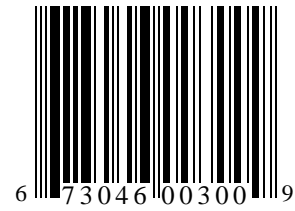
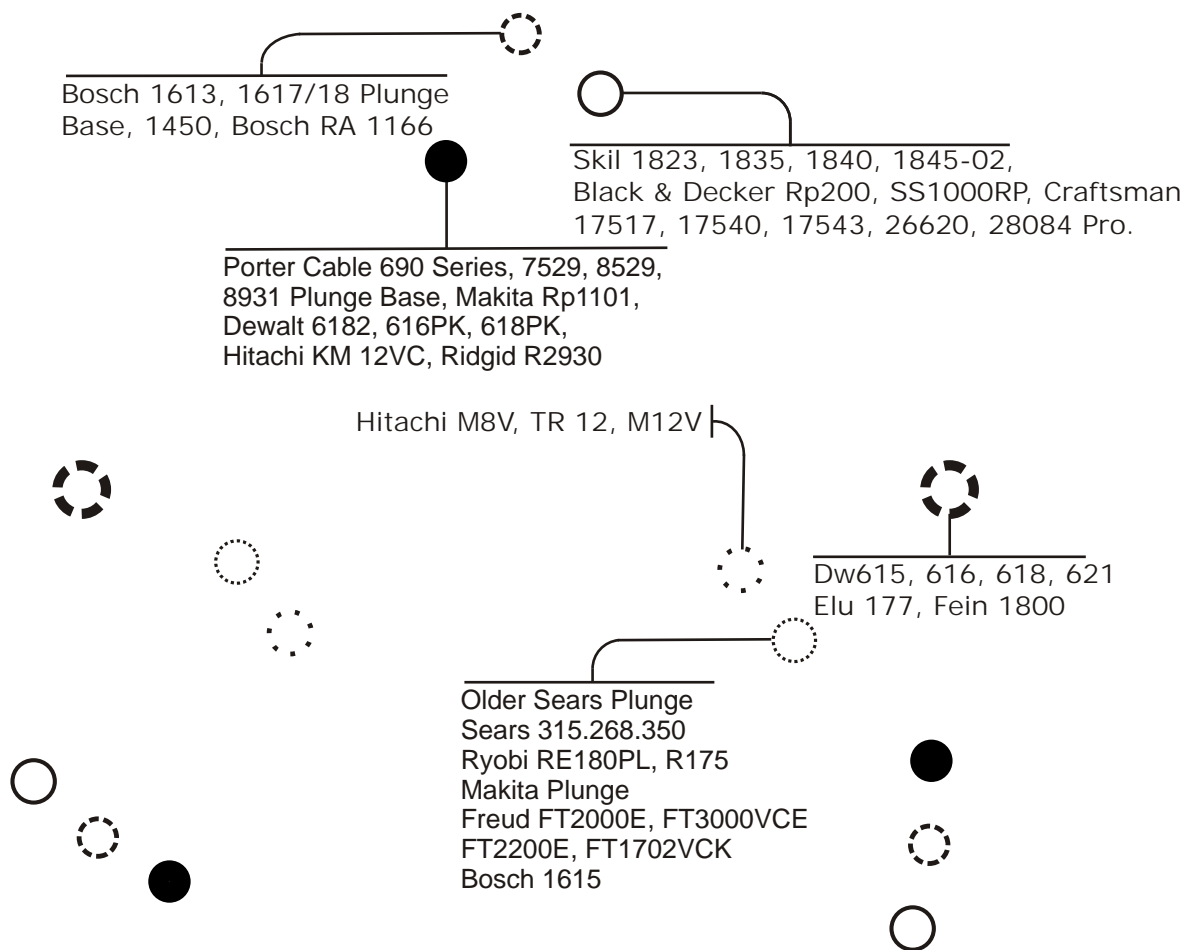




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The Circle Guide Model 300 will make 184 different size circles in 1/4 inch increments from 7 inches to 52 3/4 inches. The scale is calibrated to read direct disk diameter when a 1/2 inch router bit is used. A calibration disk is included that is used to calibrate the guide to your router.



Router Base Layout

M300 Instructions (Cont)

SAFETY: Read all precautions that came with your router. Make sure your router is unplugged while changing the bit and leave router unplugged until you complete your setup and you are ready to route your circle. Always use eye protection while routing.

MOUNTING THE GUIDE TO THE ROUTER: Place your guide on the workbench with the counterbores facing the workbench. Remove the plastic base from your router. A 1/4 inch dowel pin has been provided in the hardware tube. Install the 1/4 inch dowel pin in the collet of your router, so that 7/8 of an inch of the pin is protruding from the collet. Note that you may need to use your 1/4 inch reducer to properly install the dowel pin. A calibration disk has been pressed into the 1 3/4 inch hole that is in the guide. Leave the disk in place until you have finished mounting your router. There is a 1/4 inch hole in the disk. Plunge the router so that the dowel pin aligns into the 1/4 inch hole and lock the brake. Hold your hand on the bottom of the guide and turn your router over so that you can see the counterbores. Rotate the guide around the router base until the mounting holes line up and mount the guide with the supplied screws. Release the lock on the router and remove the disk from the guide by tapping up on the disk from the bottom with a small hammer. Replace the 1/4 inch pin with a 1/2 inch router bit. Your circle guide is now calibrated for your router.

REINSTALLING THE CALIBRATION DISK ON THE GUIDE: Save the calibration disk and 1/4 inch dowel pin for future installation. The disk should be reinstalled in the guide by tapping it into position with a small hammer. The disk should remain in the guide when the guide is not in use.

HOW TO USE THE SCALE: The guide has inches listed along the horizontal scale on the bottom edge of the pivot hole pattern, and the fractions listed vertically along the left end. To find the 12 1/2 inch pivot hole, find the 12 inch column of holes from the horizontal scale and the 1/2 inch row of holes from the vertical scale. Follow these lines to the 12 1/2 inch pivot hole and insert your pivot pin there.

MAKING CIRCULAR HOLES: The jig is calibrated to make disks using a 1/2 inch diameter router bit. To make circular holes, use a 1/2 inch router bit and subtract 1 inch from the scale.

SETUP FOR CIRCLE ROUTING

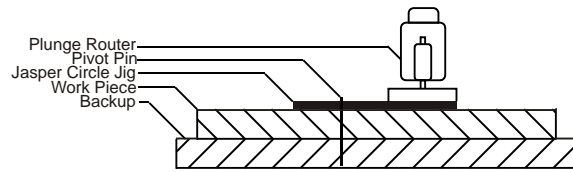


Figure 1

SETTING UP: Figure 1 shows a typical setup for cutting circular holes, mortises, or disks. The work-piece should be taped to the backup with double sided tape on both the inside and the outside of the cutout. Using a 1/8 inch diameter drill bit, drill a vertical hole through the work-piece and into the backup for the pivot pin or use a Model 350 pivot plate.

USING OTHER BIT DIAMETERS: To make a disk with a bit other than 1/2 inch diameter, select the pivot hole by using the following equation:

$$\text{Pivot Hole Value} = \text{Disk Diameter} + \text{Bit Diameter} - \frac{1}{2}$$

To make a circular hole with a bit diameter other than 1/2 inch, use the following equation:

$$\text{Pivot Hole Value} = \text{Circular Hole Diameter} - \text{Bit Diameter} - \frac{1}{2} \text{ inch}$$

USE THE GUIDE FOR METRIC DIMENSIONS

(Note: These equations calculate the Pivot hole on the Guide in Inches)

To Make a Metric Disk in MM:

$$\text{Pivot Hole on Guide (Inches)} = \frac{\text{Disk Diameter (MM)} + \text{Bit Diameter (MM)} - 12.7}{25.4}$$

To Make a Metric Cutout in MM:

$$\text{Pivot Hole on Guide (Inches)} = \frac{\text{Cutout Diameter (MM)} - \text{Bit Diameter (MM)} - 12.7}{25.4}$$



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