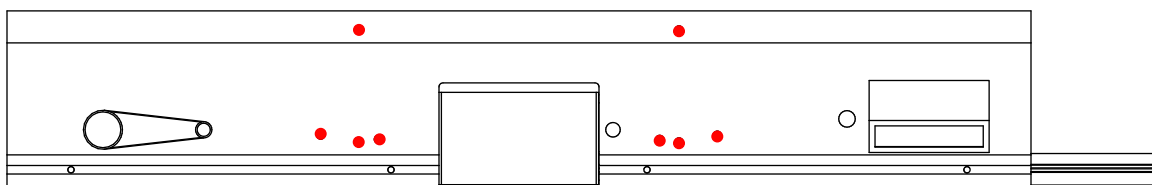


# Exploded Views and Hardware Lists

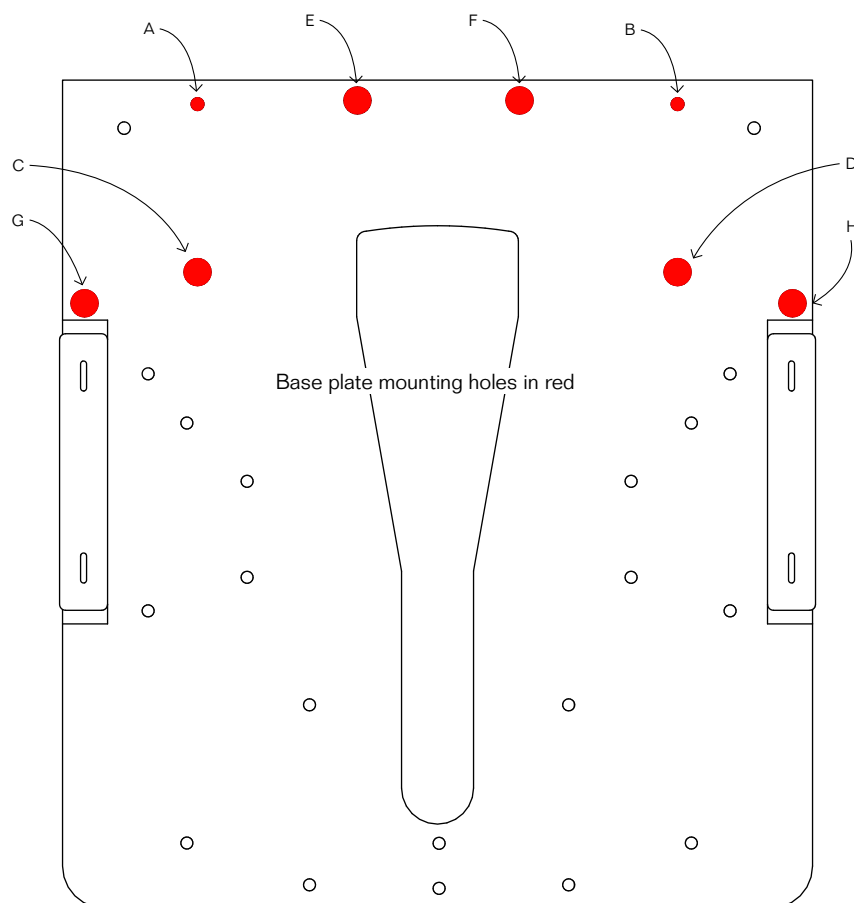


# Angle Cutting on the Router Boss

The base plate normally mounts perpendicular to the machine face. In this position the variable guides allow angled cuts at  $\pm 10^\circ$  in  $1^\circ$  increments. For greater angles you can rotate the base plate  $20^\circ$ ,  $25^\circ$  or  $45^\circ$  and also use the variable guides to adjust the cut angle up to  $55^\circ$ .

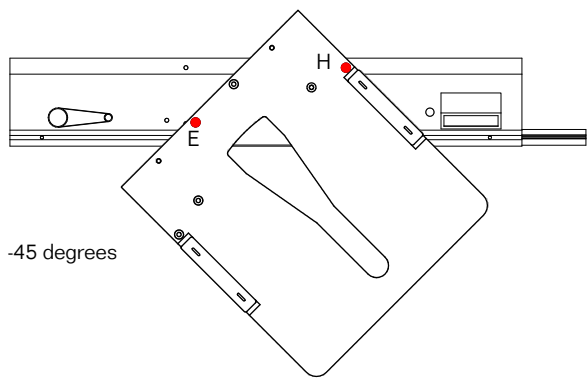
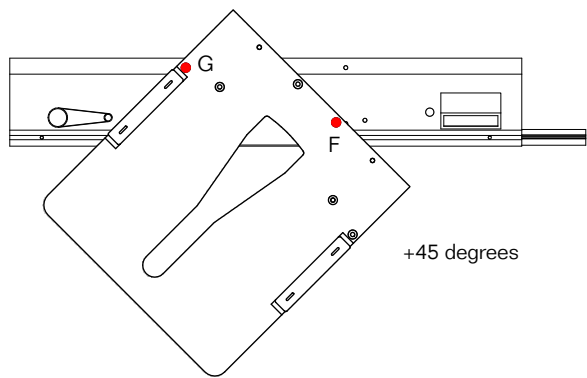
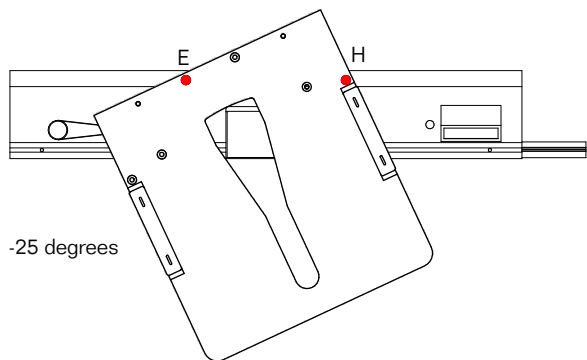
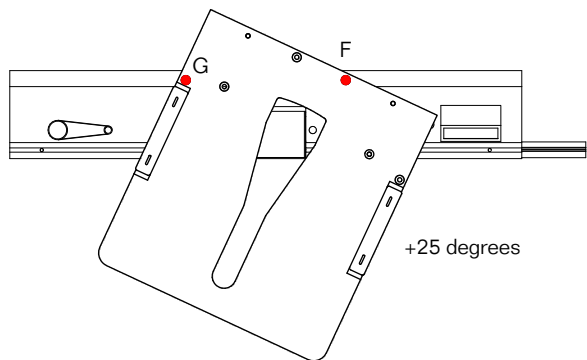
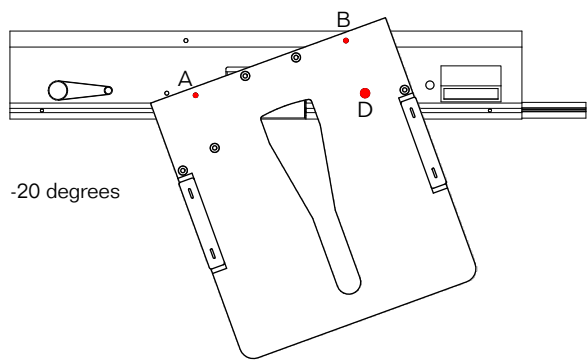
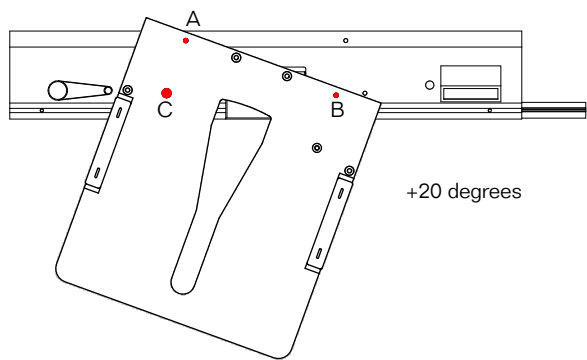
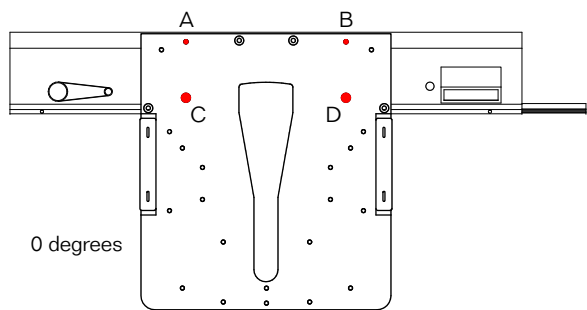


Threaded holes on box beam shown in red



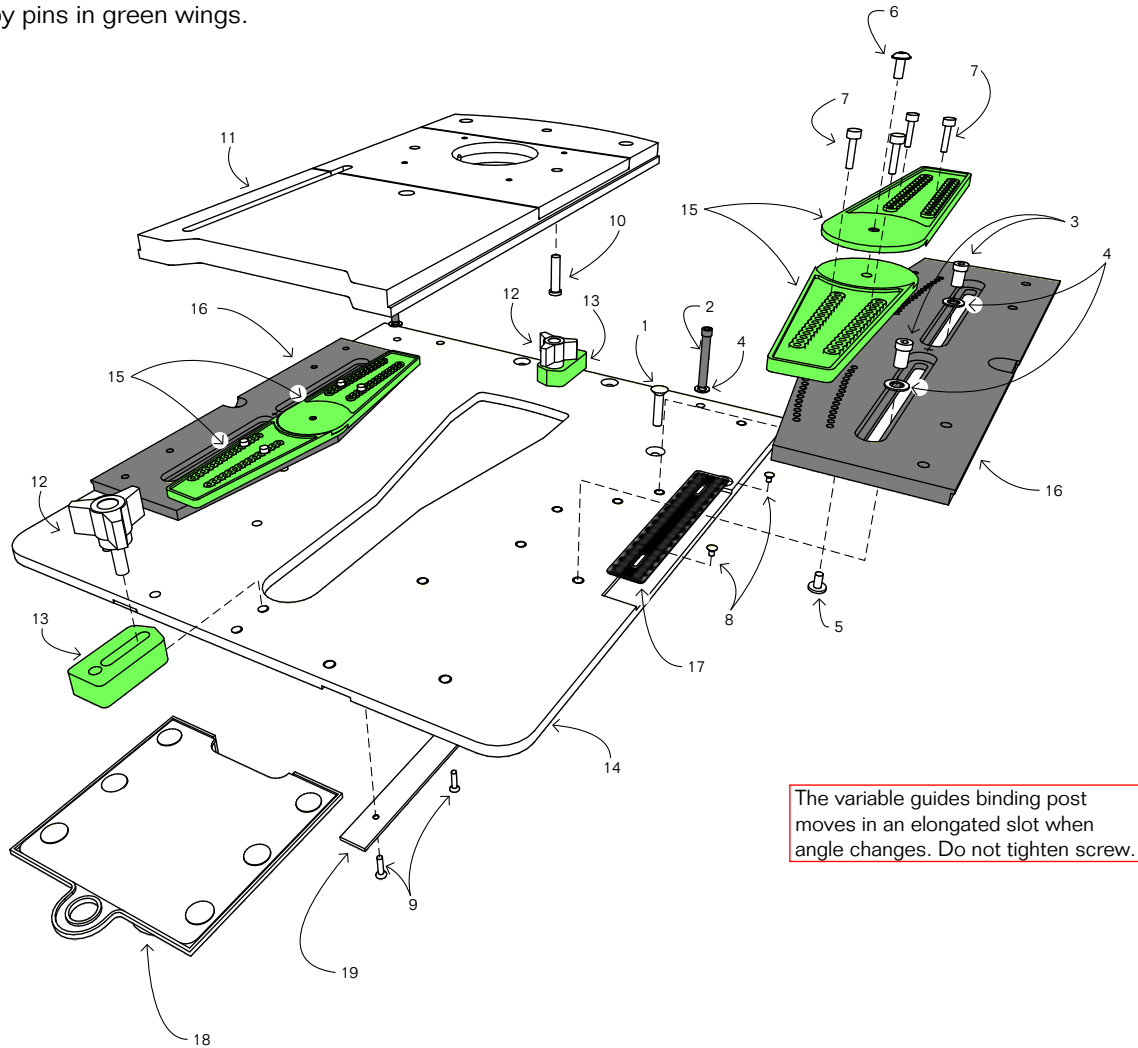
Base plate mounting holes in red

# Angle Cutting on the Router Boss



# Base Plate with Variable Angle Guides

For dovetails and joinery that requires router to be guided at an angle. Angle set by pins in green wings.



## Contents of Router Boss Guides and Base Plate Fastener Bag

No.	Qty	Description	Use
1	2	1/4-20 x 1-1/2" Flat Socket Head Screw	Screws base plate to channel-front
2	2	1/4-20 x 1" Socket Head Screw	Screws base plate & alum guides to channel-rear
3	4	1/4-20 x 3/8" Low Head Socket Screw	Screws guides to base plate (both variable & alum)
4	6	1/4" L Size .468" OD Flat Washer	Washers for no. 2, 3 & 4 socket head screws
5	2	8-32 x 3/8" Binding Post Barrel	Center post for variable guides
6	2	8-32 x 3/8" Button Head Screw	Screw for above post (snug, not tight)
7	10	1/8" Angle Stop Pin (2 extra provided)	To set/hold angle of the variable guides
8	4	4-40 x 1/4" Flat Head Socket Screw	Screws variable guide rules to base plate
9	6	6-32 x 1/4" Flat Head Socket Screw	Screws dust port metal strips under base plate
10	3	M6 x 16 Flange Button Head Screw	Screws router or transition plate to acrylic plate

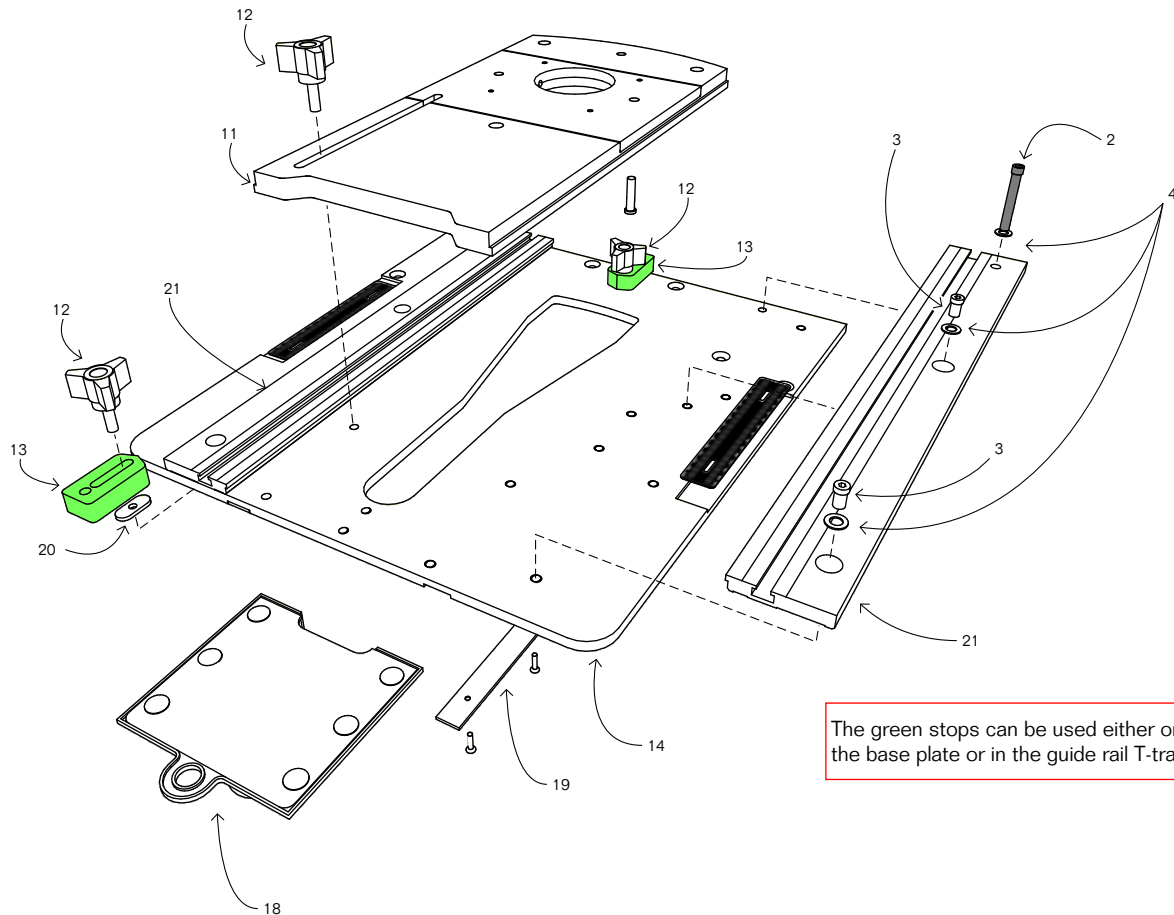
## Router Boss Parts Also Shown

11	1	Acrylic Router Plate
12	3	Star Knob with 1/4-20 3/4" stud
13	2	Green Plastic Stop
14	1	Aluminum Base Plate
15	4	Variable Guide Green Wing
16	2	Variable Guide Black Base
17	2	Variable Guide Rules (for dovetails)
18	1	Front Dust Chute with 6 Magnets
19	2	Metal Strip (to which dust chute attaches)



# Base Plate with Aluminum Guide Rails

For tenons and joinery that requires straight cuts or when the router is stationary and the wood is guided by the sliding bar.



## Fasteners Included in Router Boss Guides and Base Plate Fastener Bag

No.	Qty	Description	Use
2	2	1/4-20 x 1" Socket Head Screw	Screws base plate & alum guides to channel--rear
3	4	1/4-20 x 3/8" Low Head Socket Screw	Screws guides to base plate (both variable & alum)
4	6	1/4" L Size .468" OD Flat Washer	Washers for no. 2, 3 & 4 socket head screws

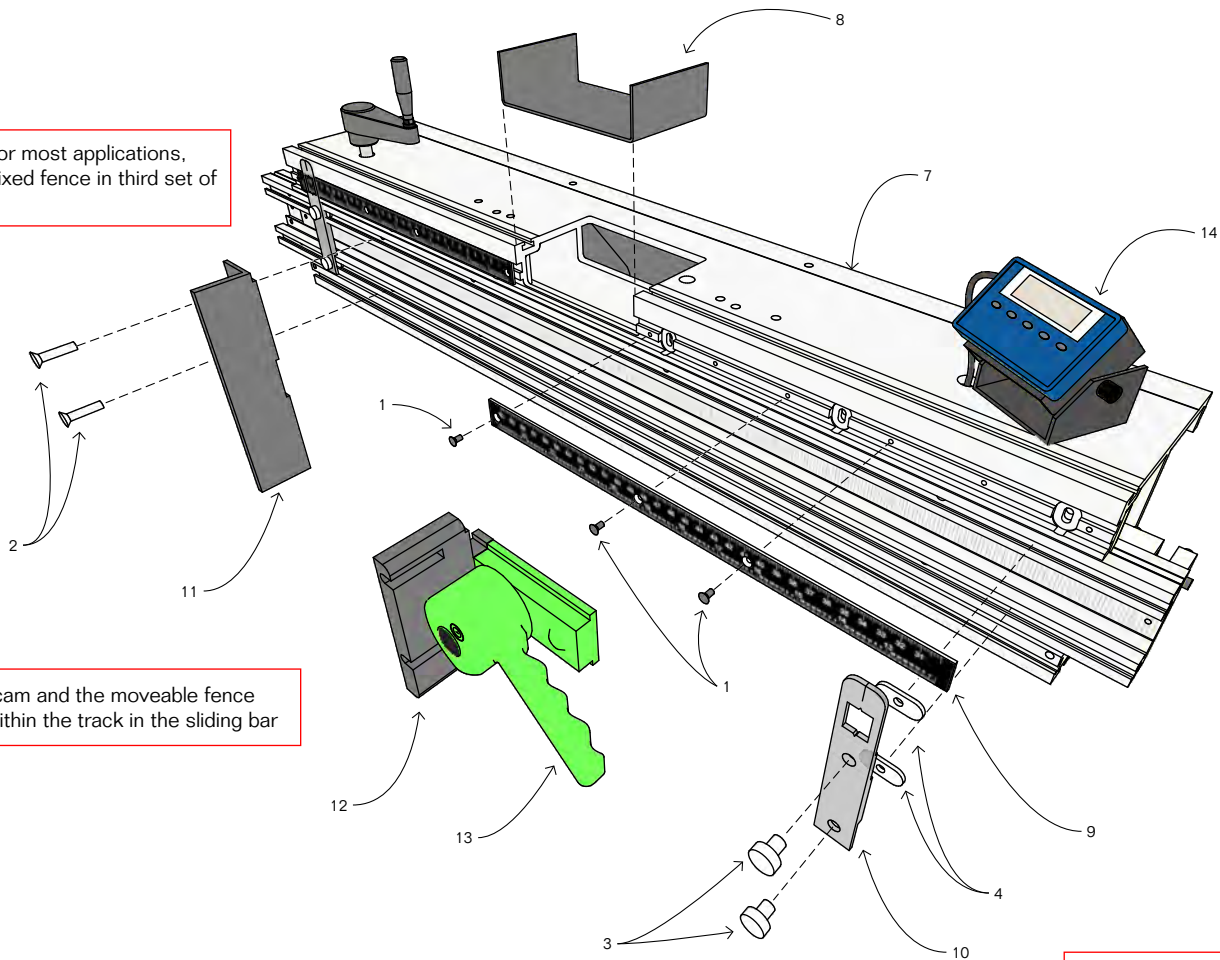
## Router Boss Parts Also Shown

11	1	Acrylic Router Plate
12	3	Star Knob with 1/4-20 3/4" stud
13	2	Green Plastic Stop
14	1	Aluminum Base Plate
18	1	Front Dust Chute with 6 Magnets
19	2	Metal Strip (to which dust chute attaches)
20	1	Oval Nut, 1/4"-20
21	2	Aluminum guide rail



# Box Beam Assembly

Note: For most applications, mount fixed fence in third set of holes.



Both the cam and the moveable fence operate within the track in the sliding bar

Note: Rules may be mounted in any of three optional locations

## Contents of Router Boss Box Beam Channel Fastener Bag

No.	Qty	Description	Use
1	6	4-40 x 1/4" Flat Head Socket Screw	Attach rules to front channel
2	2	1/4-20 x 1-1/4" Flat Socket Head Screw	Attach fixed fence to sliding bar
3	4	10-32 x 3/8" Nylon Thumb Screw	Attach cursors to sliding bar T-tracks
4	4	10-32 Oval Nut	Nut for thumb screw above
5	4	1/4-20 Oval Nut	Extras or for plastic stop when in aluminum rails
6	2	6mm Oval Nut	Extras for user jigs using t-tracks

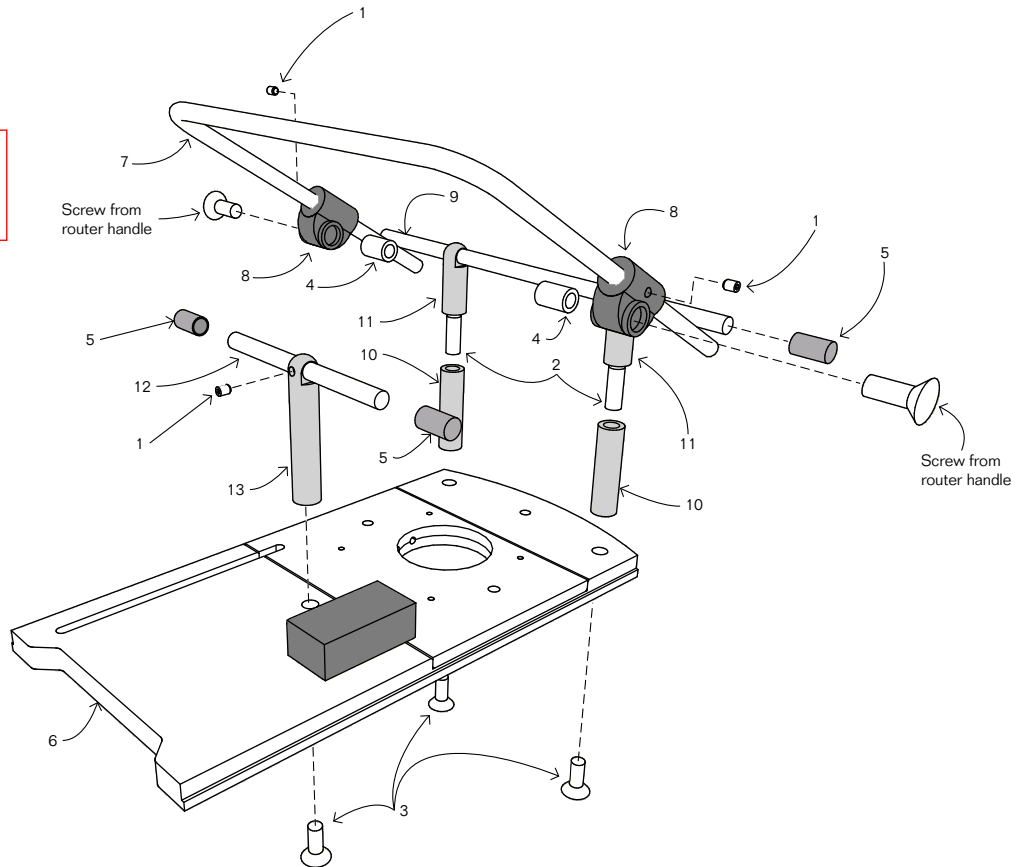
## Router Boss Parts Also Shown

7	1	Assembled Channel with Sliding Bar
8	1	Channel Dust Chute
9	2	Either Ruler or Story Board (left & right)
10	2	Gray cursor
11	1	Aluminum Fixed Fence
12	2	Moveable Fence (attaches to cam)
13	2	Push Button Cam Assembly
14	1	Digital Display & Mount (optional)



# Plunge Assist for DeWalt 625 Router

U-bar (7) inserts into plastic elbows (8) which replace router handles



## Contents of DeWalt 625 Plunge Assist Kit Fastener Bag

No.	Qty	Description	Use
1	5	10-32 x 1/4" Socket Head Set Screw	Secure rods in standoffs and elbow
2	2	3/8-16 x 1-1/4" Threaded Rod	Joins the top & bottom of rear standoff
3	3	3/8-16 x 1" Flat Socket Head Screw	Attach standoffs to acrylic router plate
4	2	5/16" Sleeve Bearing 1/2" OD, 3/4" Length	Insert into plastic elbow on DeWalt 625
5	4	3/8" Vinyl End Cap	Cover for ends of straight steel rods

## Router Boss and Plunge Assist Parts Also Shown

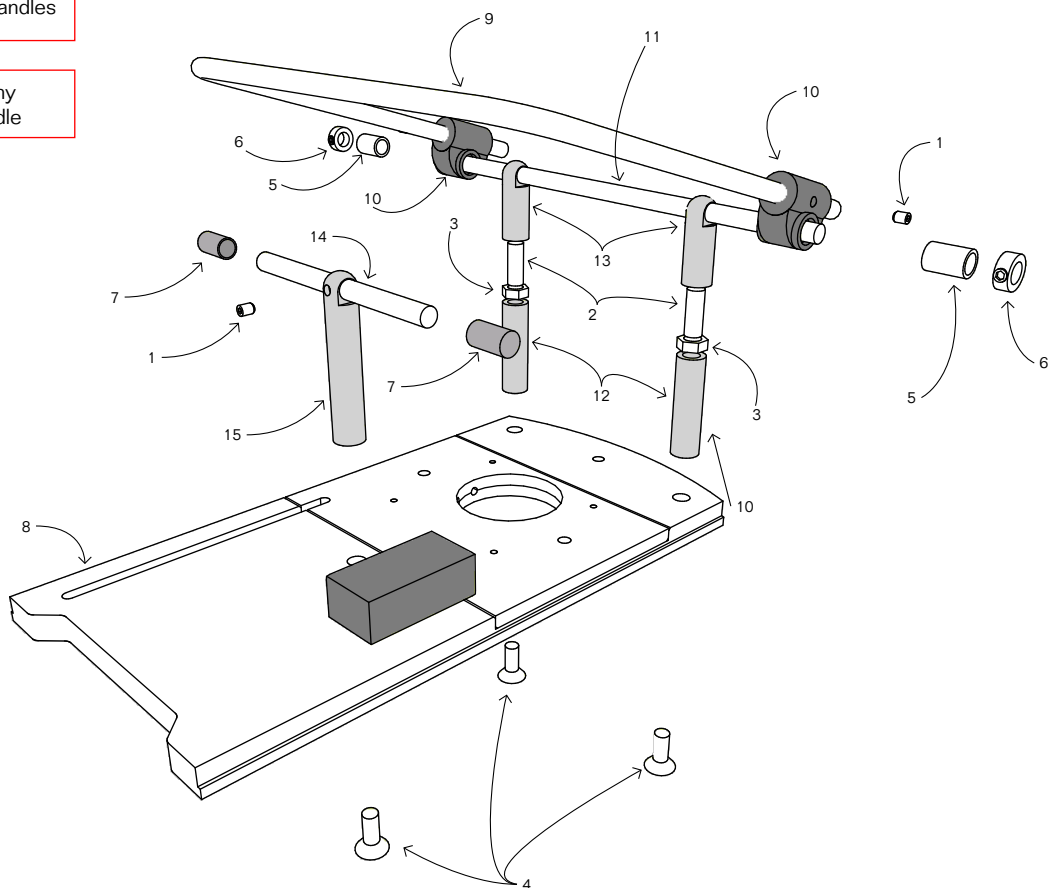
6	1	Acrylic Router Plate
7	1	10.275" Plunge U-Bar
8	2	Plastic Elbow (replaces DeWalt handle)
9	1	12" Rear Rod
10	2	Bottom-Half Rear Standoff
11	2	Top-Half Rear Standoff
12	1	5" Front Hand-Grip Rod
13	1	Front Standoff



# Universal Plunge Assist

## U-bar rides over router handles

Not for DeWalt 625 or any router with switch in handle



### Contents of Universal Plunge Assist Kit Fastener Bag

No.	Qty	Description	Use
1	5	10-32 x 1/4" Socket Head Set Screw	Secure rods in standoffs and sleeve adapter
2	2	3/8-16 x 1-1/4" Threaded Rod	Joins the top & bottom of rear standoff
3	4	3/8-16 Hex Jam Nut (optional usage)	Spacer on threaded rod to extend rear standoffs
4	3	3/8-16 x 1" Flat Socket Head Screw	Attach standoffs to acrylic router plate
5	2	3/8" Sleeve Bearing 1/2" OD, 3/4" Length	Insert in plastic elbow
6	2	3/8" Shaft Collar 3/4" OD, 3/8" Width	Positions U-bar on rear rod
7	4	Vinyl End Cap	Cover for ends of straight steel rods

### Router Boss & Plunge Assist Parts Also Shown

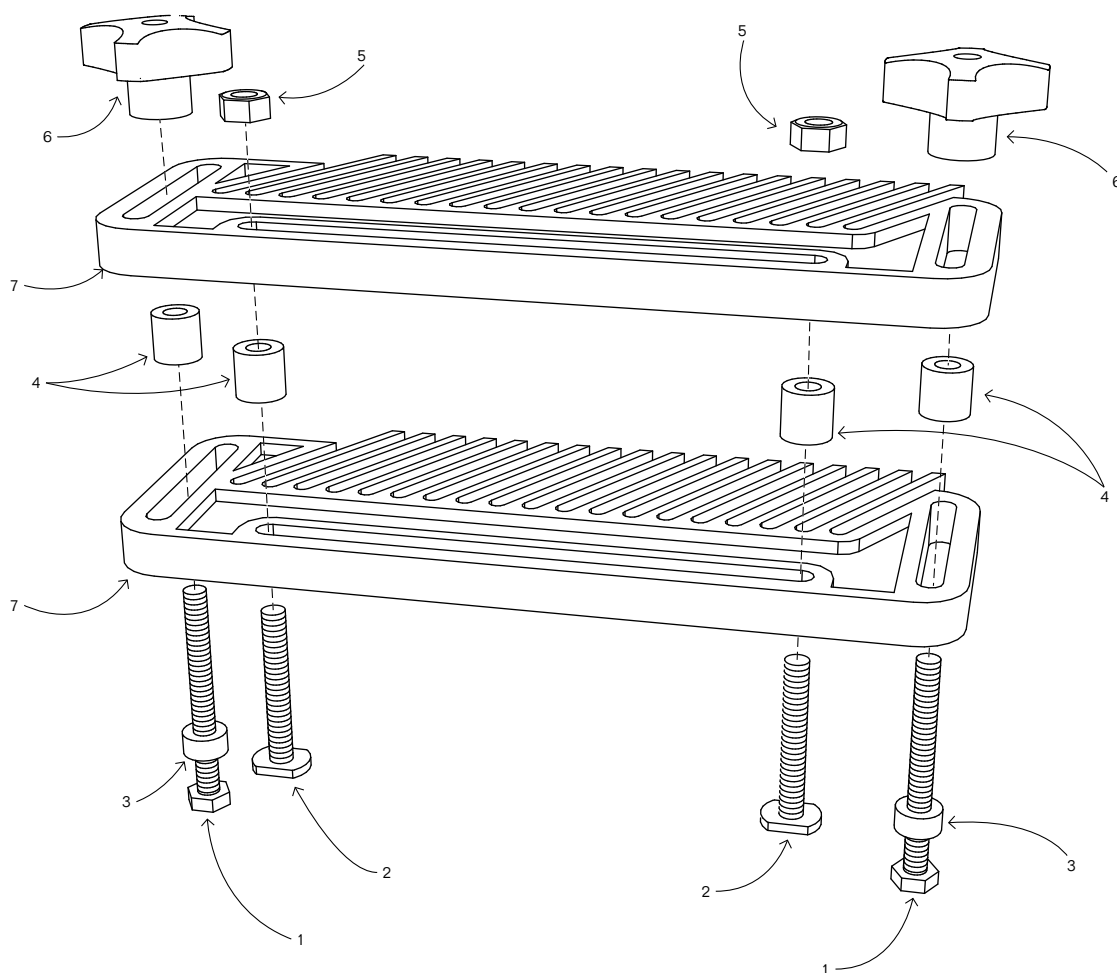
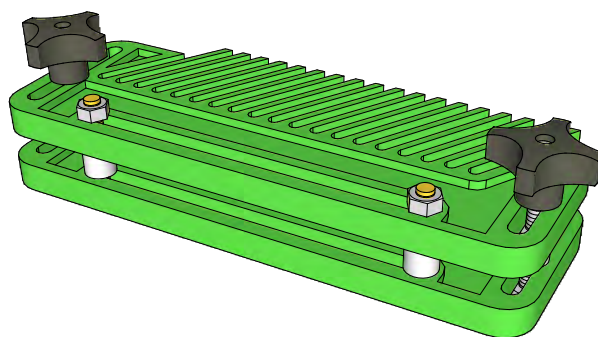
8	1	Acrylic Router Plate
9	2	Both 8" & 7.5" Plunge U-Bars
10	1	Plastic Elbow (mounts on rear rod)
11	1	12" Rear Rod
12	2	Bottom-Half Rear Standoff
13	2	Top-Half Rear Standoff
14	1	5" Front Hand-Grip Rod
15	1	Front Standoff





# Twin Feather Board

Optional feather board for support of work piece under base plate. Can be mounted on either the sliding bar or on vertically mounted T-track of mortise table.

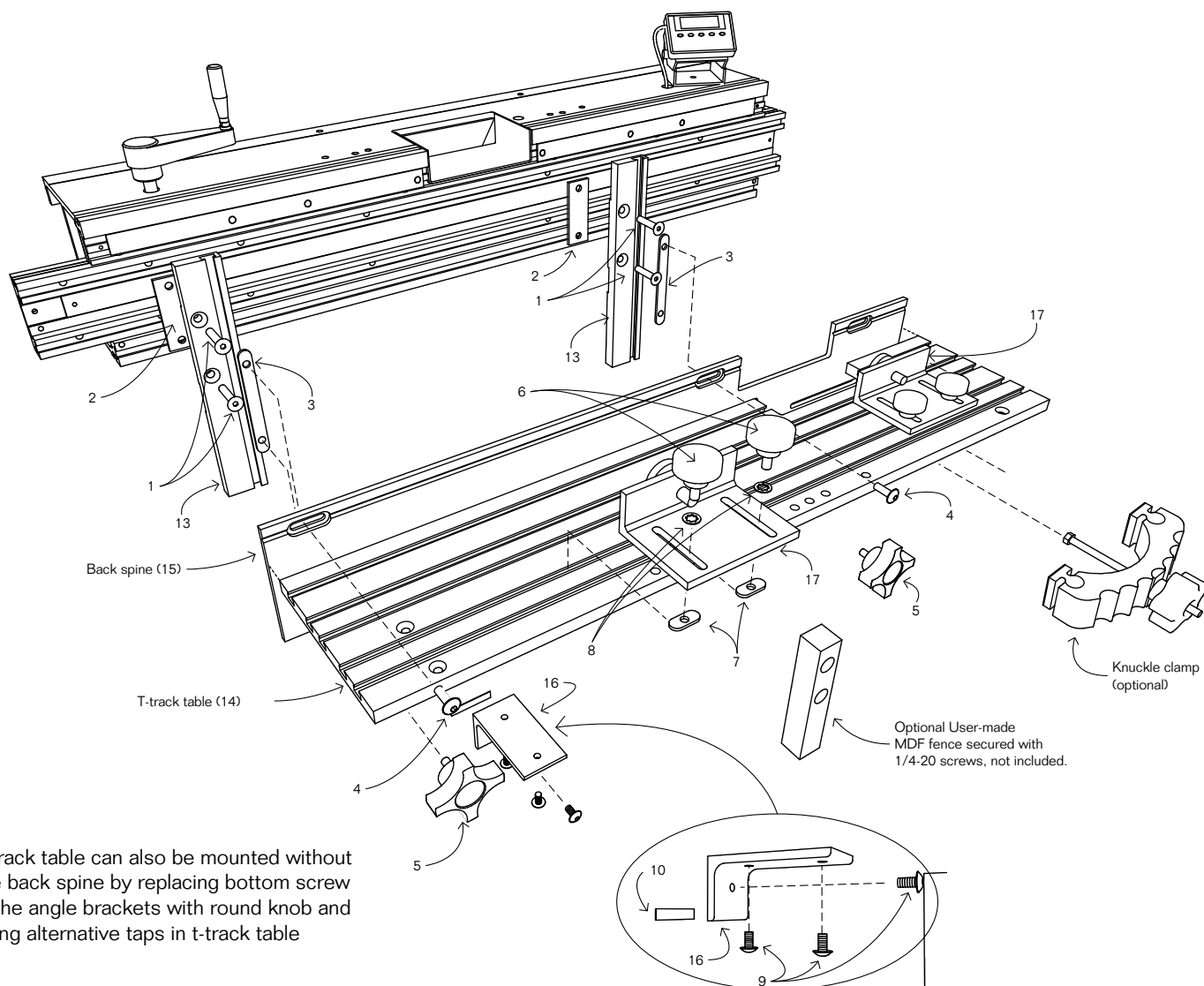


## Twin Feather Board Parts Kit

No.	Qty	Description
1	2	1/4"-20 x 2-1/2" long hex bolt
2	2	1/4"-20 x 1-3/4" long T-bolt
3	2	1/4" x 1/4" Nylon spacer
4	4	1/4" x 1/2" Nylon spacer
5	2	1/4"-20 hex nut
6	2	Knob
7	2	Feather board



# Mortise Table -- Horizontal and Vertical Work Holder



T-track table can also be mounted without the back spine by replacing bottom screw in the angle brackets with round knob and using alternative taps in t-track table

## Contents of Mortise Table Fastener Bag

No.	Qty	Description	Use
1	4	1/4-20 x 1-1/4" Flat Socket Head Screw	Screws vertical support to sliding bar and MDF fence to spine
2	4	Spacer Plates 1/8" & 1/4" Thick	Shim between vertical support and sliding bar
3	2	1/4-20 T-track Bar (Double Tap Nut)	Slides in the T-track of vertical supports
4	2	1/4-20 x 3/8" Flange Button Head Screw	Screws the top of spine to T-track bar in vertical supports
5	2	Four-Arm Knob with 1/4-20 x 1/2" Stud	Attach bottom of spine to T-track bar in vertical supports
6	4	Round Knob with 1/4-20 x 1/2" Stud	Attach vise clamps to T-track table
7	4	1/4-20 Oval Nut	Nut for vise clamp knobs (slides in T-track)
8	4	1/4" Inside Tooth Lock Washer	Lock washer for vise clamp knobs
9	12	1/4-20 x 7/16" Socket Head Screw	Screws angle brackets to spine and T-track table (pre-installed)
10	12	Plastic Shims, 4 ea. 1/32", 1/64", 1/128"	Fine tune parallelism of table to base plate
11	2	1/4-20 x 3/4" Flat Head Cap Screws	Attach fixed fence to T-track table (see next page)
12	3	Yellow Angle Locator Stop Pins	Insert into holes in Table to establish miter angle (see next page)

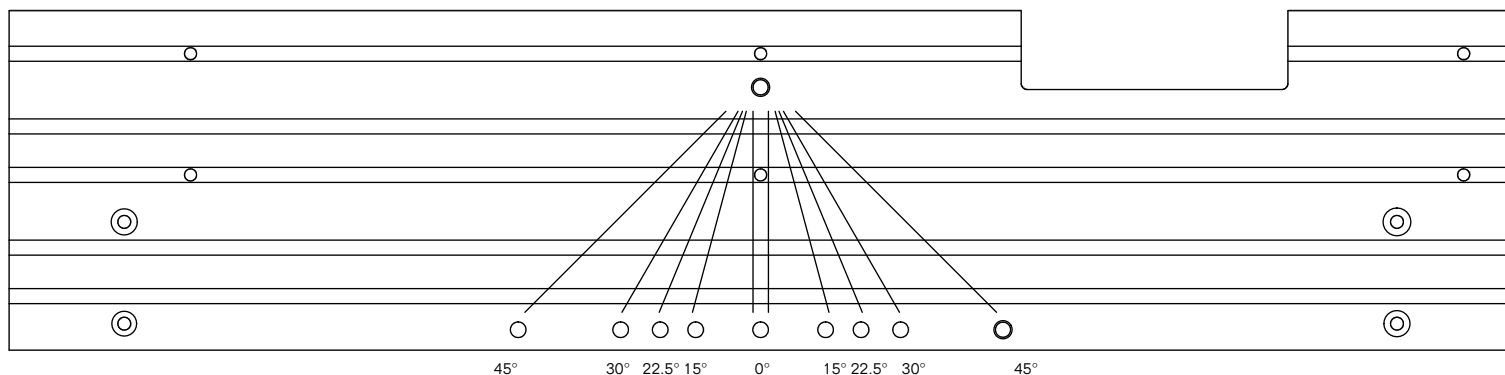
## Mortise Table Parts Also Shown

13	2	Vertical Support with T-track
14	1	31" x 7.25" T-track Table
15	1	31" x 5" Back Spine
16	4	Angle Bracket
17	2	Vise Clamp w/ adjustable pad

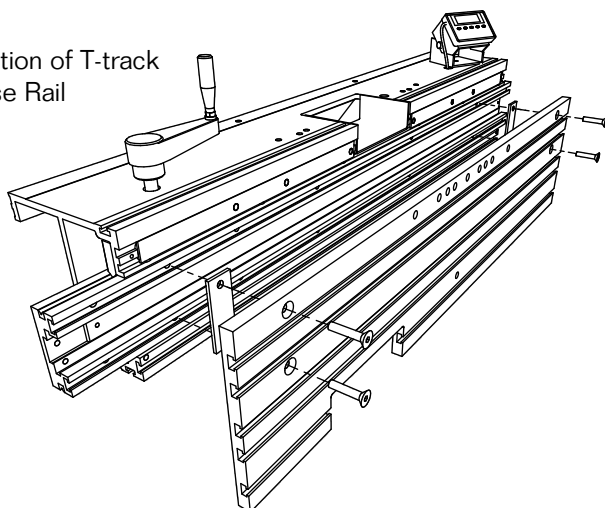


# Mortise Rail --Vertical Mounting

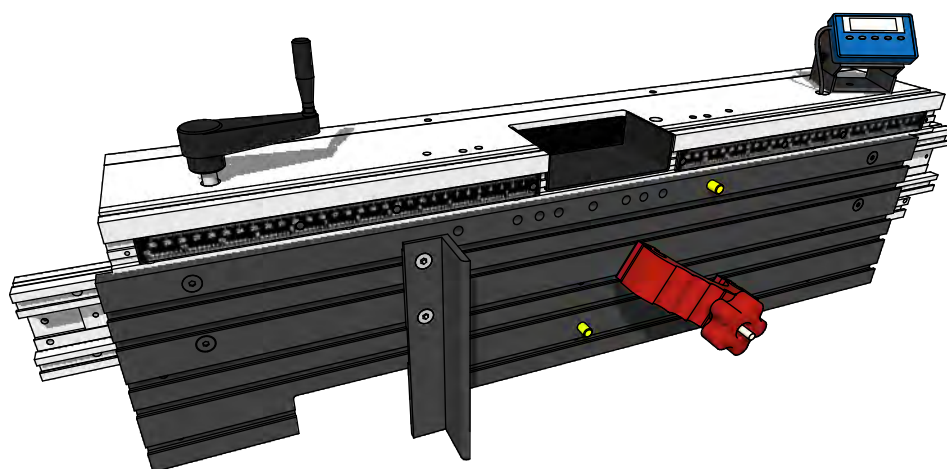
Angle settings  
Insert yellow stop pins into holes as indicated for desired angles



Alternate installation of T-track  
portion of Mortise Rail



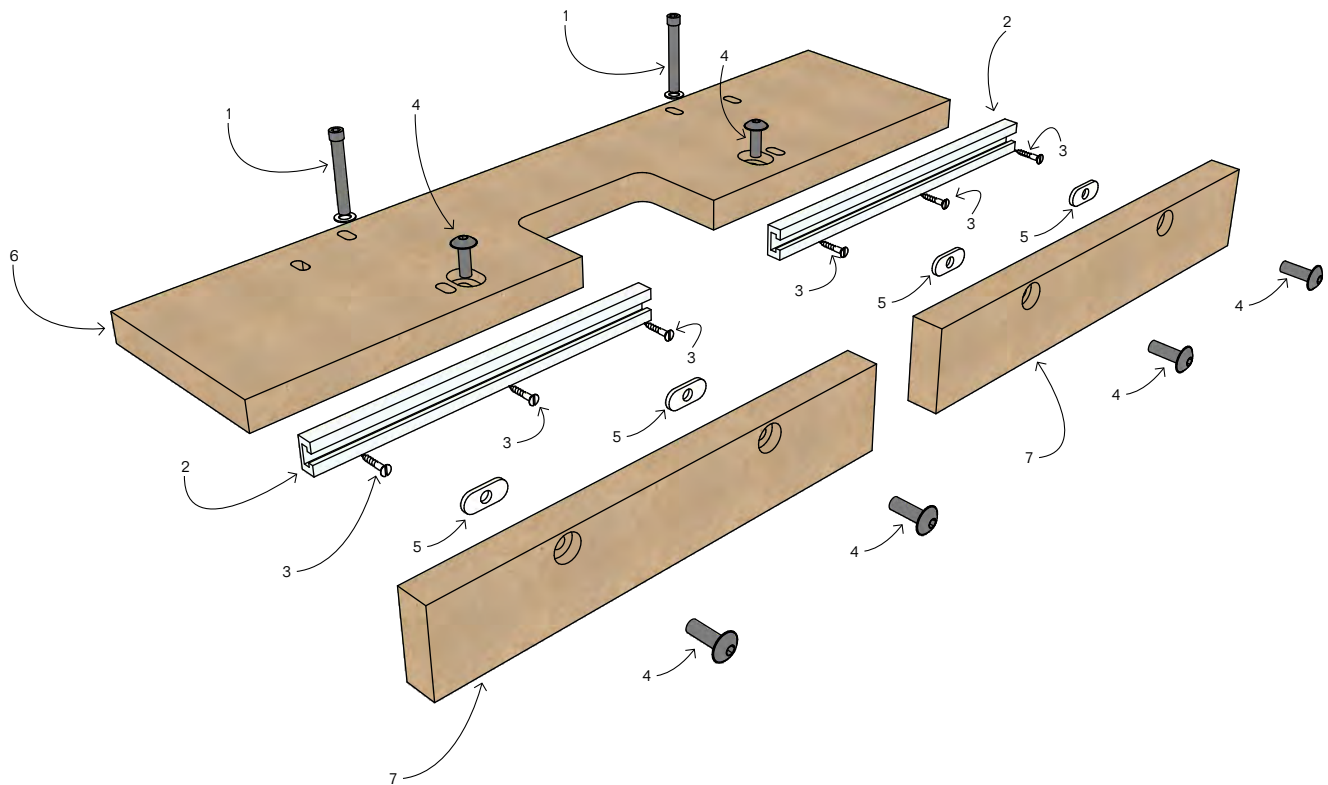
By using a fence or inserted pins, a  
work piece can be clamped either  
vertical or at left/right miter angles then  
crank feed through cutter.



Fixed fence installed

# Riser Plate with Fence - Inverted Router Table

Rests between aluminum base plate and top of box beam channel and increases maximum depth of cut when cutter is in channel dust chute



Edge profiling can be done using the feather boards to support a work piece under base plate. Close fences next to bit when edge profiling or use sacrificial fences to prevent breakout.

## Contents of Riser Plate Kit Fastener Bag

No.	Qty	Description	Use
1	2	1/4-20 x 1-3/4" Socket Head Screw	Screws to attach base plate & riser plate to channel rear
2	2	1/4-20 T-track, 9" Length, 1/2" projection	Attach T-track on front edge of riser plate
3	6	#8 x 1" Zip-R` Pan Head Screw	Screws for T-track (pre-drill the MDF)
4	6	1/4-20 x 3/4" Flanged Socket Head Screw	Screws for fence to T-track and riser plate to channel front
5	4	1/4-20 Oval Nut	Nut for flanged screw above (slides in T-track)

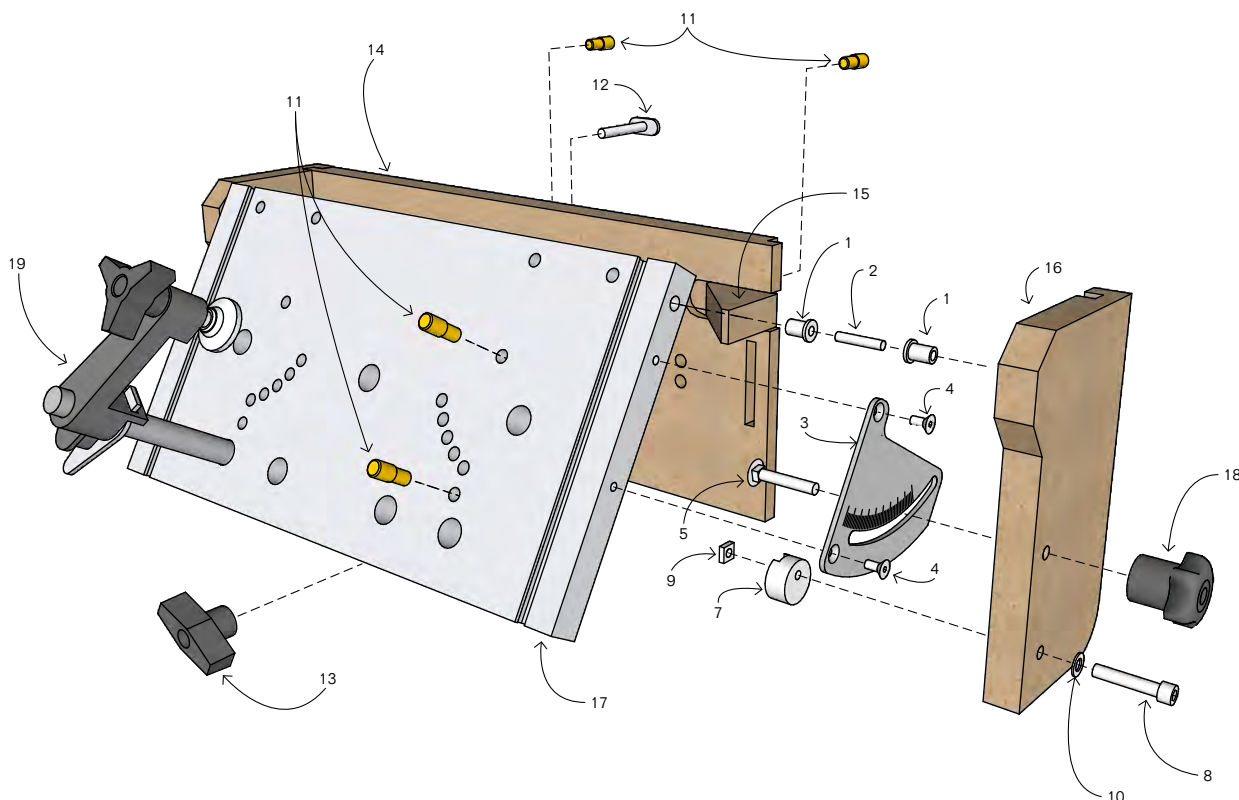
## Riser Plate Parts Also Shown

6	1	3/4" x 4.9" x 21" MDF Riser Plate
7	2	3/4" x 2" x 11" MDF Fence
8	1	Plastic Feather Board (not shown)
9	2	Star Knob with 1/4-20 3/4" Stud (not shown)
10	1	Hog Bristle Brush Feather Board (not shown)



# Multi-Angle Work Holder

For angled tenons and other joinery that requires the work piece to be held at a single or compound angle



## Contents of Router Boss Multi-Angle Work Holder Kit Fastener Bag

No.	Qty	Description	Use
1	4	Flanged Bearing for 3/16" Shaft, 5/16" OD	Insert in top edge of aluminum plate & MDF sides
2	2	3/16" Dowel Pin, 1" Length	Place inside above flanged bearings
3	2	Angle Bracket (left & right)	Attach bracket to aluminum plate sides
4	4	#8-32 x 3/8" Flat Socket Head Screw	Screws for bracket above
5	2	1/4-20 x 1-1/2" Carriage Bolt	Bolts angle bracket to MDF side with 5 arm knob
6	3	1/4" Neoprene Washer 0.75" OD, 0.048" thick	Between angle bracket & side, Between 2 arm knob & back
7	2	Slotted Cam Stop	Attach stop to inside bottom of each MDF side
8	2	10-24 x 1-1/4" Socket Head Screw	Screws for stop above
9	2	10-24 Square Nut	Nut for above screw
10	2	#10 Flat Washer 0.200" D, 0.450" OD	Washer for above screw
11	4	5/16" Yellow Angle Locator Stop Pins	Positions work holder on sliding bar & work piece on plate
12	1	1/4-20 1-3/4" T-bolt	Bolts work holder to sliding bar (safety feature)
13	1	1/4-20 Threaded Hole 2 Arm Locking Knob	Knob for T-bolt above (should be snug, but not tight)

## Multi-Angle Parts Also Shown

14	1	MDF Back
15	2	MDF Glue Blocks
16	2	MDF Side (left & right)
17	1	Aluminum Plate
18	2	5 Arm Knob with 1/4-20 threaded hole
19	1	Friction Clamp

