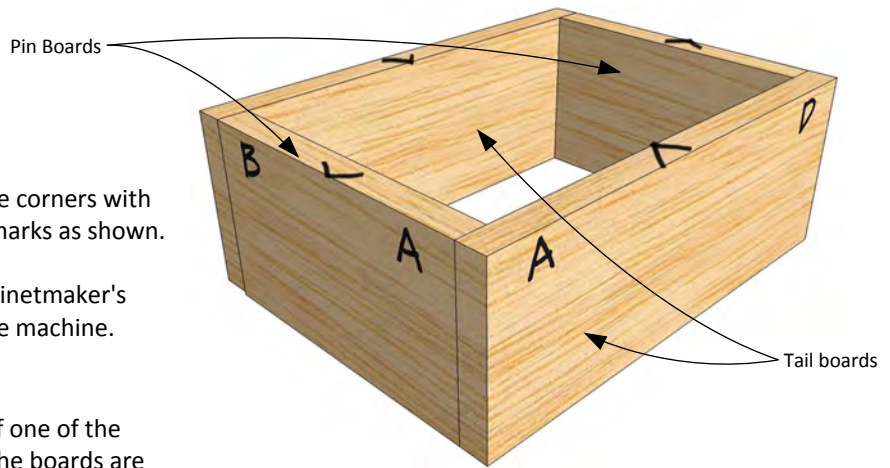


# Procedure for Cutting Dovetails for a Drawer Box



Assemble the parts for the box and mark the corners with letters and the edges with cabinetmaker's marks as shown.

Note: All our cuts will be made with the cabinetmaker's marks (>) pointing away from the face of the machine.

Layout the socket cut centers on one end of one of the tail boards (side pieces). For this example, the boards are 3 inches wide and the sockets will be located 1 inch apart.

Place this board in the machine cam clamp.

Install a centering bit in the router.

Crank the sliding bar to align the left edge of the board with the pointed end of the centering bit.

Either zero the digital read out (DRO) or setup a cursor at a convenient location and place a mark at the location on a story board.

Advance the board to each mark and record the new DRO reading or mark the storyboard. In this example we'll use the DRO. Our readings are:

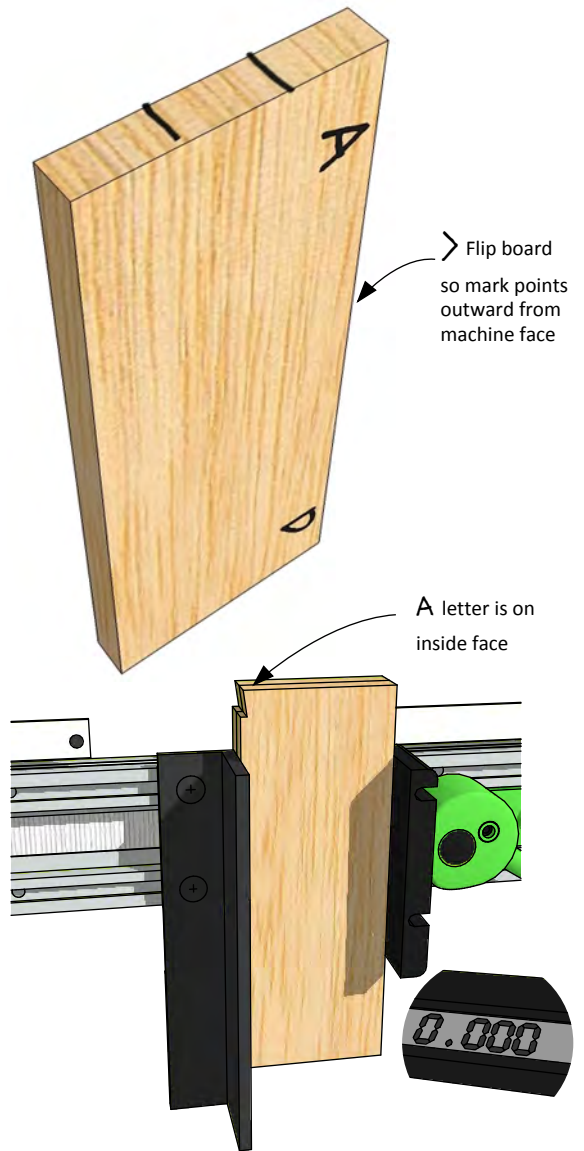
0"  
1"  
2"  
3"

Return the board to the zero position. Stack the two tailboards together with the letter marks toward machine and the cabinetmaker's mark pointing away from machine.

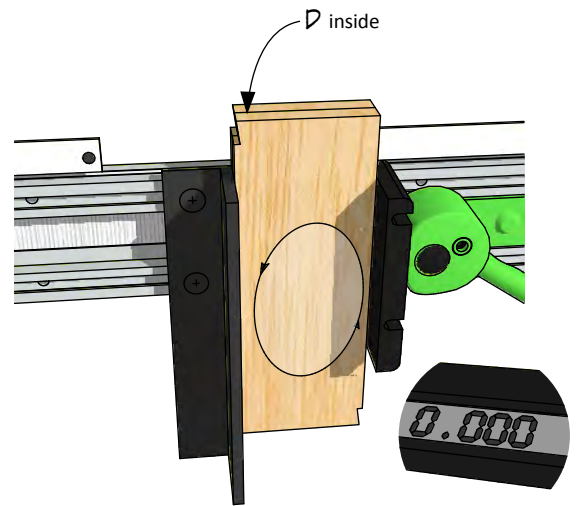
Replace the centering bit with a dovetail bit.

Set depth of cut to pin board thickness then cut a half-socket.

Note: The spacing between sockets does not need to be the same nor does it need to be symmetrical for this procedure to work properly. For example you might use a layout such as 0", 3/4", 2-1/4", 3" or even 0", 3/4", 2", 3". However, if your layout is not symmetrical the pattern will reverse on each end of the board.

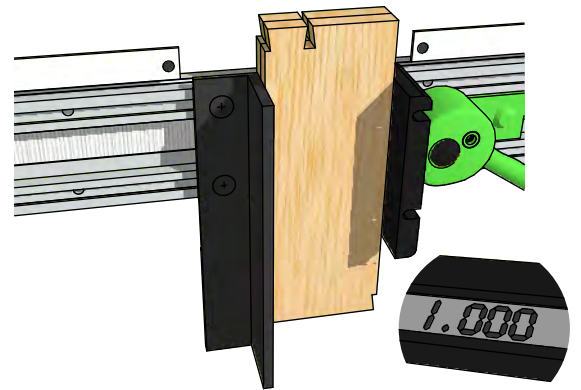


Cartwheel the board and clamp it again. Do not move the sliding bar. Cut another half-socket as shown.



Advance the sliding bar to the next recorded position.

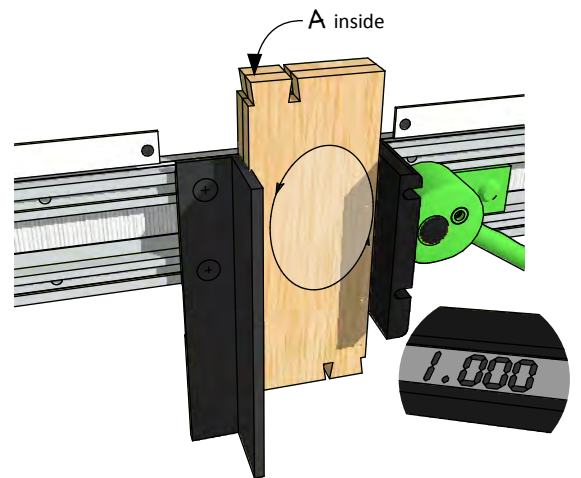
Cut the first full socket.



Cartwheel the work again and cut the same socket on the opposite board end. Do not move the sliding bar.

Continue this process until all remaining sockets are cut.

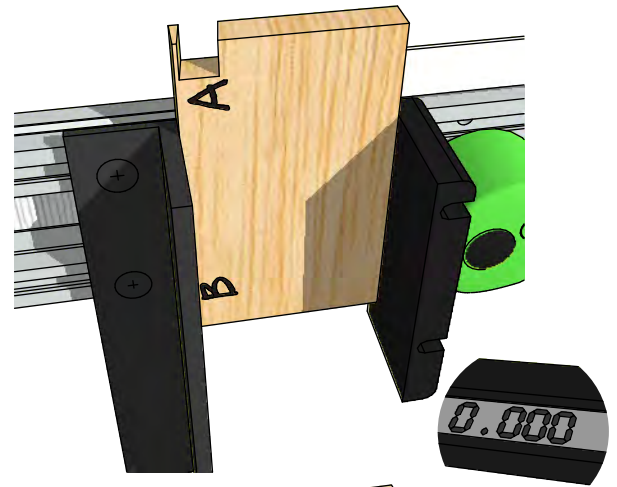
Note: It is not necessary to turn the board with each cut. You may find it quicker to cut all the sockets on one end of the board before cartwheeling the board and cutting the other end. Choose what works best for you.



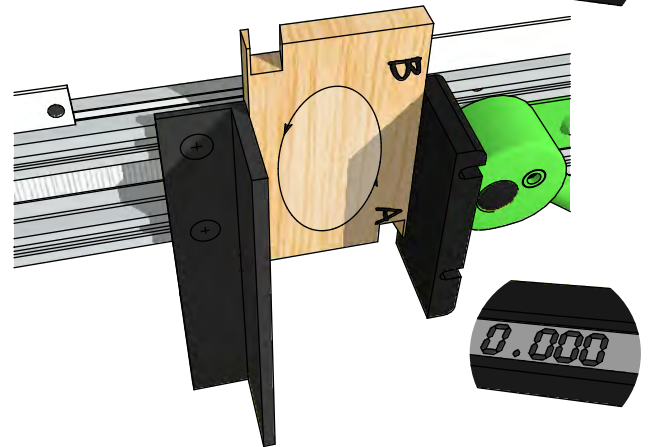
After all of the sockets are cut, return the board to the zero point. Set the guide rail wings to the dovetail angle and base plate setting. Replace the dovetail bit with a straight bit.

Place a pin board in the cam clamp with the letters and its outside face toward you. The cabinetmaker's mark (>) should be pointing away from the face of the machine.

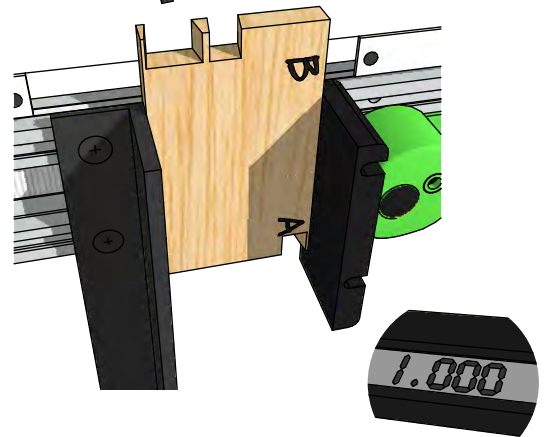
Cut the left half-pin keeping the router plate tight against the back right wing and front left wing of the guide rails.



Cartwheel the pin board and repeat the same cut. Do not move the sliding bar.



Advance the sliding bar to the next position and cut the first full pin. Right side of the pin is cut like the left half-pin then rotate router plate against opposite wings to cut left side.



Cartwheel the pin board and repeat the cut. Continue this process until the remaining pins are cut then repeat the entire process for the other pin board.

