### SAFETY GUIDELINES

- **WARNING:** This product contains one or more chemicals known to the State of California to cause cancer and birth defects or other reproductive harm. Wash hands after handling.

- Woodworking machines are dangerous, and can cause personal injury if not used properly.

- Read safety instructions and operating instructions for your machine completely, before using products. Using this system before understanding its safe and proper use could result in serious injury to the operator.

- Failure to follow these rules may result in serious personal injury.

- For your own safety, read instruction manual before operating the tool. Learn the tools application and limitations as well as the specific hazards distinctive to it.

- Keep all guards and safety devices in proper place while using these products.

- Always wear safety glasses.

- Keep hands well away from the rotating bit when operating machine.

- Avoid awkward hand positions, where a sudden slip could cause contact with the rotating bit.

- This system was designed for certain applications only. Kreg strongly recommends that this system NOT be modified and/or used for any application other than for which it was designed. If you have any questions relative to its application, DO NOT use the tool until you have written, phoned, or e-mailed Kreg Tool and have been advised accordingly.

- Be aware of kickbacks. Kickbacks occur when the workpiece binds-up while being routed, causing it to twist, jump, and possibly become airborne. To avoid kickbacks (and potential injury) always use sharp bits, keep the machine aligned and maintained properly, and adequately secure/support the workpiece.

- Turn machine off before adjusting. Never adjust the fence, plate level, reducing rings, or any other part of the tool while the machine is running.

- Wait for the machine to stop. Make sure the router comes to a complete stop before adjusting the workpiece or workpiece-angle.

- Ground electric machines. If your machine is equipped with a three-prong plug, it should be plugged into a three-hole electrical receptacle only. If the proper outlet is not available, have one installed by a qualified electrician before use. Never remove the third prong, and never modify the provided plug in any way.

- Don’t operate in a dangerous or unclean environment. Don’t use power tools in damp or wet locations, or expose them to rain. Keep work area well-lit, un-cluttered, and clean.

- Keep children and visitors away. All children and visitors should be kept a safe distance from the work area, and should not operate the tool under any condition.

- Make your workshop “child-proof”. Use padlocks, master switches, or any other means necessary to make your work area safe for children.

- Use the right tool. Never ‘force’ the tool to do work for which it was not intended. If used properly, the tool will produce better results in less time, under safer conditions.

- Wear proper apparel. No loose clothing, gloves, neckties, rings, bracelets, or any other jewelry that could possibly get caught in moving parts. Non-slip footwear is highly recommended, as is protective hair covering. Remember to always use safety glasses, specifically designed as safety wear.

- Secure the workpiece. Use clamps or a vise to hold work when it is practical and safe. Using the proper tool may allow you to free both hands for tool operation. Also, be sure to never overreach.

- Secure your tools. In the event of the machine tipping or sliding, it is always recommended to secure your tools to the machine during use.

- Keep the proper footing and balance. Ensure that you are in no danger of slipping or sliding once you turn the machine on. Once again, non-slip footwear is highly recommended.

- Maintain tools in top condition. Keep tools sharp, clean, and properly maintained for the highest quality and safest performance. Remember to properly follow all lubrication and accessory maintenance practices, as detailed in this Instruction Manual.

- Disconnect tool before servicing. When changing accessories such as bits, clamps, etc., making any sort of physical assessment of the tool, or when motor is being mounted/connected, remember to disconnect the machine from its power source. This will reduce the possibility of accidentally engaging the machine.

- Check for damaged parts. Before use of the tool, a careful assessment of all guards and other parts should be made to ensure that it will operate properly, and perform as intended. Check for alignment of moving parts, binding of moving parts, breakage of parts, mounting, and any other conditions that may affect its operation. A guard or other part that is damaged should be properly repaired or replaced as soon as possible, preceding any additional use. Do not use the tool if you are not qualified to make these sorts of assessments.

- Never leave a running machine unattended. Always turn the machine’s power “OFF” after operation. Do not leave the tool until it comes to a complete stop.

- Drugs, alcohol, medication warning. Do not operate tool while under the influence of drugs, alcohol, or any medications.
Setup

Step 1: Preparation

Place all of the parts on your workspace and make sure that each component is accounted for using the parts list on pages 6 & 7 of this instruction manual.

Step 2: Connect the Sliding Base to the Router Table

Connect the 1" T-Bolts to the bottom of the Sliding Base, slide it into your Router Table’s t-slot*. Lock down anywhere along the length of your Router Table using the T-Knobs.

* Note: If your router table doesn’t have a t-slot, you’ll have to start by installing one between 6” and 6-1/2” from the center of your insert plate.

Step 3: Attach Fence

Place the ¼” Button Head Screws through the face of the Sliding Base and barely thread on the ¼” nuts. Slide the fence onto the nuts and prop up both ends using the two Fence Spacers.
Step 4: Align Fence

Using a straight piece of scrap wood, align the left edge of the Fence to the Sliding Base. With the two aligned, you can now secure them together using the included ¼" Button Head screws and ball-end Allen wrench. Once secured, remove the Fence Spacers holding the Fence in place above the table.

Step 5: Assemble Clamp and Router Stop

Assemble the integrated clamp with the long t-bolt, spacer, ¼” washer and ¼” nut, as shown at left. Once assembled, lock the clamp into position on the left side of the fence about 1” from the edge.

Please reference the one-page instruction manual for the Precision Router Table Stop included with this kit to correctly assemble your Router Stop.
Step 6: Attach Handle

There are two ways to attach your Handle. The first method, connecting your handle directly to the sliding base, is the easiest and simplest to setup while the second method, using the included control arm, takes a bit more to setup but provides for smoother operation when routing your notches.

To connect the handle directly, start by barely threading the ¼ nut onto the handle. Then, remove the plastic cap using the ball-end allen wrench and slide the handle into position wherever it’s most comfortable. To secure, firmly rotate the handle clockwise to tighten, then reinstall the plastic cap.

To utilize the control arm, you’ll need to follow the assembly diagram on page 6 and 7, paying close attention to the positioning of the washers. With everything in place, barely thread on the ¼" nuts, remove the plastic caps as necessary, and slide the two pivot points into position as shown.

The stationary pivot point of the stationary block should be locked down roughly 1" from the end of the sliding base, while the movable pivot point should be positioned and secured about 2-1/2” from the end of the sliding base. When correctly assembled, the handle should be able to fully extend without coming in contact with the fence, providing the full range of movement allowed by the sliding base. When complete, reinstall the plastic caps.
Router Table Stop:
See Included Manual

Sliding Base
# Fence Hardware / Parts

<table>
<thead>
<tr>
<th>#</th>
<th>Description</th>
<th>Part #</th>
<th>Quantity</th>
</tr>
</thead>
<tbody>
<tr>
<td>A</td>
<td>Handle</td>
<td>FT4029</td>
<td>1</td>
</tr>
<tr>
<td>B</td>
<td>1/4” Setup Bar</td>
<td>RT10303</td>
<td>1</td>
</tr>
<tr>
<td>C</td>
<td>Beaded Face-Frame Fence</td>
<td>RT12001</td>
<td>1</td>
</tr>
<tr>
<td>D</td>
<td>1/4” x 1-1/2” Notching Bit</td>
<td>RT12008</td>
<td>1</td>
</tr>
<tr>
<td>E</td>
<td>1/4” Standard Beading Bit</td>
<td>RT12009</td>
<td>1</td>
</tr>
<tr>
<td>F</td>
<td>Integrated Clamp</td>
<td>RT12014</td>
<td>1</td>
</tr>
<tr>
<td>G</td>
<td>Control Arm</td>
<td>RT12036</td>
<td>1</td>
</tr>
</tbody>
</table>

## Lever Hardware Pack

<table>
<thead>
<tr>
<th>#</th>
<th>Description</th>
<th>Part #</th>
<th>Quantity</th>
</tr>
</thead>
<tbody>
<tr>
<td>H</td>
<td>1/4” Hex Nut</td>
<td>DK1510</td>
<td>2</td>
</tr>
<tr>
<td>I</td>
<td>1/4” Washer</td>
<td>RT10161</td>
<td>4</td>
</tr>
<tr>
<td>J</td>
<td>5/16” Washer</td>
<td>RT12032</td>
<td>4</td>
</tr>
<tr>
<td>K</td>
<td>Brass Bearing</td>
<td>RT12033</td>
<td>1</td>
</tr>
<tr>
<td>L</td>
<td>Nylon Washer</td>
<td>RT12034</td>
<td>4</td>
</tr>
<tr>
<td>M</td>
<td>Shoulder Bolt</td>
<td>RT12035</td>
<td>2</td>
</tr>
</tbody>
</table>

## Hardware Pack

<table>
<thead>
<tr>
<th>#</th>
<th>Description</th>
<th>Part #</th>
<th>Quantity</th>
</tr>
</thead>
<tbody>
<tr>
<td>N</td>
<td>Fence Spacer</td>
<td>DK1301</td>
<td>2</td>
</tr>
<tr>
<td>O</td>
<td>Brass Washer</td>
<td>DK1504</td>
<td>1</td>
</tr>
<tr>
<td>P</td>
<td>1/4” Hex Nut</td>
<td>DK1510</td>
<td>5</td>
</tr>
<tr>
<td>Q</td>
<td>1” T-Bolt</td>
<td>FT4243</td>
<td>2</td>
</tr>
<tr>
<td>R</td>
<td>2-1/2” T-Bolt</td>
<td>FT4247</td>
<td>1</td>
</tr>
<tr>
<td>S</td>
<td>T-Knob</td>
<td>RT10178</td>
<td>2</td>
</tr>
<tr>
<td>T</td>
<td>1/2” Dowel Pin</td>
<td>RT12010</td>
<td>1</td>
</tr>
<tr>
<td>U</td>
<td>Button Head Screw</td>
<td>RT12012</td>
<td>4</td>
</tr>
<tr>
<td>V</td>
<td>Clamp Spacer</td>
<td>RT12016</td>
<td>1</td>
</tr>
<tr>
<td>W</td>
<td>Ball End Allen Wrench</td>
<td>RT12024</td>
<td>1</td>
</tr>
</tbody>
</table>
Centering the Fence

Begin by installing the $\frac{1}{2}”$ Dowel Pin in your router. Then, set your Router Stop to exactly $\frac{1}{4}”$. With the t-slot knobs still loosened, carefully slide the entire assembly until the stop approaches the edge of the dowel pin and just “kisses” the edge. Don’t press too hard. The stop should still be able to swing freely when in place. Once in position, apply forward pressure to the assembly with your thumbs to prevent movement and lock the knobs down firmly. If you’ve done this step properly, your router bit should be precisely centered with the fence opening.

Notching Bit Setup

Remove the dowel pin and replace it with the included $\frac{1}{4}”$ Notching Bit. Lock the bit into place in your router, and set the height precisely using the included $\frac{1}{4}”$ Setup Bar. Be very careful with this step as the height of the bit must be exact. With the bit set appropriately, use a scrap piece of stock, secure it to the fence using the Integrated Clamp, and make a test cut in the middle of the workpiece. Use the top side of the setup bar to test the depth of the cut once complete. If your cut is too deep, you’ll need to lower the bit. If the setup bar teeters, you’ll need to raise the bit slightly. Again, precision is incredibly important here. Do not take shortcuts and make sure the depth is exact.

Notching the Stiles

For this step, we’ll be following “example 1” in your instruction manual which features two frame openings and 1-1/2” rails. We’ll also be cutting both stiles at once to reduce the possibility for tear-out and to ensure that both stiles are cut exactly the same.

Lay your two stiles in front of you and place a small 'V' to signify which side will be visible when the project is assembled. Sandwich the “V’s” together, ensure the pieces are aligned correctly, and use masking tape to secure the two together.

For the first two cuts, we’ll be creating the notches for the top and bottom rails. This will require two passes through the cutter. First, position your stop at the 0” marking and lock it into place. Gently press the workpiece against the stop and secure it with the integrated clamp. Engage the router and slowly press the handle forward until the cut has been completed. Disengage the router and wait for it to come to a complete stop. Then, release the clamp and rotate the workpiece 180°. Lock the clamp, reengage the router, and repeat the same cut on the opposite end.

With the second pass complete, set your stop at the $\frac{3}{4}”$ marking and lock it into place. We’re using $\frac{3}{4}”$ because it represents the center of the 1-1/2” workpiece. Press the workpiece against the stop, secure it with the clamp and make the second pass on both ends.

To find the center notch location, start with $\frac{3}{4}”$ for the first stile and add 5” for the drawer bank opening. Secure your Router Stop in place at 7-1/4”.
**Notching the Rails**

Secure your Router Stop at ½” on the left side of the bit. Gently rest the workpiece against the stop and clamp down firmly. Make the cut and then flip the workpiece to repeat. On the center rails, you’ll be making the same cut to all four corners. On the outer rails, you’ll just be trimming the inner corners.

After all of the rails have been machined, dry-fit the pieces and make any adjustments as necessary.

**Routing the Bead**

Remove the ¼” notching bit, insert the ⅛” beading bit, and replace the Precision Beaded Face-Frame Fence with your standard router fence. Next, carefully set the height of the bit by using the included setup bar. The top of the cutter, below the bearing, should be just touching the bottom of the setup bar.

Lock the bit into place, bring the bit up to speed, and run each workpiece through as desired. The center rails will get both sides machined, while the stiles and upper and lower rails will only have a bead on one side. Again, dry-fit the workpieces to ensure a proper fit. If everything is as it should be, assemble the frame using Kreg Joinery™. Any of our popular Kreg Jigs or our high-speed production machines designed for woodworking professionals will work perfectly.
Example #1

Basic 24”x15” face-frame. 1-1/2” stiles and rails, 5” drawer bank opening and 14-1/2” door opening.

STILES

- First cut at 0” to trim away end material. Repeat on both ends.
- Second cut at ¾” marking, indicating center of top and bottom rails. Repeat on both ends.
- Third cut at 7-1/4” marking, indicating center of middle rail.

Rails

- Set your stop at ½” on the left side of the bit.
- Trim all 4 corners of the center rail and the inside 2 corners of the top and bottom rails.

Example #2

Basic 24”x15” face-frame. 2” rails, 1-1/2” stiles. 5” drawer bank opening and 13” door opening.

STILES

- First cut at 0” to trim away end material. Repeat on both ends.
- Second cut at 3/4”. Repeat on both ends.
- Third cut at 1-1/4” marking. Repeat on both ends.
- Fourth cut at 7-3/4” marking, to cut the top half of the middle rail.
- Fifth cut at 8-1/4” marking, to cut the bottom half of the middle rail.
- By purchasing a ⅛”x2” Notching Bit in addition to the ¼”x1-1/2” Notching Bit included with this product, you can use it to reduce the number of cuts required.

Rails

- Set your stop at ½” on the left side of the bit.
- Trim all 4 corners of the center rail and the inside 2 corners of the top and bottom rails.
Example #3

24”x15” three-drawer-bank face frame. 1-1/2” stiles and rails. 3 – 6” drawer bank openings.

STILES

- First cut at 0” to trim away end material. Repeat on both ends.
- Second cut at ¾” marking, indicating center of top and bottom rails. Repeat on both ends.
- Third cut at 8-1/4” marking, indicating center of the two middle rails. Repeat on both ends.

Rails

- Set your stop at ½” on the left side of the bit.
- Trim all 4 corners of the 2 middle rails and the inside 2 corners of the top and bottom rails.

Example #4

Basic 24”x15” face-frame. 1-1/2” top and middle rails, 3” bottom rail, 1-1/2” stiles. 5” drawer bank opening and 13” door opening.

STILES

- First cut at 0” to trim away end material. Repeat on both ends.
- Second cut at ¾” marking, indicating center of top rail. Repeat on both ends.
- Third cut at 1-1/2” marking, on the bottom of the stile only.
- Fourth cut at 2-1/4” marking, on the bottom of the stile only.
- Fifth cut at 7-1/4” marking, indicating center of the middle rail.
- By purchasing a larger Notching Bit in addition to the ¼”x1-1/2” Notching Bit included with this product, you can use it to reduce the number of cuts required.

Rails

- Set your stop at ½” on the left side of the bit.
- Trim all 4 corners of the middle rail and the inside 2 corners of the top and bottom rails.
**Accessories**

**Precision Router Bits**
These specialized bits were specifically designed for use with the Kreg Precision Beaded Face-Frame System. Each bit features a high quality ½” shank construction along with high-grade carbide tips for extreme durability. We currently offer 6 beautifully unique beading bits to match your distinctive project and 4 standard notching bits depending on your rail widths and bead of choice.

**Precision Set-up Bars**
These innovative setup bars feature three unique ways to ensure your projects get the precision they truly deserve. Whether you’re setting your blade depth, positioning your fence, or double-checking your cuts, these precise aluminum bars do it all!

**Precision Router Table Lift**
This heavy-duty lift includes several unique features which work together to bring true speed and convenience to your router table top. Features like the Quick-Lift and tool-less micro adjustment wheel allow you to make fast bit changes and precise depth adjustments on-the-fly. If you’re ready to start working quickly and conveniently, look no further.

**Precision Router Table Stop**
Bring more precision and repeatability to your Precision Router Table with this uniquely designed stop. Features a low-profile aluminum design uniquely made to flip out of the way when not in use. Also includes our exclusive Precision Lens Cursor giving you a clear, accurate, and precise view of the fence’s tape.

**Multi-Purpose Router Table Switch**
Add safety and convenience to your Precision Router Table with this incredibly handy power switch. Features a 2-Plug design which allows it to control two independent devices at once, Key-Lok™ which eliminates accidental power-on, and a long 8ft. heavy-duty 14 gauge power cord.

**Heavy-Duty Casters**
Add true mobility to your Universal Steel Stand with our Heavy-Duty Casters. Built to last and perform, these casters feature a dual-locking mechanism that won’t roll OR pivot once engaged, resulting in an extremely stable work station. Includes all necessary hardware.