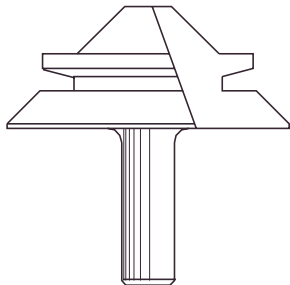


45° LOCK MITER 45° LOCK MITER 45° LOCK MITER

OPERATING INSTRUCTIONS



Thank you for purchasing the enclosed 45° Lock Miter Router Bit from Amana Tool.

This is a high quality industrial cutting tool that will give years of superior performance provided that the router bit is properly maintained.

We suggest using only a high quality heavy-duty router and router table. Please refer to your power tools owners manual for further information.

As with all power tools, wear proper eye protection and unplug router before changing tooling.

Tool No. 55391 is designed for 3/8" through 1/2" material

Tool No. 55389 is designed for 3/8" through 5/8" material

Tool No. 55390 is designed for 1/2" through 7/8" material

If you have any questions, please call the Amana Technical Hotline @ 800-445-0077.

HOW TO ADJUST AMANA'S 45° LOCK MITER

STEP 1:

Insert and properly tighten LOCK MITER BIT in the collet of router table. At least 1" to 1-1/4" of the shank must be in collet for safe operation. Make sure router is set at 10,000/11,000 RPM.

STEP 2:

Elevate Router up or down until the centerline of cutter aligns with centerline of stock (stock should be laid flat on table).

STEP 3:

Set fence back from leading edge of bit an equal distance to the stock thickness.

STEP 4:

Perform test cut to make sure bit is set up evenly. A good way to ensure that the cut is centered is to measure each 45° plane. If each 45° plane is the exact same length, then the cutter is properly centered (see drawing).

STEP 5:

With stock cut to size, cut side A (Material is cut horizontally).

STEP 6:

With stock cut to size, cut side B (Material is cut vertically).

