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CUTTING TOOLS

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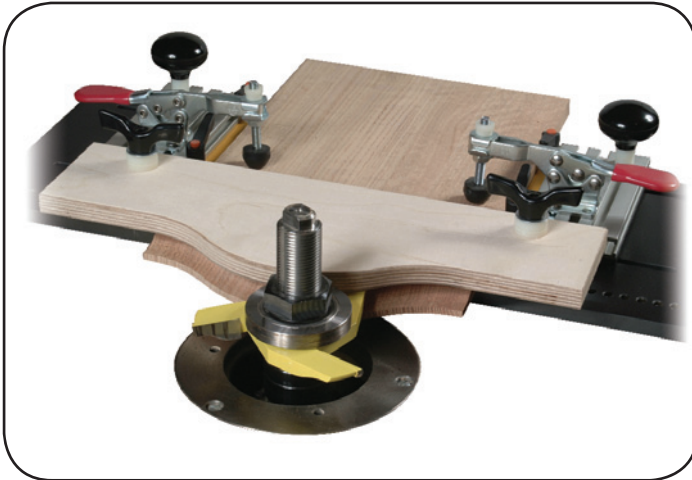
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HD Panel Master, For HD Panel Templates Use With Router Or Shaper *Item: HDPM-001*

Additional Hardware:

Parts listed below are not shown in the hardware drawings. Refer to photos in the instructions:

Part	Desc.	Qty.
5432B	Base	1
5432S	5-7/8" One Track	2
5432T	6-3/4" Ultra Track Fence	2
6305	Toggle Clamps	2



Part#	Description	Qty.
MP375	3/8" Screw	4

Part#	Description	Qty.
MF006	5/8" screw	4

Part#	Description	Qty.
BUSH004	5/8" Spacer	2

Part#	Description	Qty.
5525	Knob	2

Part#	Description	Qty.
HB030	1" Bolt	2

Part#	Description	Qty.
5765B	Oval Nut	8

Part#	Description	Qty.
BUSH1125	1/8" Spacer	8

Part#	Description	Qty.
5560	Knob	2

Part#	Description	Qty.
HB040	1-1/4" Bolt	4

Part#	Description	Qty.
5760B	Oval Nut	4

Part#	Description	Qty.
BUSH1250	1/4" Spacer	8

Part#	Description	Qty.
5590	Knob	2

Part#	Description	Qty.
HB060	3" Bolt	2

Part#	Description	Qty.
WS002	Washer	4

Part#	Description	Qty.
WFN002	1" Washer	4

BEFORE BEGINNING

Identify and verify that you have all the parts listed. The HD Panel Master was designed to be used with Woodhaven HD Door Templates with the hardware included. It can also be used with our Standard Door Templates by purchasing the 5431 Hardware Kit. It can be used on a shaper or a router table using the HD Door Templates and on a router table only using the Standard Door Templates. You'll need a #3 Phillips screwdriver and a 7/16" wrench for assembly. Read the instructions carefully at least once before beginning.

ASSEMBLY

Install a 5/8" screw (**MF006**) thru the countersunk holes in each of the 5-7/8" One Tracks (**5432S**) and start an oval nut (**5765B - smooth side first**) on the end of each screw. There are two holes in each of the 6-3/4" Ultra Track Fences (**5432T**). One hole is 3/4" from the end of the Fence and the other hole is 1-1/2" from the opposite end of the Fence. Place the long edges of the two Fences against each other so the holes are closest to and across from each other to insure you have mirror images of the two Fences after assembly. At the end of each Fence, where the hole is 1-1/2" from the end, install a One Track. Insert the two oval nuts on the One Track in the T-slots of the Fence, butt the long edge of the One Track against the end of the Fence, check it for square and tighten the screws. *See fig. 1 & 2*

Install a washer (**WS002**) on each of the 1-1/4" bolts (**HB040**). Place the 6-3/4" Ultra Track Fence (**5432T**) on the Base (**5432B**) with two holes in each Fence aligned with the two slots in the Base and the One Tracks butted against the rear edge of the Base. The two holes in the Fences should face towards the center of the Base. Insert the 1-1/4" bolts thru the holes in the Fence/slots in Base and, from the underside of the Base, start an oval nut (**5760B - smooth side first**), on the end each bolt. Position the Fences about 12" apart for now and snug the bolts. *See fig. 2*

Insert two 3/8" screws (**MP375**) thru the two front holes of each Toggle Clamp (**6305**) and start an oval nut (**5765B - raised side first**) on the end of each screw. Slide one Toggle Clamp on to each Fence, with the oval nuts engaged in the center T-slot. Position the Toggle Clamps where desired and tighten the screws. For quicker spindle adjustments, replace the top nut on the spindle with the thumb nut (**5525**). *See fig. 3*

Insert a 5/8" spacer (**BUSH004**) on the two 1" bolts (**HB030**) and start a knob (**5590**) on the end of each bolt. Slide the bolt head into a T-slot of the fence, positioning the knob where desired for best control, and tighten. *See fig. 4*

1 Track Assemblies

5432S

5432T

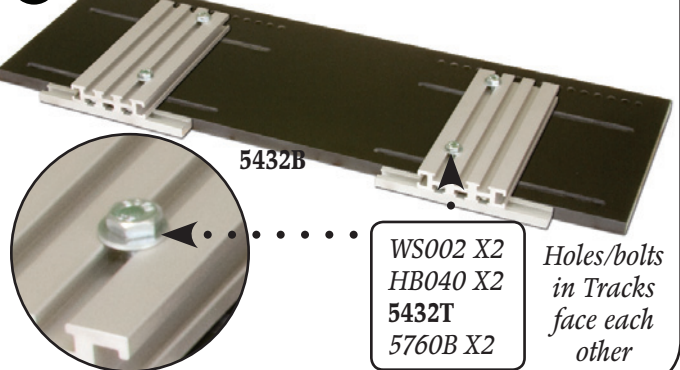
MF006 X2

5432S

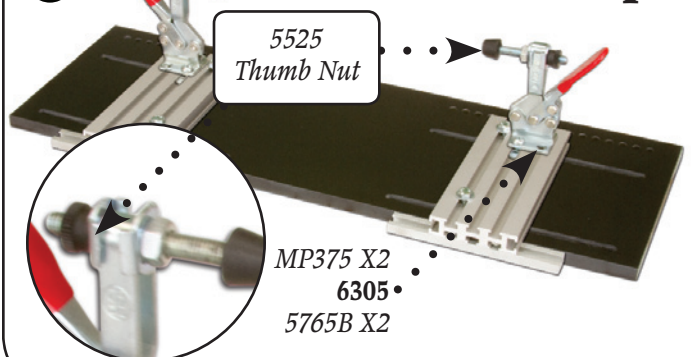
5765B X2

5432T

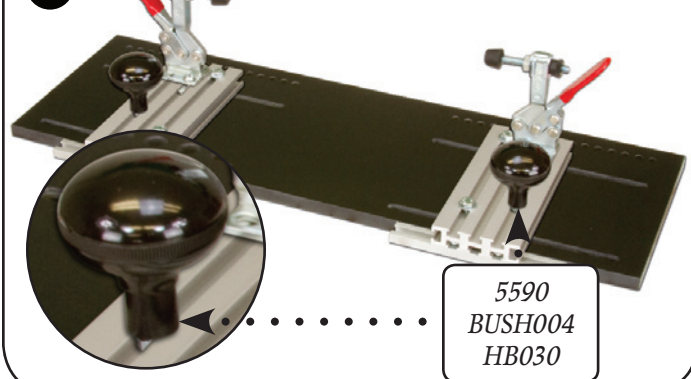
2 Attach Tracks to Base



3 Install Clamps



4 Install Handles



SETUP THE HD PANEL MASTER

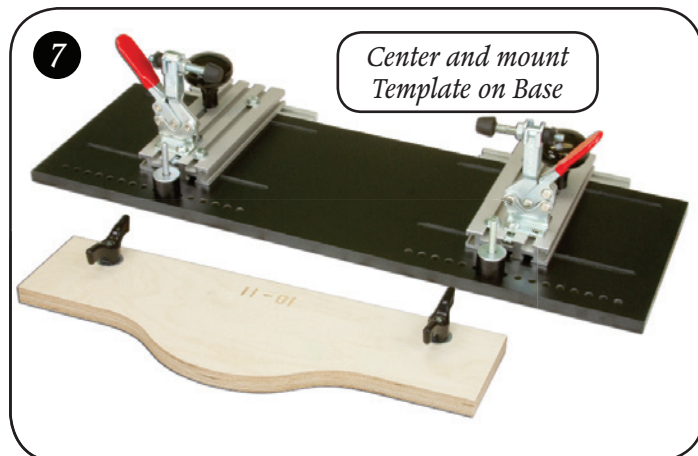
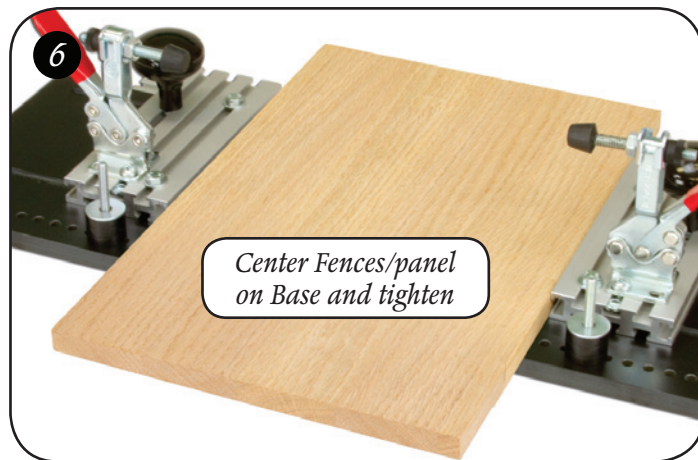
Insert the panel between the Fences on the Base of the HD Panel Master. Slide the Fences up against each side of the panel and center the Fences/panel side-to-side on the Base, keeping the One Track of each Fence against the edge of the Base to insure the panel is square to the Base. Tighten the Fence bolts using a 7/16" wrench. *See fig. 6*

Select the panel template you wish to use from the HD Door Template set. Center the template side-to-side on the Base, using the center notch on the edge of the template as a reference. Select the holes in the Base that line up with the holes in the template. Install two 3" bolts (**HB060**) thru the recessed slot in the bottom of the base and thru the holes in the Base that line up with the holes in the template. *See fig. 7*

Place three 1/4" spacers on each bolt. *The number of spacers may need adjustment depending on your shaper cutter configuration.* Place a 1" washer (**WFN002**) on each bolt/spacer stack. Install the template on the bolts and another 1" washer on each bolt, on top of the template. Place a knob (**5560**) on each bolt and tighten. *See fig. 8*

The height of the spacer stack on each bolt should be more than the thickness of the panel and it should also place the template at the optimum height for your shaper cutter bearing to ride firmly on the edge of the template. Adjust the number of 1/4" and 1/8" spacers as necessary to achieve the best template height. Make sure the shaper cutter will not hit the template.

Slide the panel blank (*one end should be finished cut square*) in the Panel Master, between the Fences, Base and template. Position the uncut end of the panel at the desired finished length, using the high point of the template as a reference. Trace the outline of the template on the panel blank, remove the panel and rough cut it to shape, staying 1/8" or less from the line. *See fig. 8 & 9*



FLUSH TRIM PANEL TO SHAPE

Clamp the panel blank in the HD Panel Master, hold the handles and flush trim the panel to shape using a flush trim cutter on your router or shaper. The bearing of the flush trim bit will follow the panel template and cut the panel to its finished shape. You can use the HD Panel Master to hold the panel for the raised panel cut on the panel end just shaped (*see below*). After making the raised panel cut, the panel tongue will fit into the groove in the mating rail. *See fig. 10*

RAISED PANEL CUT WITH A ROUTER

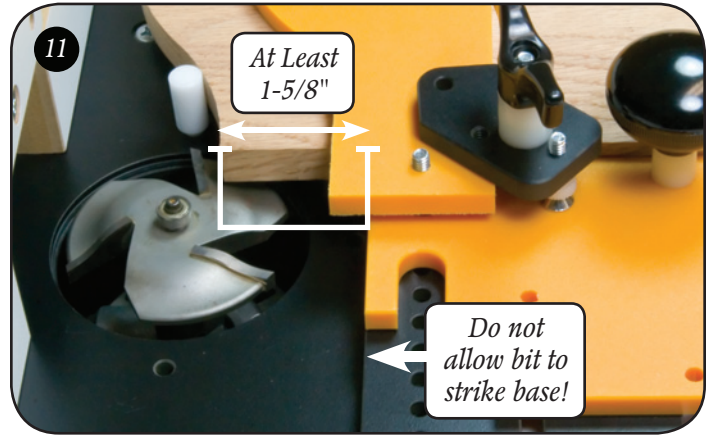
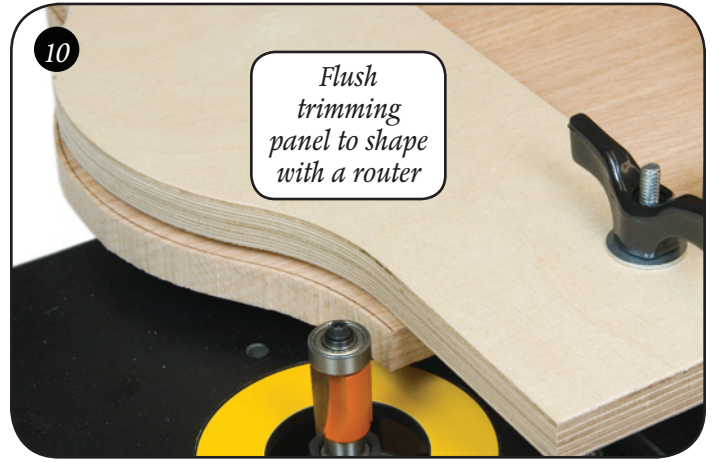
The door template can be removed since the bearing on the panel bit will follow the edge of the panel, not the template. Make sure you have at least 1" of the bit shank in the router. If extra bit height is needed to cut the full profile depth, you may need to use a router lift or collet extension. You'll need to make sure the panel sticks out past the Base at least 1-5/8" to prevent the raised panel bit from cutting into the Base. Clamp the panel in the HD Panel Master with the toggle clamps, hold the handles and make incremental passes to machine the raised panel profile on the panel. *See fig. 11*

RAISED PANEL CUT WITH A SHAPER

If possible (*depends on raised panel cutter & bearing set up*), keep the HD Door Template on the HD Panel Master when machining the raised panel profile. The templates are extra long so the bearing can make contact with the template before the cutter makes contact with the panel. This provides greater control and increases the margin of safety.

The height of the spacer stacks under the template should place the template at the optimum height for your shaper cutter bearing to ride firmly on the edge of the template. Adjust the number of 1/4" and 1/8" spacers as necessary to achieve the best template height. Make sure the shaper cutter will not hit the template.

Make sure the template is in line with the raised panel cutter bearing. Clamp the panel in the HD Panel Master with the toggle clamps, hold the handles and make incremental passes to machine the raised panel profile on the panel. *See fig. 12*



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