



Instructions - #55-502 & #55-503 Lock Miter Bits

SAFETY

The Lock Miter Junior Bit is designed for use with a table-mounted router only, at a maximum of 18,000 rpm.

Always unplug the router before changing or working around the router bit.

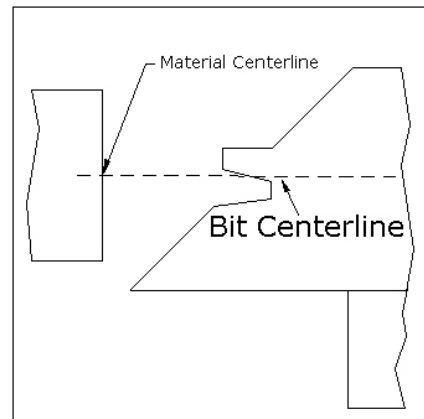
Always use push sticks and other appropriate safety devices to keep your hands a safe distance from the bit.

MATERIAL PREPARATION

The Infinity Lock Miter Junior Bit is designed to joint material 3/8" to 3/4" thick while the Lock Miter Master Senior Router Bit is designed to work with materials between 5/8" and 1-3/16". The material must be flat and square on all sides to produce straight, even joints.

BIT SETUP

Mark the centerline of the stock thickness and adjust the bit height so that its midpoint aligns with that mark as shown in the illustration at right. Bit height is fine-tuned during the test cuts described later.



FENCE SETTINGS

The amount of bit exposure outside of the fence should equal the thickness of the stock being used. When set correctly, the cut will leave sharp edges without reducing the width of the work pieces. If any portion of the square edge remains after the cut, increase bit exposure slightly.

ADJUSTING THE SETUP

The 90-degree lock miter joint is cut with one piece flat on the table and the other vertical against the fence.

Make a test cut on one piece flat on the table and then measure the flat portions along the outside edges of the cut. If they are not equal in width, adjust the bit height to correct them. Adjusting bit height affects the fence setting, which may need to be readjusted. When satisfied with the table-cut piece cut, machine both halves of the joint, one flat on the table and the other vertically against the fence to confirm the fit. Save a section of the final table-cut piece to use as a gauge when using the Lock Miter Junior Bit in the future to joint wood of the same thickness.

Tip: the Infinity Lock Miter Junior Bit can also make effective glue joints using the same setup by machining both halves flat on the table, one face up and the other face down.

JOINT ASSEMBLY

The Infinity Lock Miter Junior Bit creates a self-aligning joint with a large amount of glue surface. Apply a coat of glue to the contact surfaces, assemble and clamp using just enough pressure to close the joint. Make sure the assembly is square and set aside to dry.

CLEANING AND MAINTENANCE

For the best performance, keep your Infinity Lock Miter Junior Bit clean. DO NOT use caustic materials like oven cleaners as they can damage the bond between the carbide cutters and the bit body. Most woodworking supply outlets have commercially prepared solutions that safely remove the pitch and gum associated with machining wood.

Infinity Tools Customer Service: **1-877-USA-BITS (872-2487)**

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