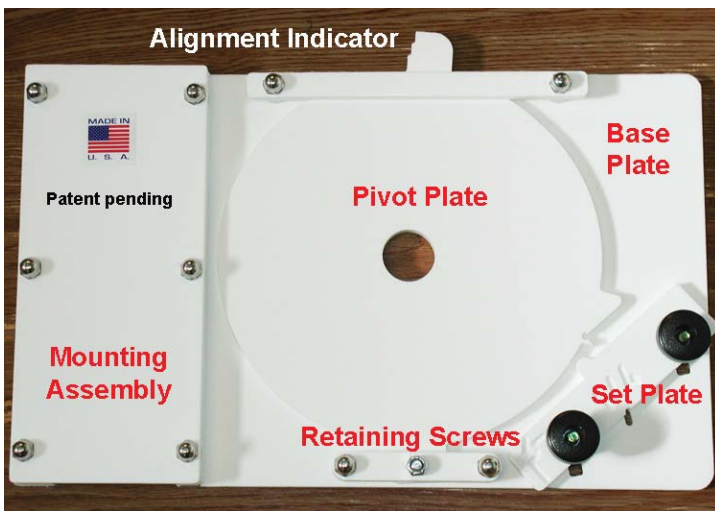


TRUE TRAC DADO JIG INSTRUCTIONS



CAUTION: POWER TOOLS CAN BE DANGEROUS AND MISUSE CAN CAUSE SERIOUS INJURY OR DEATH. ALWAYS READ AND FOLLOW ALL POWER TOOL INSTRUCTIONS. IF YOU ARE NOT SURE WHAT YOU ARE DOING, STOP AND BITS. DO NOT USE WITH WOOD THAT CONTAINS NAILS, SCREWS OR OTHER OBJECTS. TRUE TRAC IS NOT RESPONSIBLE FOR INJURY, ACCIDENTS, OR MISUSE.

The True Trac Dado Jig along with the True Trac system and your router is the simplest way to make perfect fitting dados and grooves every time.



The system uses a pivoting baseplate and a router. One side of the movement is limited by a fixed stop and the other side is controlled by an adjustable set plate. A perfect dado is easily made by setting the set plate, moving the True Trac Dado Jig along the True Trac guide rail while simultaneously holding the router against the fixed stop. At the end of the first cut, the router is pivoted against the set plate and drawn back towards the operator. The travel of the True Trac Dado Jig is controlled, and no matter how many passes are used to clean the cut, the final product is a great fit simply and easily.

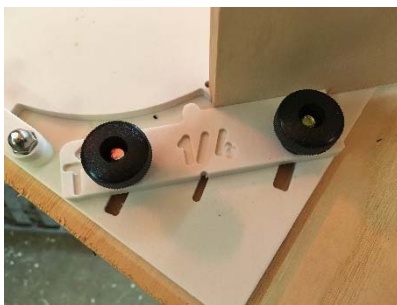


Figure 1 Stop is set to limit travel of pivot plate

The amount of pivot plate movement required depends on the diameter of the router bit used. The system is designed to work with either a 1/4" or 3/8" bit. The minimum width of a groove or dado is the diameter of the bit used, however, a smaller bit can be used to make a wider slot. Additional passes may be required to clean out the middle of the groove.

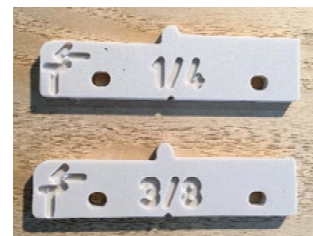


Figure 2 Use the correct set plate for the bit you are using, 1/4 or 3/8.

Fitting the *True Trac Dado Jig* to track.

The True Trac Dado Jig works on the narrow side of the True Trac extrusion as shown. Slightly loosen the three screws on the outside edge of the mounting assembly. Place the True Trac Dado Jig over the true track extrusion. Insert the tip of a screwdriver into the end of the adjustable track guide that rides in the center of the extrusion. Adjust the width of the grey portion to tighten the jig to the track. Adjust both ends and then tighten the screws snugly. The True Trac Dado Jig has small slots that allow for precise adjustment. When properly set, the True Trac Dado Jig should slide smoothly along the extrusion without excessive play.



Figure 3 Place over track, Loosen all three screws. Squeeze and then tighten.

Setting up your *True Trac Dado Jig*

The True Trac Dado Jig works well with virtually any router with a base plate up to 6½" in diameter (most 2½ HP or less routers). A router can be mounted to the pivot plate directly or by using a standard 1" OD style bushing (optional).

Using a Bushing

The True Trac Dado Jig can be used with or without an optional 1" guide bushing. A standard 1" diameter guide bushing fits tightly into the center hole of the pivot plate and the True Trac Dado Jig can easily be removed for use elsewhere. Contact us if you need to purchase a 1" bushing.



Figure 4 router with 1" bushing installed.

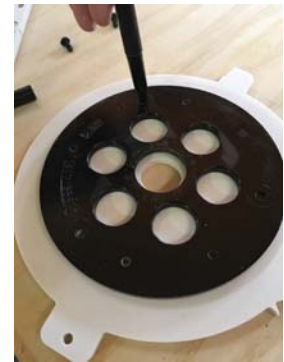
Without a 1" bushing, the router must be mounted to the pivot plate.

Option 1: Remove the pivot plate from the jig by removing the three retaining screws. Place the router on top of the pivot plate and note the position of the router handles and other fittings. The router should be turned until the handles and fittings will not interfere with the set plate knobs when the router base is pivoted during use. The opening in the pivot plate should be centered on the router bit opening. Carefully mark the location of router mounting holes. Drill the mounting holes and countersink them so the screw heads are just below the bottom surface of the pivot plate. Reinstall the pivot plate into the jig and tighten all the screws. The pivot screw is secured with a special nylon lock nut. Tighten the screw firmly, then back off ¾ turn to allow smooth movement of the pivot plate.



The pivot plate is marked and drilled, then countersunk to fit a router.

Option 2: Remove the pivot plate from the jig by removing the three retaining screws. Remove the original router baseplate and place the router on top of the plate. Note the position of the router handles and other fittings. The router should be rotated until the handles and fittings will not interfere with the set plate when the router base is pivoted during use. The opening in the pivot plate should be centered on the router bit opening. If your router plate will accept a bushing, use the bushing to help you center the router on your pivot plate. Carefully mark the location of router mounting holes. Drill the mounting holes and countersink them so the screw heads are just below the bottom surface of the pivot plate. Reinstall the pivot plate into the jig and tighten all the screws. The pivot screw is secured with a special nylon lock nut. Tighten the screw firmly, then back off $\frac{3}{4}$ turn to allow smooth movement of the pivot plate.



Use the original baseplate to mark the pivot plate.

Setting dado width to match material

To set the dado width, select the set plate that matches the diameter of the bit used. Select $\frac{1}{4}$ " for dados from $\frac{1}{4}$ " to $\frac{1}{2}$ " wide. Use a $\frac{3}{8}$ " bit and set plate for dados from $\frac{3}{8}$ " and larger.

Install the set plate and push the pivot plate against the left stop as shown; place a sample of the material between the straight portion of the pivot plate and the set plate. Press the set plate trapping the material between the pivot plate and the set plate.



Insert a sample of the wood between the set plate and the pivot plate. Press gently and tighten the knobs snugly. Slide set plate left or right to adjust cut.

Compensation for runout and adjusting fit.

There is an additional adjustment that compensates for variation in routers, runout, and degree of desired fit. Set plates are adjustable left to right by a small amount. There is an arrow on the set plate. Moving the set plate in the direction of the arrow tightens the dado slightly. Moving it to the right loosens the cut. If your test dado is too tight, move the set plate to the right. If your dado is too loose, move the set plate to the left.

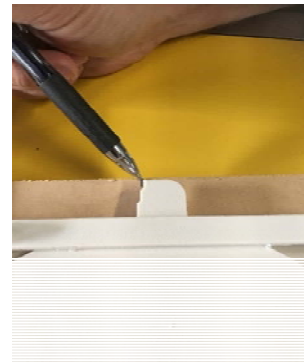
NOTE: There is a reference slot in the base plate and a notch cut in each set plate to allow a visual reference of the setting. You may have to practice a couple of times, but you will soon get the hang of it!

We recommend you make your initial cut with the set plate in the "tight" position. You can always make a small adjustment and make another pass if the dado is too narrow. Press the set plate against the material and tighten both thumbscrews snugly. Once set for a given thickness, all additional dados should be exactly the same width.

ALWAYS TEST THE FIT IN A SCRAP OF WOOD TO ASSURE YOU HAVE PROPERLY ADJUSTED THE SET PLATE. SOME VARIATION CAN EXIST AND CORRECTIONS ARE EASILY MADE BY ADJUSTING THE LEFT TO RIGHT POSITION OF THE SET PLATE A SMALL AMOUNT TO GIVE A TIGHTER OR LOOSER FIT.

Cutting A Dado

Place the True Trac Dado Jig over the True Trac extrusion and adjust the position of the guide rail to the desired. The True Trac Dado Jig pivot plate contains an alignment indicator that will closely correspond to the left edge of the dado when the pivot plate is against the left stop. It is best to make a test cut and compare the actual position with the indicator. Any variation is the result of mounting the router a little off center or runout in the router. A user can quickly note the alignment of the test cut versus the indicator and use this knowledge to set up future cuts accurately and easily.



Align the proper notch to match your bit size. 1/4" bit shown.

DO NOT TURN ON THE ROUTER BEFORE INSERTING THE ROUTER COMPLETELY INTO THE JIG. DAMAGE TO THE JIG AND POSSIBLE SERIOUS INJURY MAY OCCUR.

Once the track is in position, **clamp the track firmly in place** and place the jig over the track with the center hole located off the edge of the material. Place the router with bit set to the desired depth onto the jig. If using a bushing, make sure the router is fully inserted into the pivot plate. Firmly hold the router and jig assembly while simultaneously gently pressing the assembly to the left so the pivot plate is against the left side of the jig (toward the track).

Turn on the router, and with a slow smooth action, slide the assembly along the True Trac rail making a cut. Once the end of the cut is reached, and without turning off or lifting the router, move the pivot plate against the right hand set plate and slide the jig assembly along the guide toward the user. Repeat sliding the jig assembly as necessary to clean out the middle of the dado. The router cannot move outside the area of your perfect dado.

Turn off the router and wait until the bit stops turning. Then and only then can you remove the router and jig from the workpiece.

The True Trac Dado Jig is the perfect solution for perfect dados quickly and easily.

Replacement parts are available for any damaged items. Some woodworkers may also like to have an extra pivot plate for other routers. If you damage the jig by accidentally lifting the router bit while it is still turning, just give us a call. We sell replacement parts for a reasonable price.

For videos and additional instructions visit our website. We recommend that all users read these instructions carefully and visit our website for updates and additional information.

Patent pending.