

# Blue Max Clamp System

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[WWW.WOODLINE.COM](http://WWW.WOODLINE.COM)

Woodline makes a complete line of Blue Max clamp guides for many wood working tasks. These instructions are designed to cover most applications of the clamp.

## **Using Blue Max clamps:**

All guide type bar clamps are designed to lay flat on the material and provide either a reference to run a tool against or to guide accessories over the surface of the wood. These clamps are not designed for high clamping pressure glue up applications. For that purpose use Woodline Parallel Clamps with Ultra Torque handles.

Secure the clamp to the surface by making sure the clamp tightening handle is in the released position. Lay the clamp over the material holding the jaw at the end of the clamp firmly against the material. Slide the moveable jaw away and then back to the material until the moveable jaw stops against the material. The clamp tightens by using the handle which contains a multi-lobe cam to pull on the rod located on the bottom side of the clamp. The released position is when the rod is released into the clamp body and the handle is loose. As the cam handle is moved it has three clamp positions which provide incremental tension on the rod and thus on the material. Use the lowest tension position that will assure the clamp does not slip on the material. Excess pressure will wear the clamp dogs prematurely and cause failure of the clamp. If the clamp is move to a board of similar size always move the moveable jaw away and bring it back to the correct position. This frees the clamp dogs and improves clamping ability.

## **Special note for BLUE MAX 360 clamps only.**

Do not rotate the handle while tension is applied to the clamp. Doing so may damage the clamping mechanism. The handle should rotate only counter clockwise when changing from one position to another.

## **Optional Saw Base**

The saw base is a plastic plate that a circular saw mounts to and is guided by the clamp. This accessory is excellent for cutting sheet goods into manageable sizes.

### **Mount the saw to the base:**

Set the saw on the base making sure the motor will not hit any portion of the clamp when in use. Assure the saw is retracted to a point where the blade is above the base. The saw must be mounted square to the base. Sit the saw in place and use a square to align the

saw. Mark the mounting holes where screws can secure the saw to the base. Drill the holes. Screws are not provided since many types of saws are used. Secure the saw firmly to the router base with screws that are countersunk from the bottom of the base. Screws should be checked frequently to assure they have not vibrated loose during use.

T bolts and knobs are used to hold the saw base to the clamp and slide in the T slot on the edge of the clamp. Do not tighten the knobs or the base will not be able to slide as the saw is used. Clamp the bar over the material to be cut and align the blade with the desired cut line. Cut the material. Use care to assure the saw does not cut any items below the material or the electrical cord. Wear safety glasses at all times and use caution.

## **Router Base**

The router base is used to route slots, dados and profiles in material being held by the clamp. Mount the router to the router base accessory using the screws that held the router to the router base plate. The original base plate can be used as a template to drill the mounting holes and secured from screws. Screws should be checked frequently to assure they have not vibrated loose during use.

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Do not tighten the knobs or the base will not be able to slide as the router is used. Clamp the bar over the material to be cut and align the bit with the desired cut line. Cut the material. Use care to assure the router does not cut any items below the material or the electrical cord. Wear safety glasses at all times and use caution.

## **Bandsaw Fence**

### **Mount Angle Brackets to Clamp**

- Remove and separate all hardware components from the aluminum angle brackets.
- Clamp the clamp on the band saw table to the left side of the blade when facing the saw in the normal operating position. Slide two T nuts into the slots on the outside edges of the clamp.
- T bolts are used to secure the angle brackets to the clamp assembly. The angle brackets should be mounted at least 4" either side of the center of the table where the blade is located. Insert the angle bracket over the T bolts and securely tighten the knurled brass knobs.
- Due to variation in clamp sizes and the possible variation in extrusion of the angle brackets, you may occasionally have to file the bracket slightly to allow it to fit the clamp perfectly. This is normal and allows the angle brackets to be used with other clamp manufacturers clamps. A few strokes with a file will always allow the brackets to fit properly if they do not at first.

### **Make a fence board and install it.**

- Using a piece of  $\frac{3}{4}$ " thick material that is approximately 4" wide by at least 12" long (exact sizes should be changed to fit your specific saw and application. These sizes are fine for most 14" saws), place in position with one edge on the table and one face against the clamps. Mark the location of the holes to mount the board to the brackets.
- Drill a  $\frac{3}{8}$ " deep counterbore using a  $\frac{3}{4}$ " forstner bit for the counterbore hole. Holes should be deep enough to allow the supplied T bolt heads to install below the surface of the material. Drill through holes with a  $\frac{5}{16}$ " drill bit. Using the supplied T bolts and knobs or nuts, secure the fence to the brackets.

Always assure the clamp is securely fastened to the table before usage. Be Safe and have FUN!

### **Feather board**

The feather board is simple to use. Mount to the fence to the clamp using the T bolts and knobs. Place the clamp so the feather board engages the material and tighten it to the surface. Do not apply excess pressure with the feather board or the clamp may release.