

Panel Master System by Woodline USA

CAUTION: ALWAYS FOLLOW SAFE WORKING PROCEDURES. CHECK TO ASSURE BIT WILL NOT HIT THE CLAMP OR OTHER METAL OBJECT DURING ANY OPERATON. FAILURE TO WORK SAFELY CAN CAUSE SERIOUS INJURY.

Assemble as shown. Two small washers are placed over each T bolt before the template is installed. The washers serve to keep the template from flexing when the handles and knobs are tightened. The picture below shows the panel template installed for flush trimming the panel. Use the center hole for either setup and one of the outside holes depending on whether you are cutting a rail or panel.

To assure panel is centered, ensure the scale on the clamp is in line with the edge of the 90 degree clamp head. The clamp head is installed against the fixed jaw and secured with two self drilling screws. When the template is installed the center of the template should align with a measurement equal to $\frac{1}{2}$ the door width. For example if the rail or panel is 10 inches wide the center should line up with the 5 inch mark on the scale. Tighten all knobs and handles to secure the template to the clamp.

Note that the clamp can tighten with the handle either up or down depending on how the handle is rotated. When using with the templates or as a small parts handler assure the clamp is tightened with the handle up only. Failure to follow these instructions could cause the clamp to release if the clamp handle strikes the table.



Woodline has created a unique new Raised Panel Door System that takes a lot of the guesswork and hassle out of the chore. It comes with a set of templates and a jig to hold the template and work stock.

New System for Frame and Panels

The unique system utilizes templates and a holding jig that makes it much easier and safer to make the arched rail and panel cuts. In this case, the template is used to mark the shape of the arch and again the arch cut on a bandsaw to about $\frac{1}{8}$ to $\frac{1}{16}$ inch. The template is fastened to the holding jig and the stock clamped in place. The flush-trimming bit is set so the bearing rides on the template edge and the stock is trimmed flush. The holding jig slides on the router table and has a pair of handles that make it easy to guide the stock into the cutter. The flush-trimming bit is removed, the cope bit installed. The fence is reinstated, and the cope cuts are made on both the upper and bottom rails. The

profile cuts on the stiles and bottom rail are then cut with the profile bit. The fence is removed and the inside profile is cut on the rail freehand, again using the handles to feed the stock into the cutter.



The jig holds the selected template to match the stock profile and the inside profile cut on the arched rail. Simply guide the jig and stock against the cutter with the handles. A firm grip and steady slow feed rate will result in the best cut.

The template is reversed on the holding jig and the panel door arch is cut to match the template. The flush-trimming bit is then used to trim the panel arch flush. The panel-raising bit is installed, and the jig is used to guide the arched panel portion through the cutter. When cutting the raised panel be sure to locate the panel out from the template so it will not be damaged by the cutting operation. The fence is then reinstalled, and the bottom cross-grain cut is made, followed by the two side cuts.



The holding jig is then used with the reverse side of the template to cut and shape the arched door top.

Sand the panel thoroughly, then glue. Note that the panel is not glued in place, only the corner joints of the rail and stiles are glued.