Xerocraft DeWalt 618 Router Table Instructions:

Even if you are familiar with the old router table usage, please review these instructions! Several things are different. If you are uncertain, PLEASE CONTACT A WOOD SHOP STAFFER!

Bit Installation and Removal

CAUTION: Turn the router table master switch to OFF before changing bits or adjusting the router.

1. Select the bit for your job. Depending on the shaft size of the bit selected, you may use either the standard ½" collet, or add the 1/4" adapter. Note that there is not a separate nut for the ¼" collet. It is inserted *into* the ½" collet.

When not in use, please store the collet adapter in the hole provided in the accessory table on the right.

2. To install a bit, raise up the router to get access to the spindle lock. Locate the spindle lock button as shown at right. Depress the spindle lock button to hold the spindle shaft. You may need to manually rotate the spindle a quarter-turn or so until the button locks into the hole in the spindle shaft. The button is spring-loaded and will pop out when released.
3. Insert the round shank of the desired router bit into the loosened collet as far as it will go and then pull it out about 1/16". Using the wrench provided, turn the collet nut clockwise while holding the spindle shaft with the spindle lock button.
4. To remove a bit, hold the spindle shaft by depressing the spindle lock button while turning the collet nut counterclockwise with the wrench provided. The self-releasing collet nut will turn approximately 3/4 of a turn and then become tight again. At this point the bit cannot yet be removed. Continue turning the collet nut counterclockwise. This lifts the collet, allowing the bit's removal.

5. Collets NOTE: Never tighten the collet without first installing a router bit in it. Tightening an empty collet, even by hand, can damage the collet. The ½" collet and the collet nut are connected. Do not attempt to remove the collet from the collet nut. Please do not lose the ¼" collet adapter.

Choosing Router Speed

The speed control is a six-position dial on the top of the router unit. (See photo.) Depending on the material and the size of bit you select, you can choose the best speed for your cut. Do not assume that the last user used the same settings as you. Always check the speed control before cutting.

Refer to the chart below to choose the best router speed. Turn the speed dial to control router speed. Do not adjust the speed control while the router is running. POWER OFF FIRST!

SPEED SELECTION CHART

Material	Cutter Diam.	Electronic Control Settings					
Model # DW618		**Setting 1 8,000 rpm**	**Setting 2 12,000 rpm**	**Setting 3 14,000 rpm**	**Setting 4 18,000 rpm**	**Setting 5 21,000 rpm**	**Setting 6 24,000 rpm**
Hardwood, e.g., oak	Small (1/2")	–	–	O	X	XX	X
	Medium (1/2"-1 1/8")	–	–	O	XX	X	–
	Large (over-1 1/8")	X	XX	O	–	–	–
Softwood, e.g., pine	Small (1/2")	–	–	O	X	XX	XX
	Medium (1/2"-1 1/8")	–	O	X	XX	XX	XX
	Large (over-1 1/8")	X	XX	O	–	–	–
Plastic-laminated chipboard	Small (1/2")	–	–	O	X	XX	XX
	Medium (1/2"-1 1/8")	–	O	X	XX	XX	XX
	Large (over-1 1/8")	O	XX	X	–	–	–
Plastics/Solid Surface	Small (1/2")	–	O	X	X	XX	XX
	Medium (1/2"-1 1/8")	–	O	XX	XX	X	X
	Large (over-1 1/8")	X	XX	O	–	–	–

This table can serve only as a guide, since wood was a living material. Within the same species of timber hardness and density vary. Speed settings are approximate.

KEY: XX very good X good O Satisfactory – not recommended

Direction Of Feed

The direction of feed is very important when routing and can make the difference between a successful job and a ruined project. Remember that on a router table, the router is upside down. Therefore, the bit is turning counter-clockwise from your vantage point. You will move your stock from right to left through the cutter. This insures you are cutting *against* the rotating cutter.

NEVER FEED STOCK FROM THE LEFT SIDE AS THIS CAN LAUNCH YOUR BOARD ACROSS THE ROOM!