

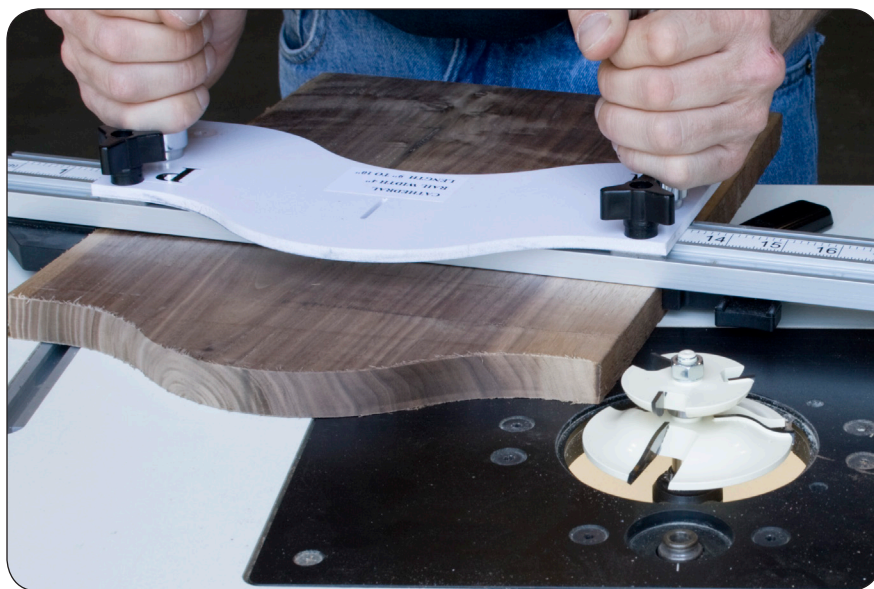
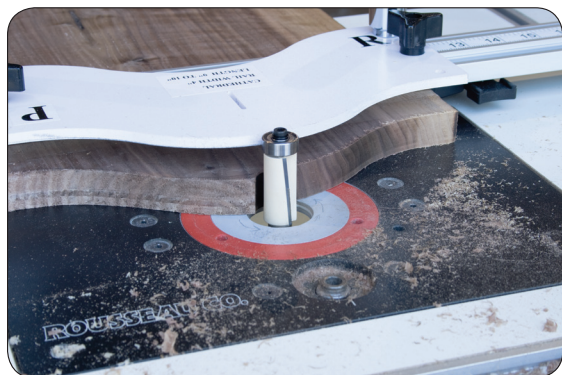
Panel Master Pro Instructions

Make wonderful looking raised panels with the Panel Master PRO! Typically when making raised panel doors you must, tape, or tack your stock piece to a template, this wastes time and can damage the wood. With the Panel Master PRO we have solved this problem by allowing you to clamp your stock secure with a 180° straight edge clamp. This clamp gives total range of motion across the table top and it also accepts two steel handles for a solid feel while working your stock through the router bit.

NOTE: The Panel Master is intended to be used for cutting the arched portions of raised panel doors only.

PLEASE READ THE ENTIRE SET OF INSTRUCTIONS, AND OWNERS MANUALS FOR ALL OF YOUR POWER TOOLS BEFORE PROCEEDING WITH ANY PROJECT.

CAUTION: Make sure the power supply is disconnected on your power tool(s) or machinery before making any adjustments. Don't use any tools with out the proper safety guard(s) in place or without reading the instruction manual that came with the unit. Always wear the proper eye, ear and respiratory equipment when using power tools.



The Panel Master Pro

Includes:

- 1ea. 90° Squaring Head - used for keeping your stock squaring during the cutting process.
- 2ea. steel handles - attach directly to the straight edge clamp and provide a solid feel in your hands while making your cuts.
- 1ea. 24" - 180° straight edge clamp - The clamp head rotates to give you an un-obstructed working plane on top of your router table.
- 1ea. 10 pc template set - Will do the panels and rails from sizes 10" to 19".

Additional items you will need.

1. Router - at least 1¾ hp or larger mounted on a router table
2. Flush trim router bit - The bit must be long enough so the bearing cleanly contacts the template during the cutting process. About a 2" to 2-1/2" flush trim bit is recommended.
3. Raised Panel Bit- Choose a raised panel bit profile to your liking.
4. Stile and Rail Bits - Usually included in a set with the raised panel bit (*must match raised panel profile*).
5. Bandsaw or Jigsaw - The bandsaw or jig saw is used to cut the rough profile on the stock.
6. Phillips head screwdriver - Needed to attach the 90° head. (a power driver may be used as well)

Cutting the Top Arched Panel

Step 1



Slide the 90° head up and against the stationary head of the straight edge clamp as shown above.

Step 2



Place a SQUARE piece of stock between the jaws, do not secure clamp. Square the 90° head to the straight edge clamp. Once square, secure the wood in the clamp. Next, with the two self tapping screws that are provided, secure the 90° head directly to the clamp.

Note: you may need to use a power driver to drive the screws in securely.

Step 3



With the Panel Side (marked with a P) facing the top end of the stock, place the template of your choosing on to the stock you are going to use. Center the template on the wood and trace the panel side of the template the entire width of the stock.

Step 4



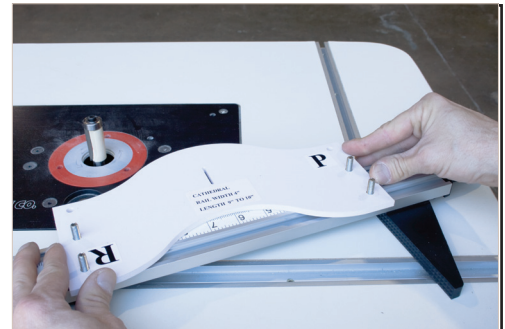
With a jigsaw or bandsaw, rough cut your stock. Leave some stock as you cut, do not cut right on the line, you will need this line as a reference later.

Step 5



Slide the 4 T-bolts into the straight edge clamp, and place the rectangle washers on so they are flush with the top track of the clamp.

Step 6



Place the template on to the four bolts as shown in photo.

Cutting the Top Arched Panel Continued

Step 7



Secure the template with the two star knobs and the two steel handles. Place the steel handles toward the back side of the template for better leverage.

Step 8



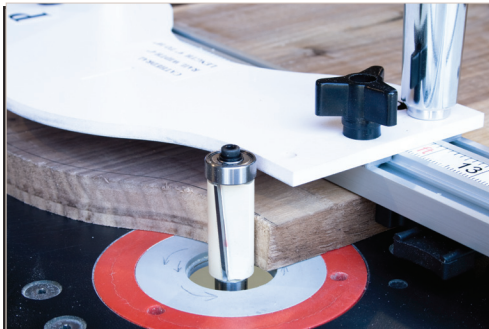
Place your stock under the clamp and the template. Align the template with the line you marked earlier.

Step 9



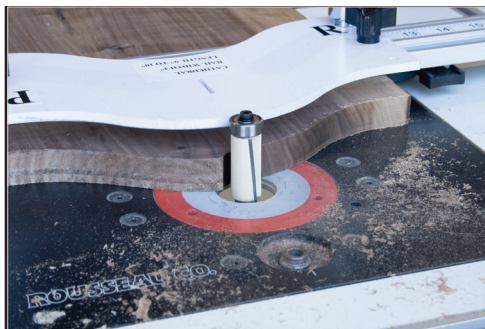
Secure the stock on to the straight edge clamp.

Step 10



Adjust the height of your flush trim router bit so the bearing rides cleanly on the template as shown in the photo above.

Step 11



With your stock and Panel Master Pro System secure, make your cut. Start out on the end and work your way slowly across the stock. You may need to make multiple passes depending on how much stock you left to remove.

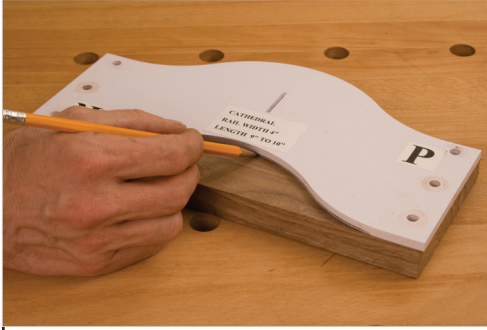
Step 12



The end of the panel should now be ready for the raised panel bit cutting process.

Cutting the Top Arched Stile

Step 1



With the Rail Side (marked with an R) facing the top end of the stock, place the template of your choosing on to the stock you are going to use. Center the template on the wood and trace the panel side of the template the entire width of the stock.

Step 2



With a jigsaw or bandsaw, rough cut your stock. Leave some stock as you cut, do not cut right on the line, you will need this line as a reference later.

Step 3



Repeat steps 5-10 in the "Cutting the Top Arched Panel" section with the exception of keeping the "R" side facing the front of the Panel Master Pro system.

Step 4



With your stock and Panel Master Pro System secure, make your cut. Start out on the end and work your way slowly across the stock. You may need to make multiple passes depending on how much stock you left to remove.

Step 5



Your stile and panel arches should match and resemble the photo shown above.

NOTE: The Panel Master Pro is intended to be used for cutting the top arches for raised panel doors only. It is not intended to be used for cutting the styles or the rails. Below are general guidelines for cutting the remaining pieces for the cabinet door. For more details on how to cut these portions of the cabinet door, refer to the link(s) below for more details.

For more details go to: http://www.ptreeusa.com/Arched_Door_Instructions.pdf

Using the Panel Master Pro with a Raised Panel Router Bit



When using the Panel Master Pro to cut the arched raised panel portion of the stock, there are a few things to remember when doing so.

1. Make sure the clamping system and template are backed up, so that neither the template or the clamp do NOT hit the router bit. *Note: this is a free hand cut, the template is not used during this process, however, the template must stay on the Panel Master Pro system for stability purposes.*
2. Raised panel bits are large bits that remove a lot of stock at once. It is important to keep a slow and steady pace while making this cut. Do not slam or force the stock into the cutter.
3. It is recommended to slow the speed of the router when using larger router bits. When using raised panel bits the recommended speed setting is 14,000 to 16,000 rpm.

For more details on cutting with raised panel bits go to: http://www.ptreeusa.com/Arched_Door_Instructions.pdf

Using Stile and Rail Router Bits



When cutting the stiles and the rails on your raised panel door you will NOT be using the Panel Master Pro System. The stiles and rails are too narrow for the system to properly fit the stock.

1. When making the cut(s) on the stiles and rails, be sure to use a safety push device.
2. The stile and rail cutters are large bits that remove a lot of stock at once. It is important to keep a slow and steady pace while making this cut. Do not slam or force the stock into the cutter.
3. It is recommended to slow the speed of the router when using larger router bits. When using stile and rail bits the recommended speed setting is 14,000 to 16,000 rpm.

For more details on cutting with the stile and rail bits go to: http://www.ptreeusa.com/Arched_Door_Instructions.pdf

Cutting the Bottom and the Sides of the Panel

Once you have made the arched cut on your panel with the raised panel bit, remove the Panel Master Pro system from your stock. Once the system is removed, install your fence on your router table. This is done to setup for cutting the bottom and the sides of the panel.

1. Align the fence in the desired position to the raised panel bit. Secure the fence in place. *Note: Make sure ALL safety devices are in place before making the cuts: featherboards, safety guards, safety glasses, etc.*
2. Make the bottom cross grain cut first and then the side cuts. Depending on your raised panel bit, you may need to make a couple of passes to obtain optimum results.

For more details on cutting the bottom and the sides of the panel go to: http://www.ptreeusa.com/Arched_Door_Instructions.pdf