Using the Freud® Easy-Set Jig

**FIRST - Determine the thickness of your stock.** Don’t assume that hardwood or softwood stock you buy in a lumberyard or home center is of a consistent thickness…or that it is as stated. For example, most 3/4” plywood is actually 23/32” thick. Dial calipers are best for these measurements. The decimal conversion tables below will help. A fractional calipers works best.

**NEXT - Set the Easy-Set dial** - Each mark on the outer jig dial = 1/128” (.0078”). Each medium-length line = 1/64” (.0156”). Each full-length line = 1/32” (.0312”). Start by turning the center grip all the way counter-clockwise until the arrow on the grip stops at the star.

At this position, the jig is set for 23/32” (the standard thickness of most 3/4” plywood). Turn the dial clockwise to the next full-length line and it will be set for 3/4” thick stock. Each audible click clockwise raises the jig 1/128” for thicker stock. During your first 360° rotation, read the numbers on the right of the full-length lines. During the second rotation, read the numbers on the left of the full-length lines.

**Baby Lock Miter Settings:** When using Freud’s Baby Lock Miter Bit, the jig functions a little differently…and can be set to handle stock from 15/32” to 3/4” thick. When using 1/2” thick stock, turn the center grip all the way counter-clockwise until it stops. Then turn the grip four clicks clockwise until the 1/2” indicator is aligned with the smaller arrow on the outer ring. Each audible click clockwise raises the jig 1/128” for thicker stock. For 3/4” stock turn the center grip clockwise one revolution until the 1/2” indicator aligns with the outer ring arrow again. This is the correct setting for 3/4” thick stock.

**FINALLY - Line-up your Bit’s cutting edge with the Easy-Set profile** – With the bottom of the Easy-Set Jig resting flatly on your router table surface, align the indicated edge of your bit with the edge of the Easy-Set jig profile (see arrows with drawings).