

## PANEL ROUTERS

1. Employees will be properly and thoroughly trained before attempting to do any work with or on any panel router.
2. Read and understand the safety and operating instructions.
3. Each machine operator is responsible for insuring that the machine is operated in a safe condition and in a safe manner and that he/she has been duly authorized and trained in the safe operation of the machine.
4. It is the duty of each operator to immediately eliminate or report any changes occurring on the machine or in the wood being processed which changes may effect the machine's safe operation.
5. The cleanliness and tidiness of the machine and its surrounding area must be ensured through appropriate instructions, routine inspections, and cleaning.
6. Work on or alteration of this machine, which detrimentally affects the safety of the machine in any way, is prohibited.
7. All guards must be kept in place and in working condition.
8. Machine parts or components, which form part of the safety protection, must not be removed, dismantled, altered, put out of operation, or relocated.
9. All safety devices must be checked at regular intervals for perfect operation.
10. The beveled router sub base must be adjusted to stop 1/8" below the surface of thickness of material being cut. **Failure to follow this step will ultimately result in unnecessary damage to the router lifting platform.**
11. If you expect smooth, clean, chip free cuts you MUST:
  - A. Use industrial carbide router bits which are SHARP. Dull bits or improperly sharpened bits will cause chipping, unclean cuts, chatter, and will overload the router motor.  
**\*Note: always use a sharp cutter. If in doubt replace it with a new bit.**
  - B. Feeding the material through the machine horizontally or moving the router carriage through the material vertically MUST BE DONE SLOWLY, SMOOTHLY, AND WHENEVER POSSIBLE WITHOUT STOPPING. Over feeding will result in poor quality cuts, shorten the life of the carbide cutters, and overload the router motor.
12. Caution must be used when setting material into the roller carriage. Heavy material must not be dropped onto the roller carriage. Failure to follow this rule will ultimately cause the roller carriage to be pounded out of alignment.
13. Generally, the material must move through the machine horizontally from right to left as you face the machine.
14. Generally, the vertical movement of the router carriage must be from the top of the machine downward through the material.
15. When cutting window openings, be sure to start your plunge cut in an upper corner. This will allow the cut out to fall downward and away from the cutter when the final cut of the opening is made.
16. To maintain free and easy movement of the router carriage, occasionally wipe guide tubes clean and lightly spray with silicone.
17. Observe all appropriate safety and accident prevention requirements.

---

Date