

## The Micro Fence Circle Jig

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**Circles Between 12" and 48" Diameter:** Figure 1 illustrates the assembly most commonly used for circle cutting. We recommend your circles be initially "blanked out" slightly over-sized with either router, band or sabre saw, and then trued to perfection with our Circle Jig and your router fitted with a spiral-fluted straight bit. We realize that this approach may not be the most efficient production technique, but it will reduce the cutting load for your router and make the entire process a safer and more manageable experience.

Use a compass or trammel beam for your original layout and then drill a 1/8" pilot hole. Drill approximately 3/8" deep at the center position to receive the spiked end of the trammel point. Unless you're working with material less than 1/2" thick, you won't have to drill all the way through your workpiece. **(This will allow you the option to work upside-down and leave the top side of your work unmarked).** Position the trammel point in the center hole of the rear trammel bar, leaving the brass locking screw slightly loosened. Place the trammel bar, over the pilot hole and gently tap the 5/32" spike on the end of the trammel point into it. The trammel bar should be adjusted up or down on the pin to insure that the entire jig is parallel to the work surface. (See Fig. 2). If you wish you may insert a spacing washer of appropriate thickness between the work surface and the bottom of the trammel bar. Be sure, then, to tighten the locking thumbscrew.

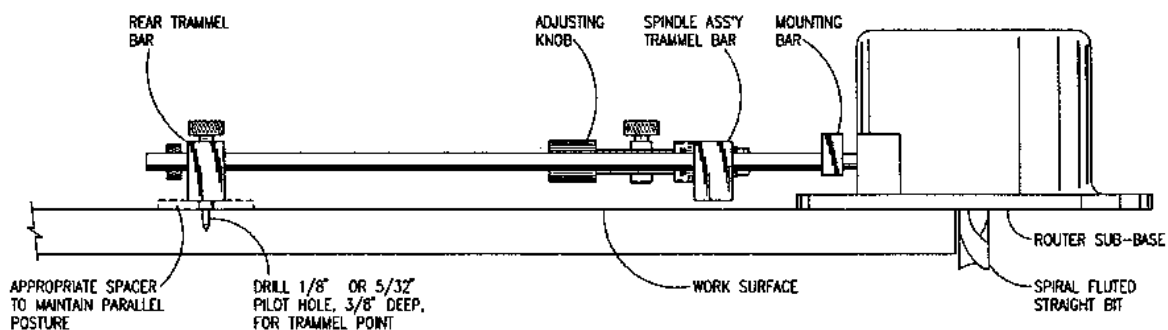


Figure #2

Set the initial jig position so that the router bit is slightly clear of the material to be cut. Make a "power-off" revolution to check all settings and to see that a smooth, uninterrupted motion will be achieved. The use of a dry lubricant spray on the sub-base of the router may provide improved motion. Once you are satisfied that all systems are "go", you're ready to make a circle.

***Turning the spindle clockwise draws the bit toward the fence; counter-clockwise pushes it away. Remember that routers rotate clockwise, (when viewed from above). Your feed should be counter-clockwise to avoid "climb-cutting." Take it easy. NEVER force your router beyond its load capability.***



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***Be sure to tighten all mounting and adjusting screws firmly. Failure to do so can result in spoiled work or injury. We encourage you to develop the habit of rechecking tightness frequently during use to insure that excessive vibration has not caused loosening.***

Start the router and gently "dial" into the cut. Turn the Circle Jig's adjusting knob clockwise until you hear the bit tick the workpiece. When contact has occurred, dial approximately .010" (.28mm) further and make an initial pass around the work. "Dead" spots or heavier cutting sounds will indicate the trueness of your circle. We recommend subsequent cuts in small increments (.010-.015"), until you become familiar with the characteristics of both material and machine. Your circle will be true when even cutting occurs all the way around the work. Check your diameter with tape measure or calipers and continue "dialing in" until you achieve the dimension you require.

**Note:** Micro Fence®'s Vacuum Center will allow you to secure your jig to the work surface without any need for a pilot hole. Call us or check our website for additional information.