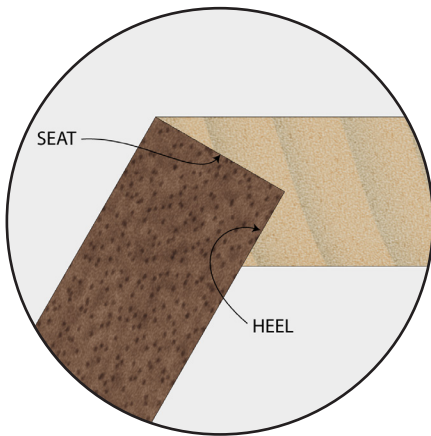


The 15137 Bird's Mouth Glue Joint Bit is designed to cut glue joints for 16-sided objects with one simple setup on the router table.

### Step 1: Determine stock thickness and diameter of finished object.



Decide on the finished diameter of your project and select stock that is no thicker than the router bit's seat-cutting edge.



### Step 2: Find the segment width.

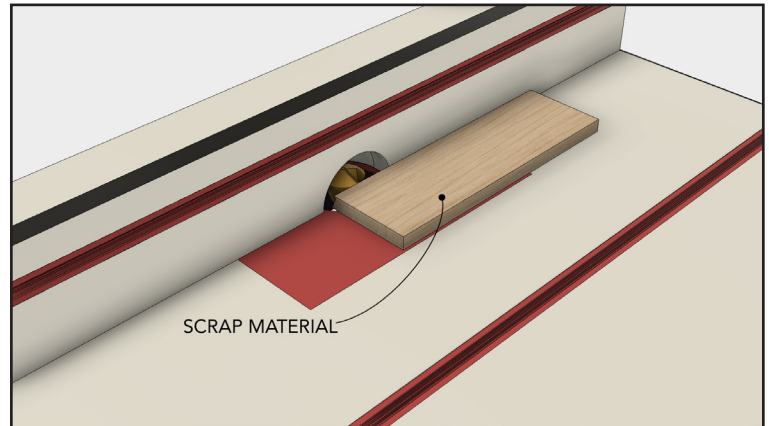


To calculate the segment width, divide the object diameter by 5. For example, segment width for a 12" diameter object would be 2.4".

### Step 3. Set bit height and fence depth.

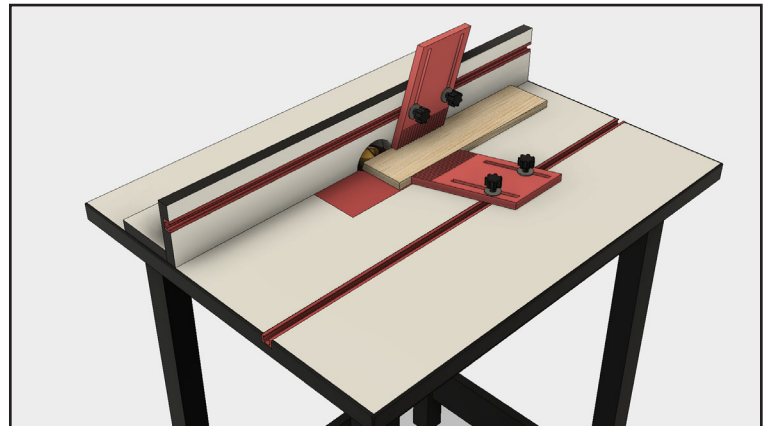
Find the appropriate bit height by multiplying the stock thickness by 0.924. If your stock is 0.5" thick, the bit height should be .462". Multiply the stock thickness by .383 for the fence depth. This formula would give you a fence depth of .192" for .5" stock.

### Step 4: Make a test cut in scrap material.



Run a piece of scrap material through the router and test the joint's fit. If the bit height and fence depth are correct, you're ready to route.

### Step 5: Route one edge of each segment.



Run each segment through the router table face down. For the best results, use feather boards to keep your work pressed tightly against the table and fence. Feed slowly, and use a push stick to keep your hands at a safe distance from the bit.

# Important Formulas

**To calculate segment width:**

Outside diameter / 5

**Bit height:**

Stock thickness x 0.924

**Fence depth...**

Stock thickness x 0.383

**Face up/face down guidelines:**

Route all segments with outside face down

## Bit & Fence Setup De- tail

