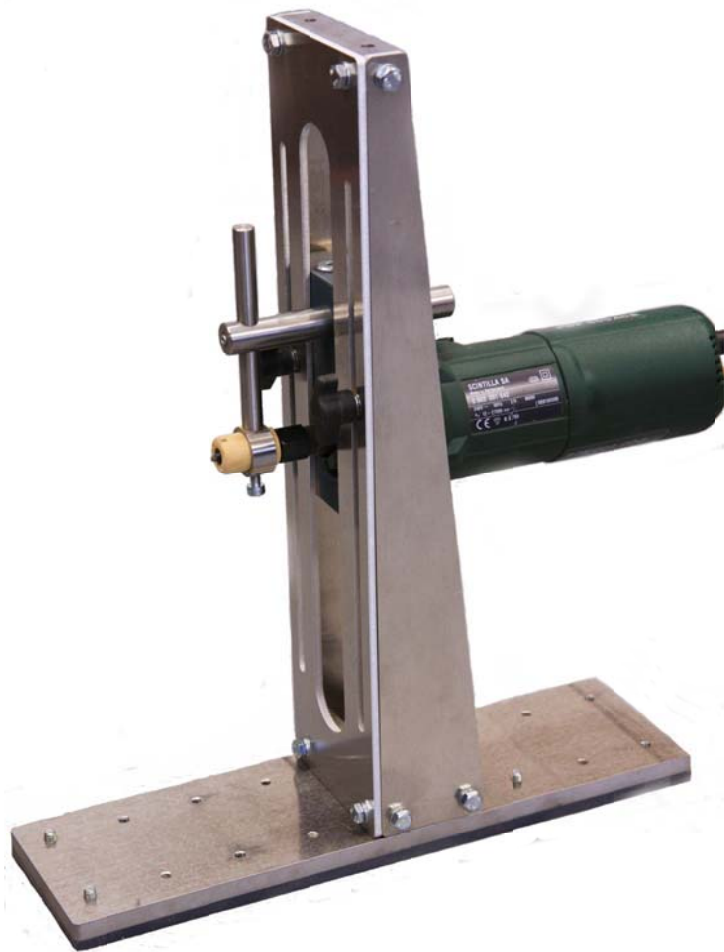


## Howard Fluting Jig



[www.paulhowardwoodturning.co.uk](http://www.paulhowardwoodturning.co.uk)

Paul Howard Tel 01621 815654 Mob 07966 188559

### Specification

Suits lathes with spindle heights from 80mm to 310mm (3.25" to 12")  
Greater spindle height can be achieved by using a base plate on the lathe bed.  
A base plate or board is recommended for a lathe with round bed bars.  
Base boards made from 20mm MDF or scrap Kitchen Work Tops are ideal.

Routers that are removable from their base with a standard 43mm or 65mm collar.

Reducer collars can be supplied to suit die grinders or other tools with a parallel collar can be provided. The Trend T3 has a 42mm collar so 0.5mm shim can be supplied. The Trend T4 has a 43mm collar.

Base fitted with plastic liner.

Router carrier can be adjusted along the length of the base.

Height and length adjustment for guide bush.

Router not included.

### Safety

Important PPE (personel protection equipment) must be worn when using this jig.

Eye and full face protection must be used.

Router cutters rotate up to 27000 RPM.

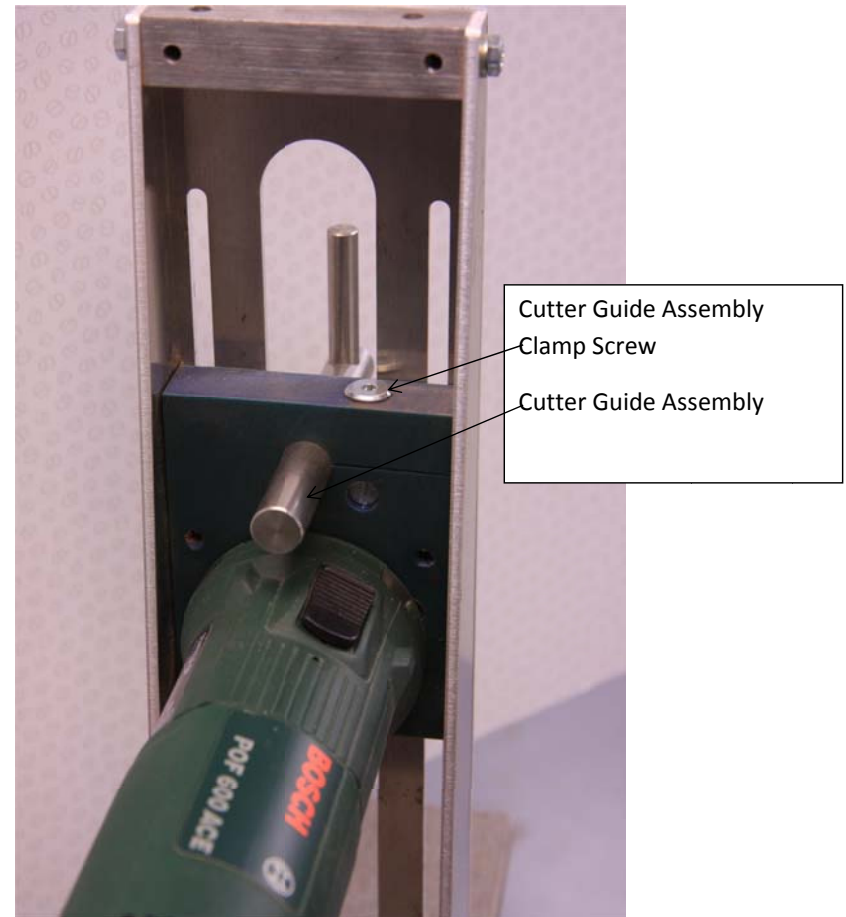
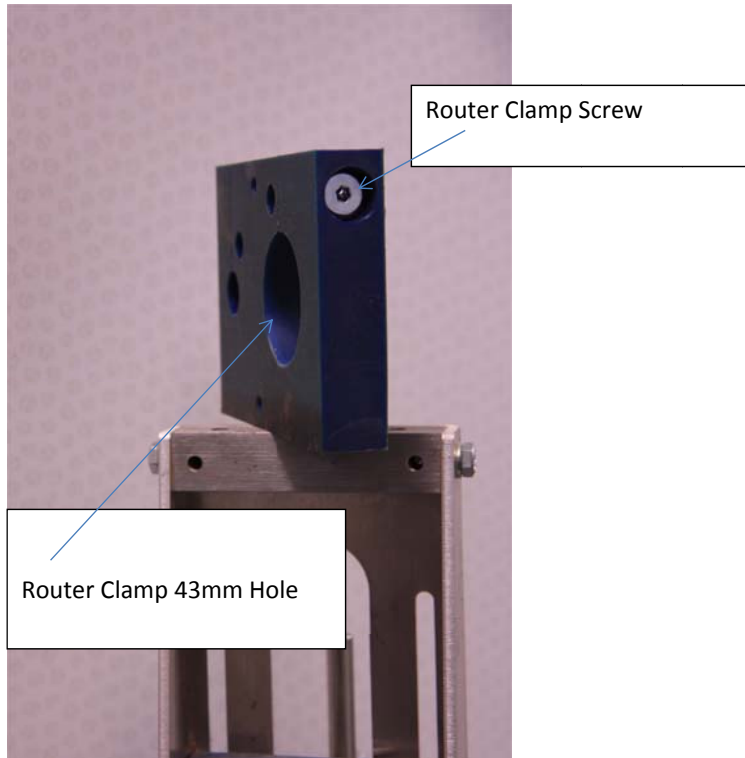
Ensure lathe power is disconnected when using the jig.

Ensure all trailing power cords do not cause a trip hazard or become trapped between the jig and the lathe bed.

## Getting Started

The jig will be supplied with the Router Carrier and Guide assembly removed.

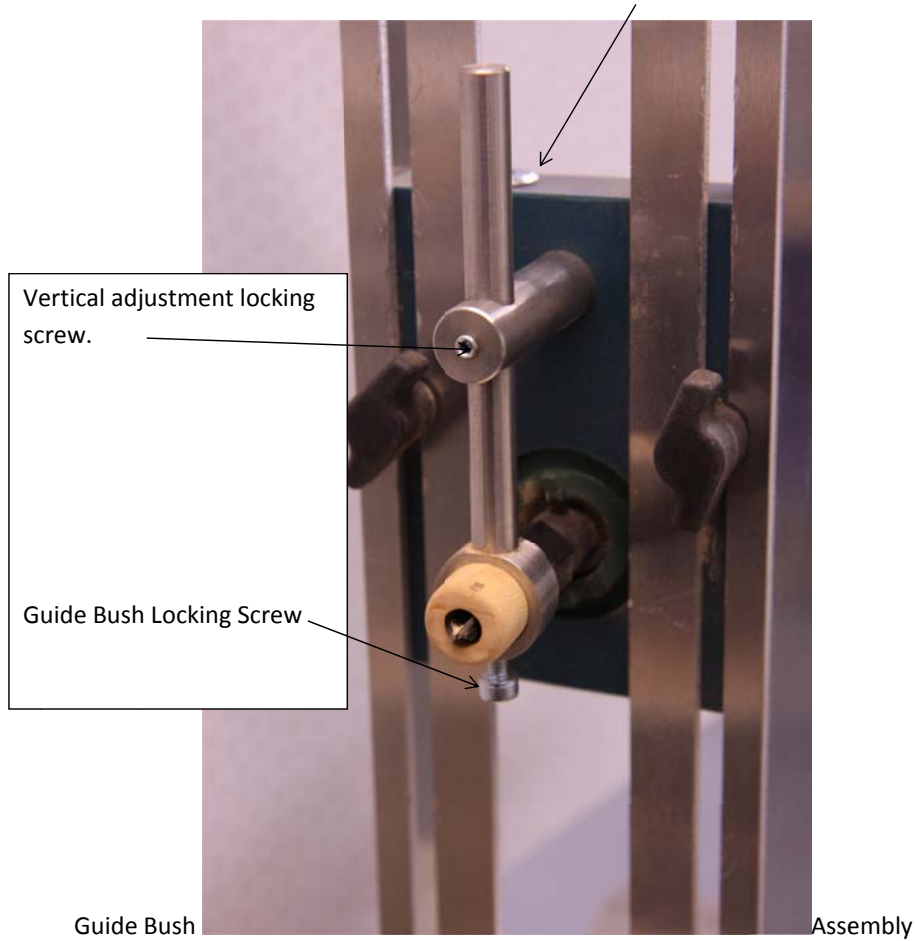
Fit the router to the carrier block checking the collar size is correct.



Refit the Block into the Carrier as shown below and then fit the assembly onto the base in the required position depending on the type of fluting to be carried out. Fit screws finger tight first, then using the allen key provided tighten lightly. **DO NOT OVER TIGHTEN.**  
Fit the Cutter Guide Assembly.

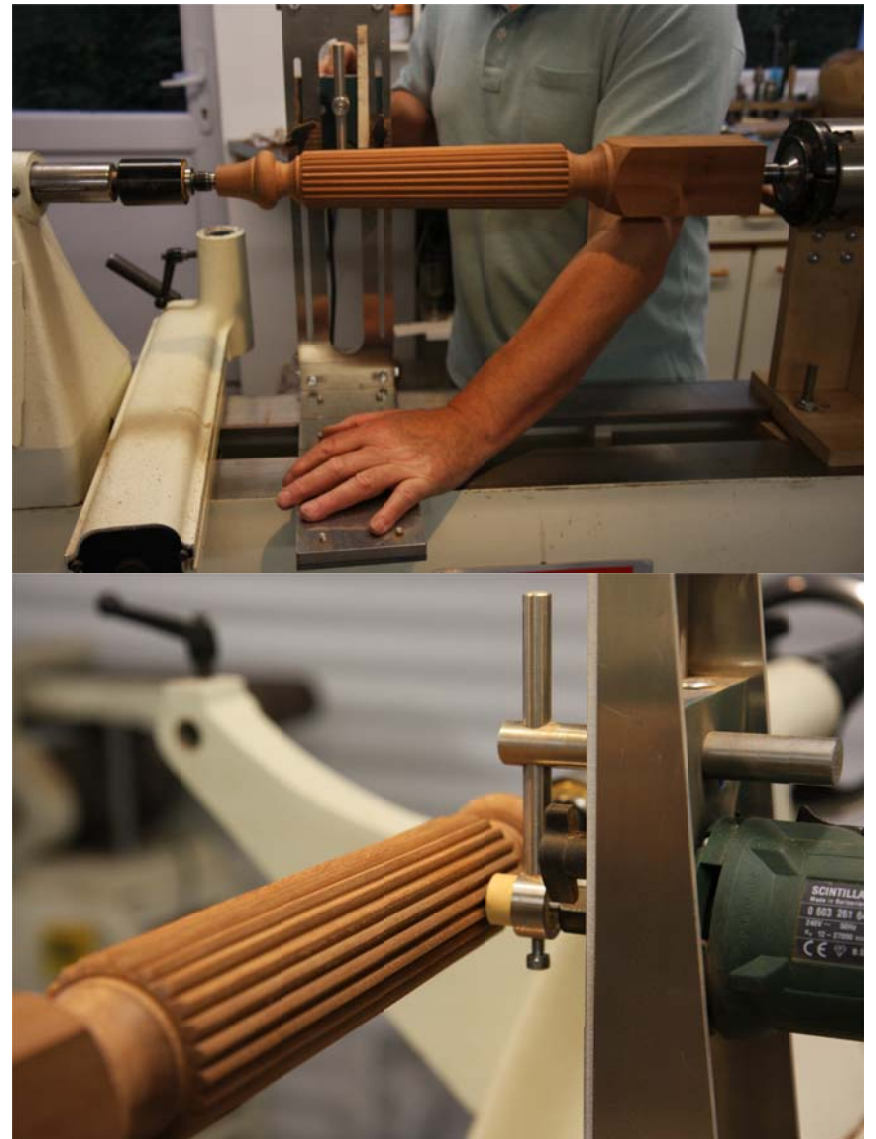
Adjust the guide bush to suit the cutter, guide bushes are made to suit the type of cutter used. Bush design and dimensions are shown at the end of the manual.

Horizontal Guide Bush  
Clamp Screw



Centralise the bush so the cutter is free running with about 1mm (1/16") clearance around the cutter.  
 The Guide Bush will have a groove machined into it to stop the bush pushing back, only tighten bush locking screw with light pressure. Set the grain vertical if wooden bushes are used.

**Setting up on Lathe.**



Router Cutter set to Center Height. One hand supporting Router one hand holding base plate firmly onto lathe bed.  
 Using a Base Board for Fluting or Drilling faceplate work.

Base Board With a back stop fitted to work to a constant position.

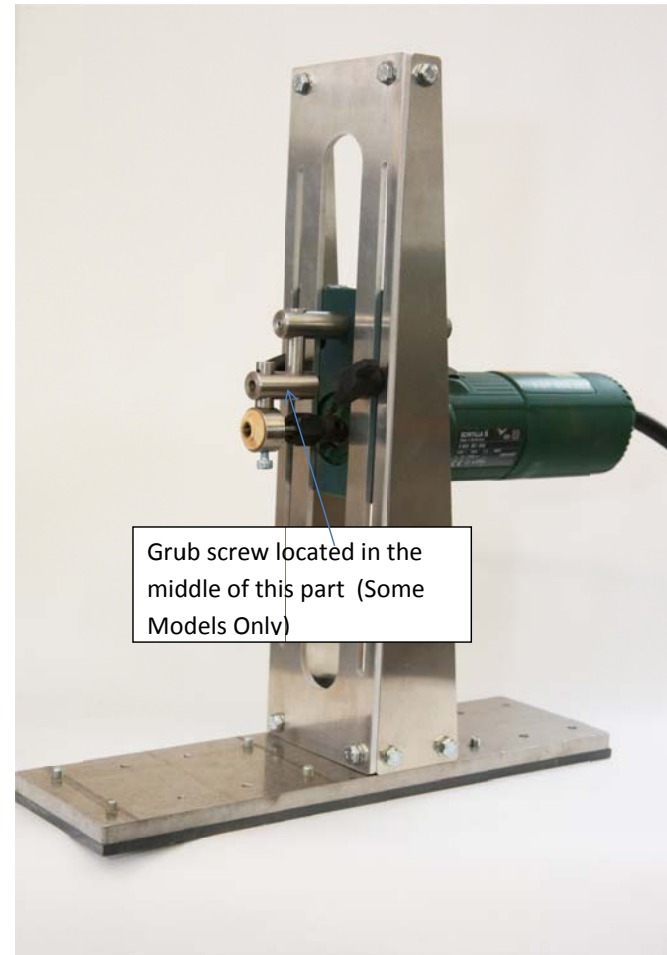
Back Stop.



### **Important**

**Several small light cuts in the correct direction will give very good results and are much easier to control.**

**Disconnect Lathe Power Before Using Jig.**



New offset bush holder. The bush ring stem is held in place by a grub screw in the middle of the short 16mm extension bar, to get to the screw if needed remove the short extension and remove the rear grub screw. The grub screw can now be accessed from the same hole.

Included with the Jig is a 6mm threaded rod nuts and washers, these are used as a micro height adjustment if needed. The rod is passed through the hole in the top block and screwed into the router mounting block and the locked in place with a nut and washer. A nut and washer can then be used on the top of the threaded rod for adjustment (the rod is 1mm pitch so one turn of the nut=1mm)

The bottom of the front plate has also been modified to allow a drill with a 43mm collar to be fitted.



Pass chuck through at this position.



**Simple Swivel Base**

## Examples



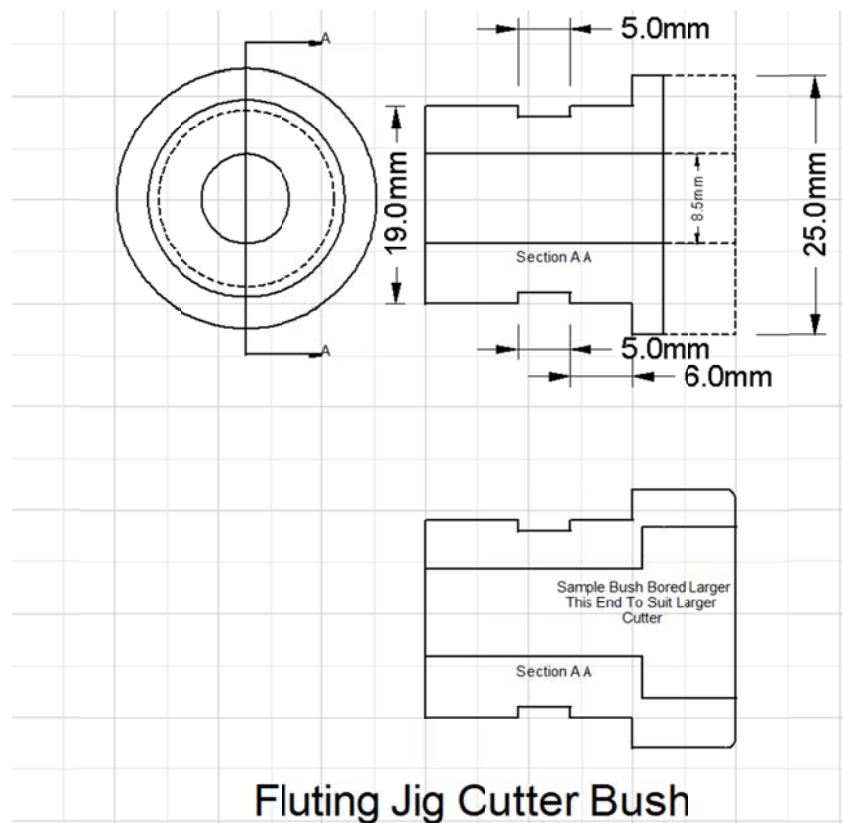
Hollow form with flutes. End stops were fitted to lathe bed to get an even start and finish point. The Guide Bush followed the shape of the form to give an even depth.



Centre Star made with the jig.

If the cutter is to go below the surface of the wood, in other words no material left between flutes, then a guide stop is used.

If no stop is used the final flute will be undersize.



**Fluting Jig Cutter Bush**

Guide bushes can be made from wood nylon or plastic, only light pressure is needed when tightening the locking screw.

1-1.5mm (1/16-1/18") Clearance around the cutter.



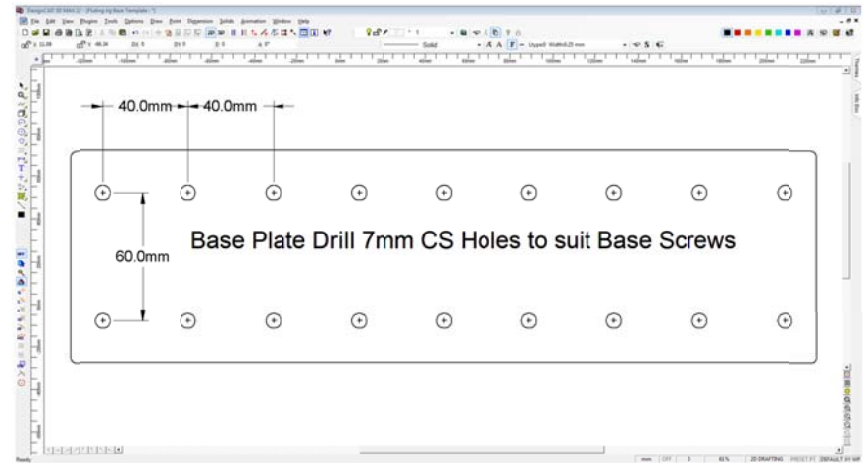
### Base Plate Fixings

The base plate is supplied with 6 CS M6 screws and these can be moved to various positions depending on the position used for the router carrier assembly.

Larger base plates can be made to give more stability if needed or for special types of work.

We suggest if you make a base it should be of sufficient strength and the holes are drilled accurately at 7mm diameter and the countersunk to ensure screw heads are below the surface.

The pitch dimensions are 60mm across and 40mm down.



### Contact Details

Paul Howard Woodturning

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## Notes