Assembling Your Original WorkBee Router Mount

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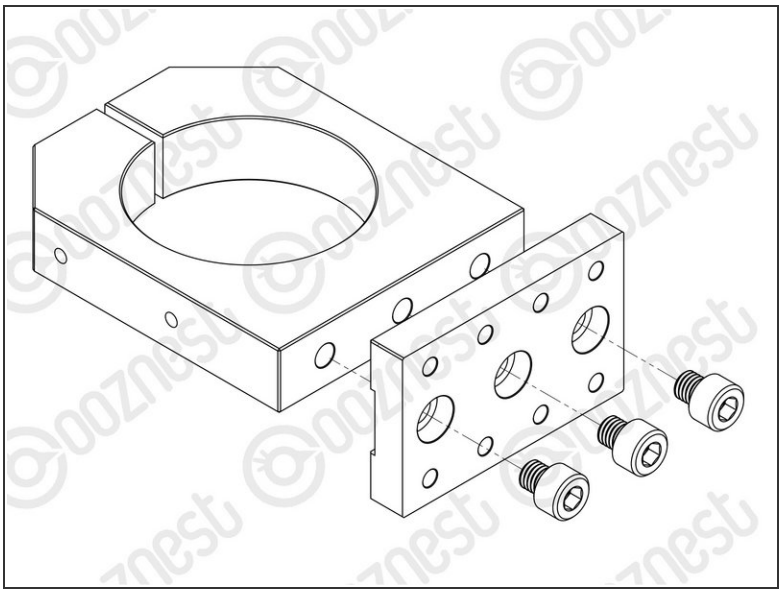
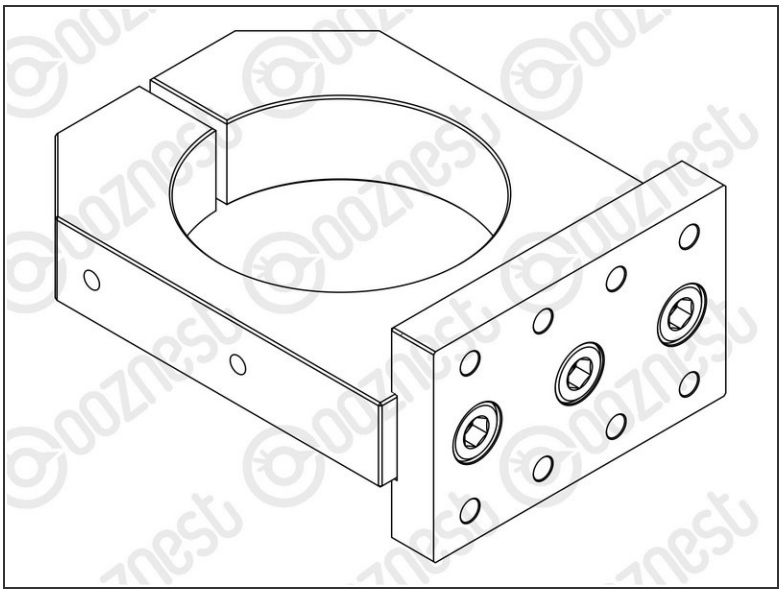
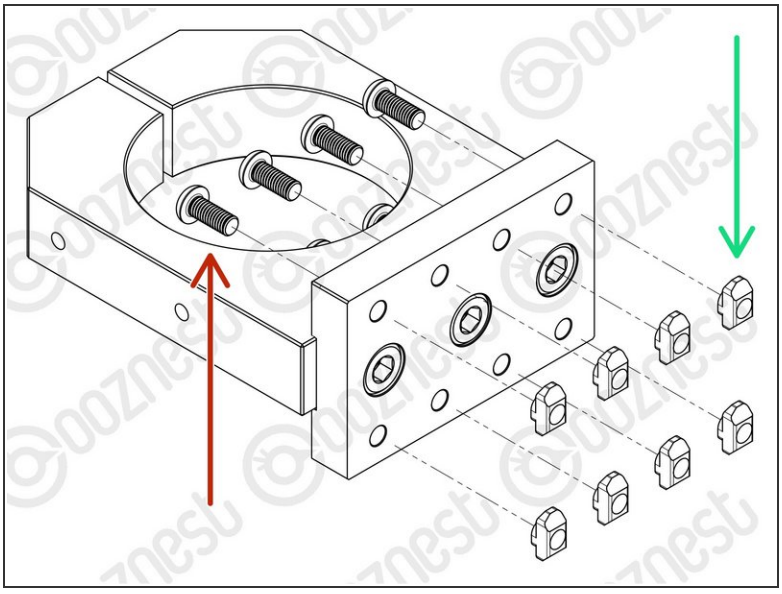
Step 1 — Router Mount Assembly

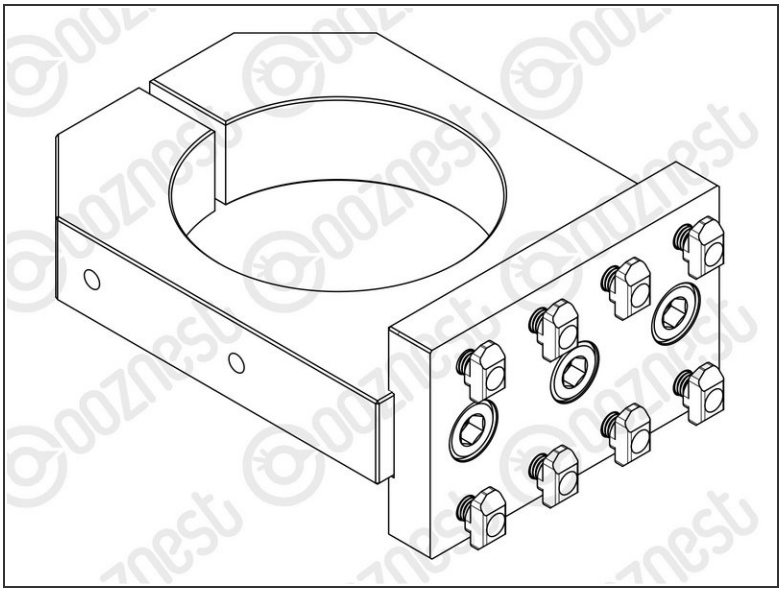




- Attach the Z-Bracket to the Router-Clamp using 3 x M8-Cap-Head-Bolt-8mm. **(Please note in your kit these may be M8-Cap-Head-Bolt-10mm)**

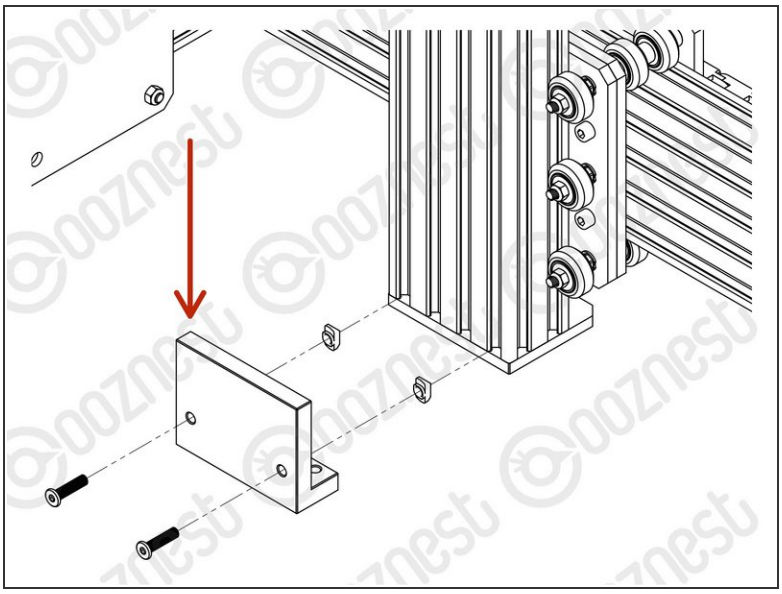
Step 2 — Z-Axis Hardware

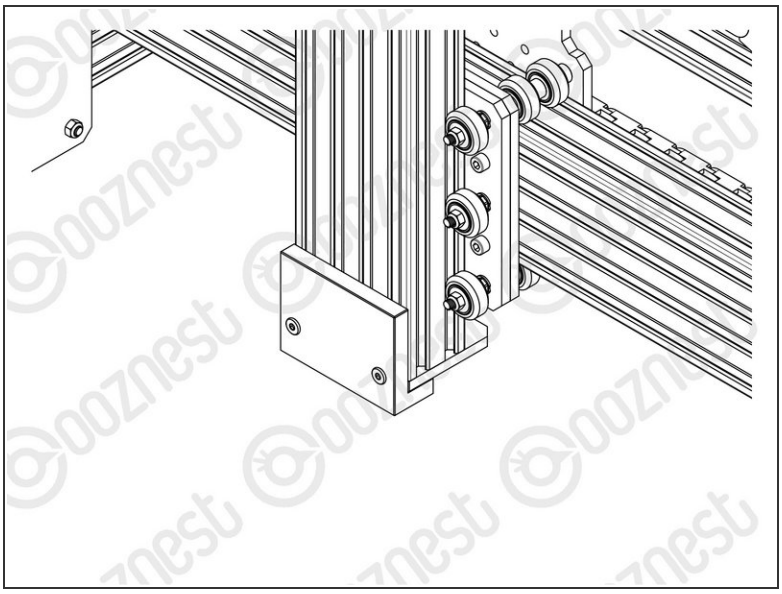




- Insert 8 x M5-Button-Head-Bolt-12mm through the Z-Bracket.
  - Slightly thread a M5-Drop-In-Tee-Nut on to the end of each bolt.

Step 3 — Height Reference Tool





⚠ Reference the correct face of the Height-Reference-Tool for your Router Head.

ⓘ 50.00mm - Katsu/DeWalt/Makita Routers.

ⓘ 17.60mm - Mafell/Kress/Festool Spindles.

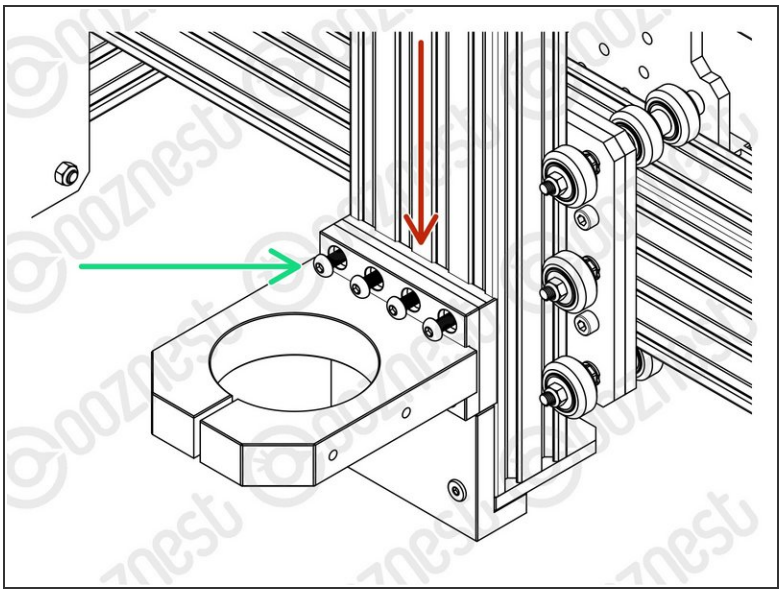
- Attach the Height-Reference-Tool to the bottom of Extrusion-D using 2 x M5-Button-Bolt-12mm and 2 x M5-Drop-In-Tee-Nuts.

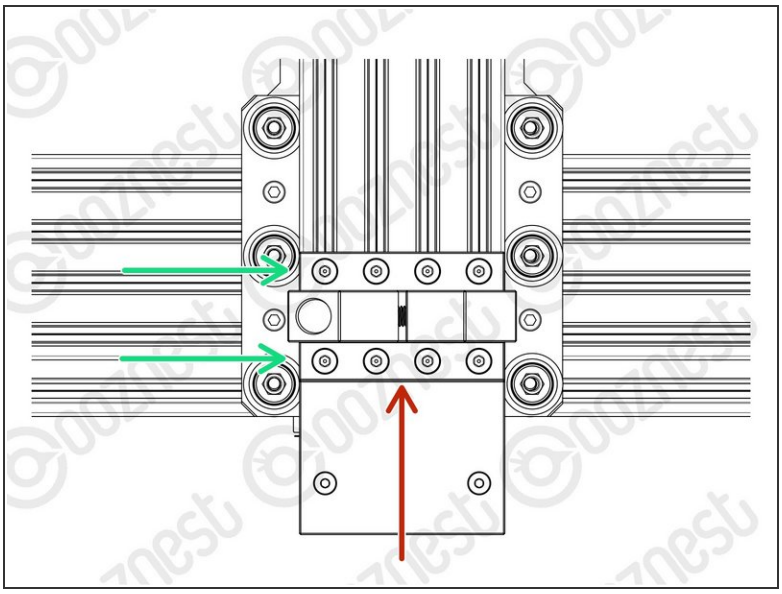
ⓘ The Height-Reference-Tool should be pushed up as high as possible.

⚠ Do not over-tighten the 2 x M5-Button-Bolt-12mm.

ⓘ The Height-Reference tool will be removed later.

Step 4 — Mounting





⚠ On one face of the Router-Clamp there are 4 threaded holes. These should be face down.

- Sit the Router-Mount-Assembly on top of the Height-Reference-Tool.
  - Fix the Router-Mount-Assembly to Extrusion-D.
    - Tighten the 8 x M5-Button-Head-Bolt-12mm inserted previously.

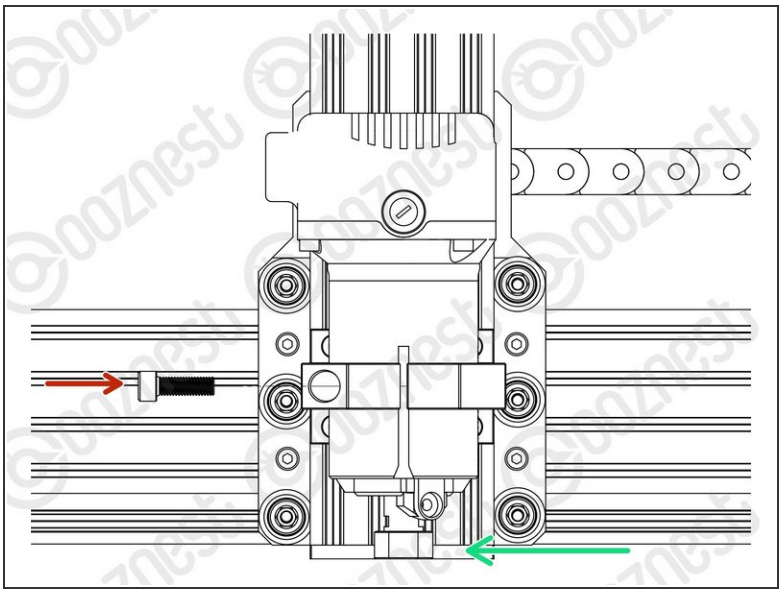
⚠ Make sure M5-Drop-In-Tee-Nuts are engaged with the slots on Extrusion-D.

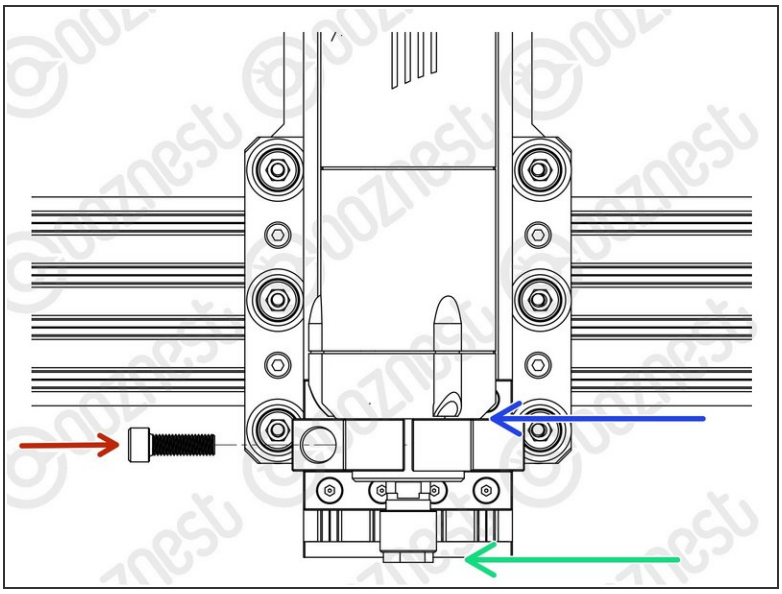
⚠ Remove the Height-Reference-Tool.

ⓘ The Height-Reference-Tool is no longer needed.

ⓘ **But it can come in handy.** It has an etched ruler to measure end mill stick out.

Step 5 — Attaching The Router Head





- Insert the Router Head into the Router-Clamp and tighten the clamp using the M8-Cap-Head-Bolt-25mm.
  - For Katsu/Makita/Dewalt Routers position it with the collet flush with the bottom of the Z-Axis.
  - For Mafell/Kress/Festool Spindles position the body flat on the top of the Router-Clamp.

⚠ **Do not overtighten the Router-Clamp.**

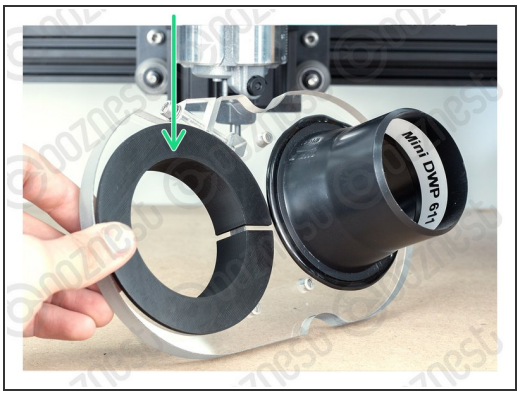
⚠ It should be tightened no more than the point that the Router Head can no longer be rotated by hand.

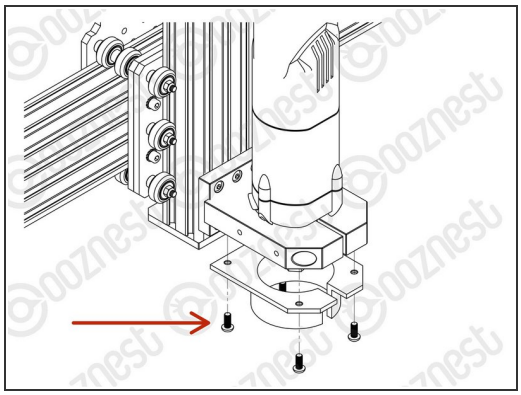
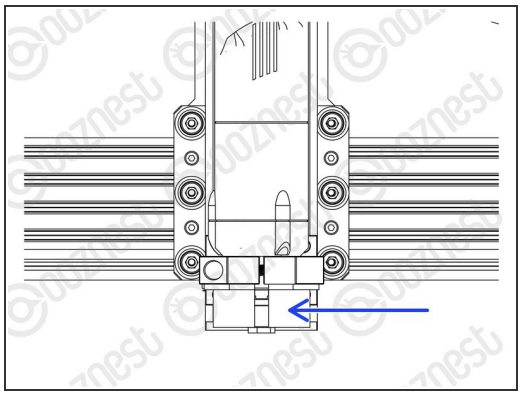
⚠ Any tighter and you will run the risk of pre-maturely wearing the brushes of the Router Head.

ⓘ The power wire of the Router Head should run vertically up to the ceiling. If you have a Dust Shoe, it can be clipped to the extractor hose.

⚠ Do not put the power wire inside the drag chains of the machine. It is a high power wire and should not run alongside the other wires.

Step 6 — Dust Shoe Adaptors



Dust-Shoe-Adaptors will be included in the 65mm (Katsu/Makita) and 43mm (Mafell/Kress/Festool) versions of the Router Mount.

- Katsu
  - The 65mm Dust-Shoe-Adaptor sits inside the Dust Shoe. The Dust Shoe is then clamped around the body of the Katsu/Makita Router.
- Mafell
  - This should only be installed if you have a Dust Shoe.
  - Attach the 43mm Dust-Shoe-Adaptor to the underside of the Router-Clamp using 4 x M5-Button-Head-5mm Bolts.
  - The Dust Shoe clamps around the circular portion of the 43mm Dust-Shoe-Adaptor.

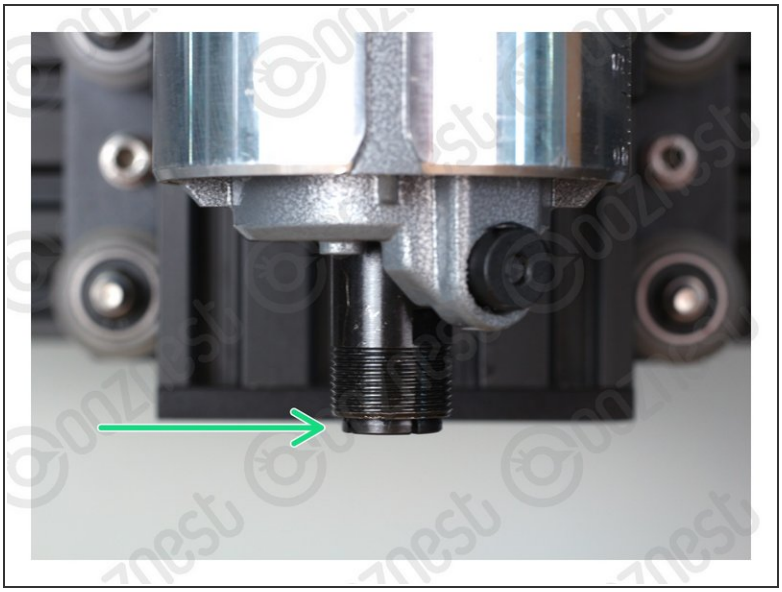
Step 7 — "Breaking In" The Router Head

The Mafell FM 1000 is broken in by the Manufacturer so is ready for use.

For the Katsu, we recommend running it at a medium RPM, with no load, for 30-60 minutes.

⚠ Remove the collet while doing this so it does not come off.

Step 8 — Collets



⚠ Always use the correct collet size for the cutter.

- Mafell
  - Click the collet into the nut first, then insert the end mill fully.
  - Fix the collet with a maximum torque of 10-11Nm. Tighten the collet by hand, then a 1/8 turn with a spanner, this should be about right.
  - Keep the collet lubricated with a solid lubricant (e.g. Molykote P-40) or by lightly greasing.
- Katsu
  - Push the collet into the shaft and then the nut over it. The end mill can then be inserted fully.
  - Only use the button on the side to hand tighten the collet. To fully tighten, use two spanners, a 13 spanner on the flat portion of the shaft, the included 22mm spanner on the collet nut.

Thanks for following the guide. Any issues, please contact us!

