

# UJK BLANK UNIVERSAL SUB BASE

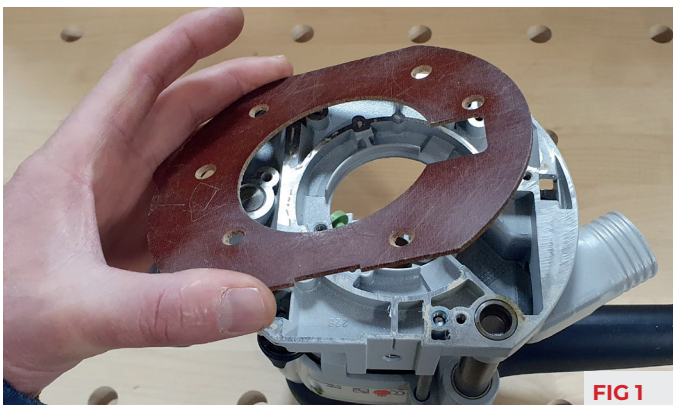


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## Step 1 – Marking up

It is extremely important to accurately centre & mark the UJK Blank Universal Sub Base in preparation for drilling, for this there are two methods.

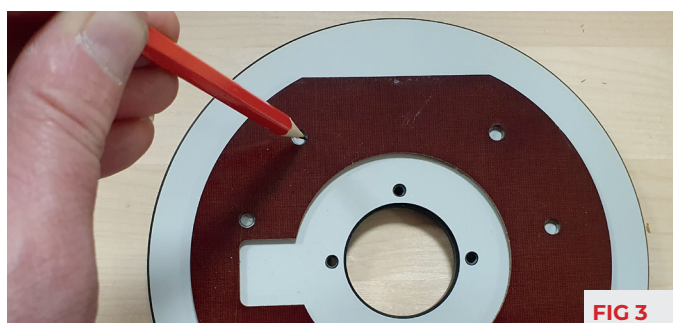
The flat edge of the UJK Blank Universal Sub Base is designed to be positioned at the back of the router, this will prevent the router base contacting the clamp bar if being used with a Dovetail jig.



### Method 1 -

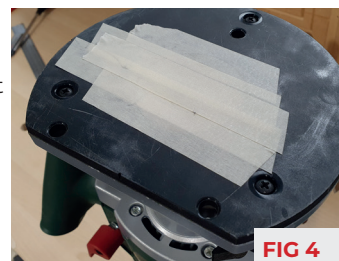
- Remove the routers base plate retaining the screws and taking note of the back of the base plate, mark up if preferred. **FIG 1**

- With the UJK Blank Universal Sub Base placed face (UJK logo) down place the router base on top ensuring that the back of the base plate and the flat edge of the UJK Blank Universal Sub Base are together, accurately measure to ensure that the two base are centred to each other, then without moving base carefully mark up the required screw holes to be used. **FIGS 2 & 3**

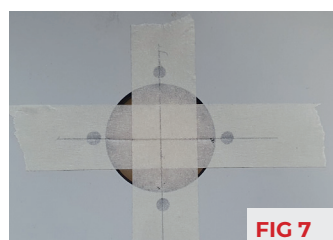


### Method 2 -

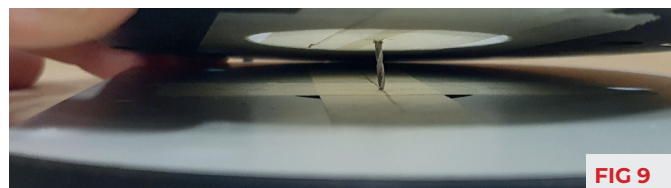
- If your routers base is an unusual shape or it is difficult to find the centres of both bases, tightly apply masking tape over the centre of the routers base before it is removed. **FIG 4**



Using a Vee cutter or small straight cutter plunge the cutter down to make a centre mark in the masking tape, then remove the router base plate retaining the screws. **FIGS 5 & 6**

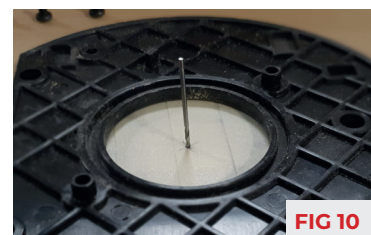


- Tightly apply masking tape over the centre hole of the UJK Blank Universal Sub Base, then carefully mark up the centre using the four guide bush screw holes as guidance. **FIGS 7 & 8**



- To centrally align the two bases, pierce a small drill bit through the centre marked on the tape in the routers base, then carefully pierce the drill bit through the centre point you have marked in the tape on the UJK Blank Universal Sub Base. **FIG 9**

- Position the router base so that the drill bit is upright. **FIG 10**



- Without moving either of the bases carefully mark up the required screw holes. **FIG 11**



- Mark the centre of each hole with a bradawl. **FIG 12**





## Step 2 – Drilling & Counter Sinking

It is recommended to use a pillar drill with a depth stop keep the holes accurate and control the depth of the counter sink/counterbore, clamping the UJK Blank Universal Sub Base when drilling & countersinking is also advised. Why not try all drilling & countersinking on a scrap piece of timber to ensure that depths are set correctly.

It is also recommended to use a bradawl to mark up the drilling points, this will stop the drill bit from skidding on the surface.

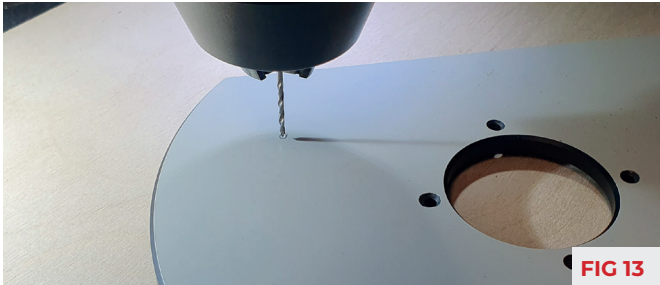


FIG 13

- Pilot drill the marked points with a 2mm or 3mm drill bit, it is recommended to use a scrap backing board under the UJK Blank Universal Sub Base to prevent excessive break out. **FIG 13**



FIG 14

- Drill out to the final hole / screw size – to allow side to side movement for centre alignment it is recommended to drill out 1mm larger than the screw thread. **FIG 14**

E.g. M4 drill out to 5mm, M5 drill out to 6mm

Countersink/counterbore from the outside face (UJK Logo side)

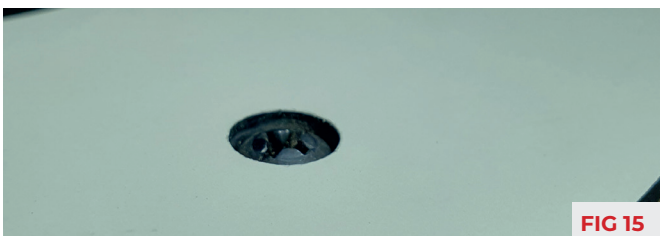


FIG 15

- Countersink / counter bore the drilled holes so that the screw that are to be used sit just below the surface. **FIG 15**

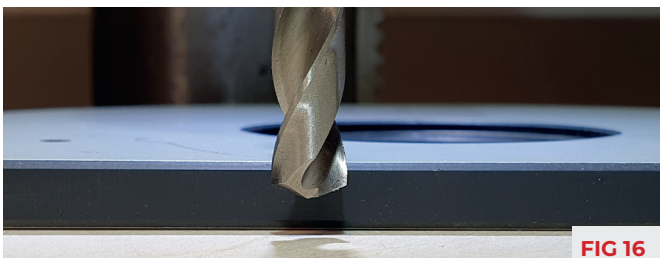


FIG 16

- Do not countersink too deeply into the surface as this could compromise the strength of the screw hole area, around halfway through is recommended. **FIGS 16 & 17**



FIG 17



FIG 18



FIG 19

- If the original screws don't appear to be long enough (5 threads protruding) then longer screws will be needed, we recommend the **UJK Fixings Kit (508626)**. **FIGS 18 & 19**

## Step 3 - Fitting & Centring

- Loosely attach the UJK Blank Universal Sub Base and guide bush adaptor to your router – do not tighten. **FIG 20**



FIG 20

- Use a centring cone to perfectly centre the UJK Blank Universal Sub Base and guide bush to the router spindle / shaft. **FIG 21**

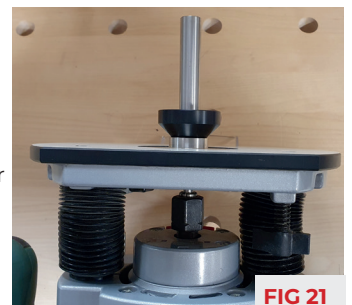


FIG 21



FIG 22

- Centring the UJK Blank Universal Sub Base can also be done by plunging the router fully and measuring against a cutters shank and the edge of the inner aperture. **FIG 22**
- Once centred tighten up all screws.