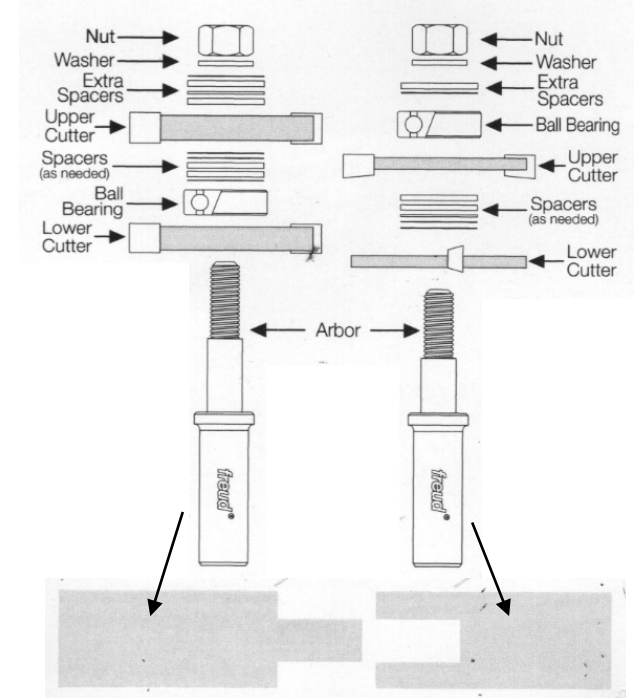


# Adjusting Tongue & Groove Thickness with your 99-036 Set

Each bit in your Freud Adjustable Tongue and Groove Set is comprised of a 5/16" arbor, two cutters, one ball bearing, one 5/16" flat washer, a nut and a total of 11 spacers of various thicknesses as listed in the chart below. The spacers are used between the cutters to allow for adjustment to produce grooves and mating tongues from 7/32" to 3/8" thick. The bits come to you assembled to rout 7/32" grooves and tongues. Use the chart below to select spacers to increase the thickness to the nominal dimensions shown. Once you add these spacers and tighten the nut, make test cuts, then adjust the number of spacers if necessary to achieve the desired fit. Always ensure that the bits are assembled according to the drawings at right, and that the nut is securely tightened on the arbor before installing the bit in the router.

**Be sure to read and follow the safety warnings that came with your bit set and your router!**



Freud 99-036			To Achieve these nominal Tongue & Groove thicknesses, use the number of spacers listed for each of the spacer thicknesses shown on the left side of the chart. Make a test cut, then make minor adjustments to the number of spacers if needed.										
			7/32" or 5.5mm	15/64" or 6.0mm	1/4" or 6.35mm	17/64" or 6.75mm	9/32" or 7.15mm	19/64" or 7.55mm	5/16" or 7.95mm	21/64" or 8.35mm	11/32" or 8.75mm	23/64" or 9.15mm	3/8" or 9.5mm
Spacer Dimensions:			Number of spacers to use:	Number of spacers to use:	Number of spacers to use:	Number of spacers to use:	Number of spacers to use:	Number of spacers to use:	Number of spacers to use:	Number of spacers to use:	Number of spacers to use:	Number of spacers to use:	
Spacer thickness, metric	Spacer thickness, inches	# of Spacers included w/each bit											
1.0 mm	0.039"	4	0	0	0	1	1	1	2	2	3	3	4
0.5 mm	0.020"	1	0	1	1	0	1	1	0	1	0	1	0
0.2 mm	0.008"	2	0	0	1	0	0	2	1	1	0	0	0
0.15 mm	0.006"	2	0	0	1	1	1	1	1	1	1	1	0
0.1 mm	0.004"	2	0	0	0	1	0	0	1	0	1	0	0