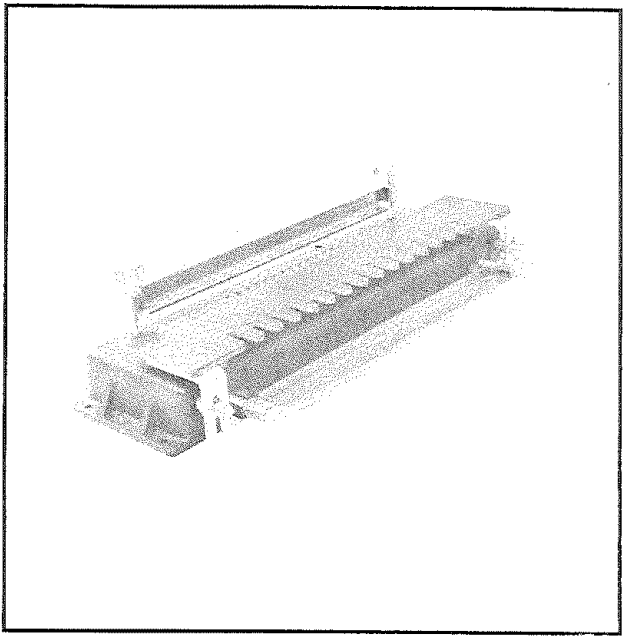
SEARS

OWNERS
MANUAL

MODEL NO.
315.25790

CAUTION:
Read Rules for
Safe Operation
and Instructions
Carefully

SAVE THIS
MANUAL FOR
FUTURE REFERENCE



CRAFTSMAN®

DOVETAIL TEMPLATE

FOR USE WITH ALL CRAFTSMAN ROUTERS

Introduction
Operation
Repair Parts

Sold only by
SEARS, ROEBUCK AND CO., Hoffman Estates, IL 60179

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RULES FOR SAFE OPERATION

⚠WARNING: DO NOT ATTEMPT TO OPERATE UNTIL YOU HAVE READ THOROUGHLY AND UNDERSTAND COMPLETELY ALL INSTRUCTIONS, SAFETY RULES, ETC. CONTAINED IN THIS MANUAL. FAILURE TO COMPLY CAN RESULT IN ACCIDENTS INVOLVING FIRE, ELECTRIC SHOCK, OR SERIOUS PERSONAL INJURY. SAVE OWNERS MANUAL AND REVIEW FREQUENTLY FOR CONTINUING SAFE OPERATION, AND INSTRUCTING POSSIBLE THIRD PARTY USER.

1. **DISCONNECT TOOLS.** When not in use, before assembling, before servicing, or when changing attachments, blades, bits, cutters, etc., all tools should be disconnected.
2. **BE SURE ALL ADJUSTMENTS ARE PROPERLY SET AND SECURELY FASTENED.**
3. **KEEP GUARDS IN PLACE** and in working order.
4. **KEEP WORK AREA CLEAN.** Cluttered areas and benches invite accidents.
5. **AVOID DANGEROUS ENVIRONMENT.** Don't use power tool in damp or wet locations or expose to rain. Keep work area well lit.
6. **KEEP CHILDREN AWAY.** All visitors should wear safety glasses and be kept a safe distance from work area. Do not let visitors contact tool or extension cord.
7. **STORE IDLE TOOLS.** When not in use, tools should be stored in a dry, high or locked-up place — out of the reach of children.
8. **WEAR PROPER APPAREL.** No loose clothing or jewelry to get caught in moving parts. Rubber gloves and footwear are recommended when working outdoors. Also, wear protective hair covering to contain long hair.
9. **USE SAFETY GLASSES** with all tools. Also face or dust mask if operation is dusty.
10. **SECURE WORK.** Use clamps or a vise to hold work. It's safer than using your hand and it frees both hands to operate tool.
11. **DON'T OVERREACH.** Keep proper footing and balance at all times. Do not use on a ladder or unstable support.
12. **NEVER USE IN AN EXPLOSIVE ATMOSPHERE.** Normal sparking of the motor could ignite fumes.
13. **KEEP TEMPLATE DRY, CLEAN, AND FREE FROM OIL AND GREASE.**
14. **STAY ALERT.** Watch what you are doing and use common sense. Do not operate tool when you are tired. Do not rush.
15. **DRUGS, ALCOHOL, MEDICATION.** Do not operate tool while under the influence of drugs, alcohol, or any medication.
16. **CHECK FREQUENTLY DURING OPERATION TO INSURE REQUIRED POSITION AND TO PREVENT HOLDING MECHANISM FROM BECOMING LOOSENED.**
17. **SECURE** Dovetail Template to a workbench. *See Figures 5 & 6,* Page 4.
18. **SAVE THESE INSTRUCTIONS.**

⚠WARNING:

The operation of any Power Tool can result in foreign objects being thrown into your eyes, which can result in severe eye damage. Before commencing power tool operation, always wear safety goggles or safety glasses with side shields and a full face shield when needed. We recommend Wide Vision Safety Mask for use over eyeglasses or standard safety glasses with side shields, available at Sears Catalog Order or Retail Stores.

INTRODUCTION

⚠WARNING: ALWAYS WEAR SAFETY GOGGLES OR SAFETY GLASSES WITH SIDE SHIELDS WHEN OPERATING YOUR POWER TOOL.

ASSEMBLY

Unpack your dovetail template, separating and removing all loose parts from the packaging materials. Check each item with the "Table of Loose Parts" to make sure all items listed have been packed with your dovetail template. *See Figure 1.*

ASSEMBLE YOUR DOVETAIL TEMPLATE AS FOLLOWS:

1. Insert hex bolts through holes in your dovetail base and fit into molded slots on bottom side of base.
2. Secure hex bolt with push nuts supplied. *See Figure 1.*
3. Place one spring over each hex bolt.
4. Place a washer on top of each spring, then install clamp bar on top of washer. **NOTE:** For proper assembly, be sure to turn each clamp bar as shown in Figure 1.
5. Place a second washer on top and/or end of each clamp bar.
6. Thread wing nut onto each hex bolt to secure washers, clamp bars, and springs.

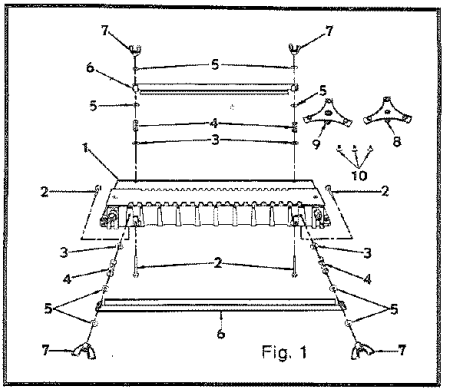


Fig. 1

TABLE OF LOOSE PARTS

Item No.	Description	Quantity
1	Dovetail Template	1
2	Hex Bolt (#1/4-20 x 2-7/8")	4
3	Push Nut	4
4	Spring	4
5	Washer	8
6	Clamp Bar	2
7	Wing Nut	4
8	5/16" Guide Bushing	1
9	7/16" Guide Bushing	1
10	Screw (10-32 x 1/2" Flat Head)	3

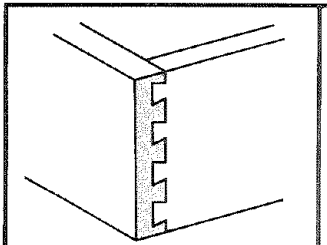
Your dovetail template has been designed for cutting flush, offset, or rabbeted joints with speed and accuracy. *See Figures 2, 3, & 4.* Since these joints are both strong and neat, they are commonly used when making drawers and boxes.

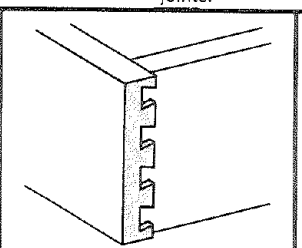
Read all instructions carefully, and follow closely while making set ups and adjustments. ONCE ALL ADJUSTMENTS HAVE BEEN PROPERLY MADE, MAKE A TRIAL CUT WITH SCRAP PIECES OF THE SAME WOOD USED FOR THE FINISHED WORK.

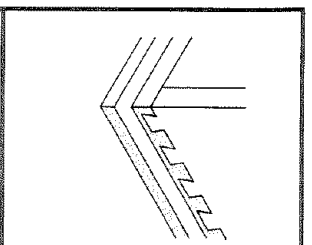
This step allows you to check your adjustments. It also makes you aware of the characteristics of the particular wood being used.

TOOLS NEEDED

In addition to your dovetail template and guide bushing, you will also need a Craftsman Router and a dovetail cutter. Use dovetail cutter Catalog Number 26319 for making 1/4 inch dovetail joints and Catalog Number 26318 for making 1/2 inch joints.


FLUSH JOINT Fig. 2


OFFSET JOINT Fig. 3


RABBETED JOINT Fig. 4

OPERATION

MOUNTING DOVETAIL TEMPLATE

FOR SAFE OPERATION AND PROPER CONTROL, YOUR DOVETAIL TEMPLATE MUST BE MOUNTED TO A WORKBENCH OR TABLE. If desired, it can be clamped to a workbench with "C" clamps, or it can be mounted onto a 3/4 inch piece of plywood for mobility. *See Figures 5 & 6.*

1. Clamp your dovetail template to a workbench or table with "C" clamps as shown in Figure 5. It can then be easily removed upon completion for easy storage or changing job sites.
2. A second, more preferred, method would be to mount your dovetail template onto a piece of 3/4 inch plywood approximately six inches wide and twenty-four inches long. *See Figure 6.* Position front of base flush with the front and centered with the ends of the board, then insert four flat head wood screws through holes in the base and secure firmly into plywood. Your dovetail template (with wooden base) may then be clamped securely to workbench or table with "C" clamps or other holding apparatus. Here again, it can be easily removed upon completion for easy storage or changing job sites.

INSTALLING TEMPLATE GUIDE BUSHING AND CUTTER

Two template guide bushings are supplied with your dovetail template. They are used to guide your router in and out of the fingers of the comb-shaped template. The 5/16 inch bushing is used when making 1/4 inch dovetails, while the 7/16" bushing is used when making 1/2" dovetails.

TO AVOID POSSIBLE SERIOUS PERSONAL INJURY, UNPLUG YOUR ROUTER WHILE ASSEMBLING PARTS OR MAKING ADJUSTMENTS

1. Attach guide bushing directly to the inside of the subbase. *See Figure 7.* **NOTE:** It is not necessary to remove subbase while attaching guide bushing, but be sure collar section is turned facing away from the router motor.
2. Secure bushing to the subbase with the 3 screws supplied.
3. Insert dovetail cutter through guide bushing and into collet at least 1/2 inch. If 1/2 inch engagement does not exist, lower the router motor in the router base until collet nut is approximately 1/8 inch clear of guide bushing.
4. Tighten clamping wing nut securely before attempting to center cutter inside guide bushing. If clamping wing nut is not tight, the router motor will be loose and wobble inside router base while adjustments are being made.
5. Visually center the cutter with the inside diameter of the guide bushing, then tighten the collet nut securely. **NOTE:** When centering cutter in guide bushing, adjustments can be made by loosening the screws holding the subbase to the router and/or loosening the screws holding the guide bushing to the router.
6. Tighten all screws securely.

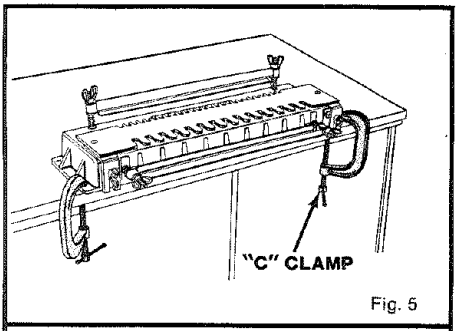


Fig. 5

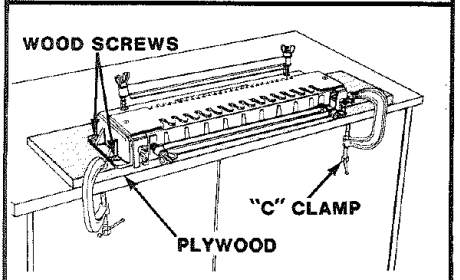


Fig. 6

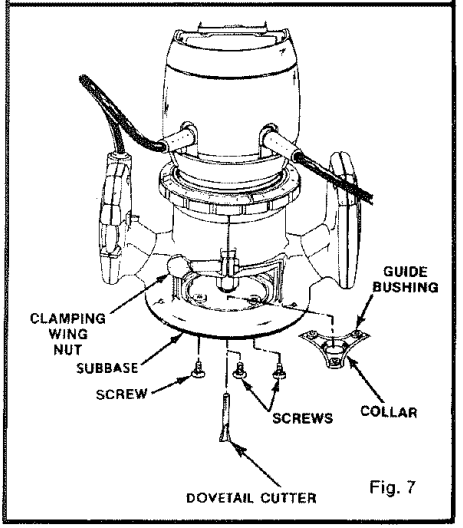


Fig. 7

OPERATION

BEGIN YOUR SET-UP

To begin your set-up, you will need to determine what the final dimensions for your drawer or box will be, then cut your boards to size. If you plan in advance, try to size the drawer opening so that a half-pin will be on both the top and bottom edge of the drawer front. See helpful hints, page eleven. See the chart below for computing proper sizes and recommended material thicknesses.

Next, decide whether you are going to make 1/4" or 1/2" joints. Your dovetail template is packaged with the angle brackets set for making 1/2" joints. If 1/4" joints are desired, loosen the two screws holding the angle brackets, and reverse them 180°. *See Figure 8.* Re-tighten angle bracket screws. Reverse the procedure when changing your template from 1/4" joints to 1/2" joints.

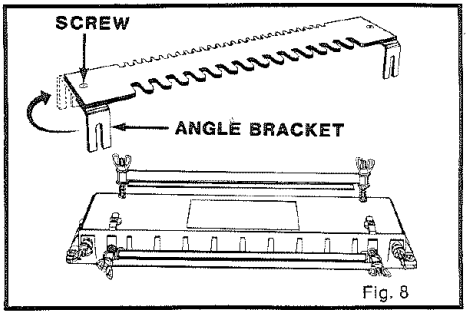
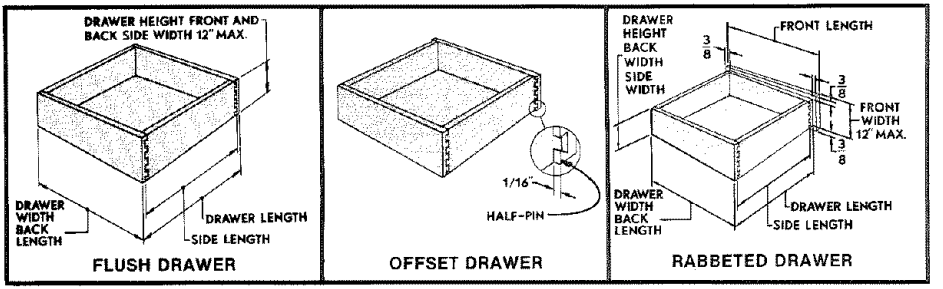


Fig. 8



1/2" DOVETAIL JOINTS

SECTION	RECOMMENDED THICKNESS	LENGTH	WIDTH
Back	1/2" to 3/4"	Width of opening less clearance	Height of opening less clearance
Sides	1/2" to 3/4"	Must be determined for each job depending on depth of opening, clearance, and thickness of front and back.	Same as Back
Bottom	1/4" to 3/8"	Length of side less 1/4"	Length of back, plus 1/2" less 2 times side thickness
Flush Front	1/2" to 3/4"	Same as Back	Same as Back
Offset-Front	1/2" to 3/4"	Back Length plus 1/8",	Same as Back
3/8 Inch Rabbeted Front	3/4"	Back Length plus 3/4"	Back width plus 3/4",

NOTE: Front, back and sides should be grooved 1/4 inch deep to receive bottom piece and may be done before or after dovetailing. If groove depth is more or less than 1/4 inch, bottom dimensions must be altered to compensate.

1/4" DOVETAIL JOINTS

SECTION	RECOMMENDED THICKNESS	LENGTH	WIDTH
Back	5/16" to 3/4"	Width of opening less clearance	Height of opening less clearance
Sides	1/4" to 1/2"	Must be determined for each job depending on depth of opening, clearance, and thickness of front and back.	Same as Back
Bottom	1/4"	Length of side less 1/4"	Length of back, plus 1/2" less 2 times side thickness
Flush Front	5/16" to 3/4"	Same as Back	Same as Back
Offset-Front	5/16" to 3/4"	Back Length plus 1/8",	Same as Back
3/8 Inch Rabbeted Front	1/2" to 3/4"	Back Length plus 3/4"	Back width plus 3/4"

NOTE: Front, back and sides should be grooved 3/16 inch deep to receive bottom piece and may be done before or after dovetailing. If groove depth is more or less than 3/16 inch, bottom dimensions must be altered to compensate.

Operation

REFERENCE GUIDE

The base of your dovetail template has a label to serve as a guide for you to follow when making set-ups for different types of joinery. Familiarize yourself with this label and refer to it as often as necessary. *See Figure 9.*

FLUSH FRONT DRAWER OR BOX

⚠WARNING: UNPLUG ROUTER FROM POWER SUPPLY WHILE ASSEMBLING PARTS OR MAKING ADJUSTMENTS. FAILURE TO DO SO COULD RESULT IN ACCIDENTAL STARTING OF YOUR ROUTER CAUSING DAMAGE TO THE WORK SURFACE OR POSSIBLE SERIOUS PERSONAL INJURY.

1. Attach guide bushing with 7/16" pilot diameter to router base (5/16" pilot diameter for 1/4" joints). Insert the dovetail cutter bit through the guide bushing and into chuck collet at least 1/2 inch, then tighten securely. See **INSTALLING TEMPLATE GUIDE BUSHING AND CUTTER,** Page 4.
2. Adjust the base on your router until the cutter extends 17/32 inch beyond the router subbase for 1/2" joints. Adjust 7/16 inch beyond the router subbase for 1/4" joints. *See Figure 10.*
3. Loosen the stop screws and place the 3 way stop on top of your dovetail template and the 2 way stop on the side of your dovetail template in their proper position. *See Figures 9 & 11.* Re-tighten stop screws securely.
4. Mark the boards for the drawer or box on the inside with identifying letters near the bottom edge. *See Figure 12.*
   NOTE: The reverse sides of the board will be the outside of the finished drawer or box. The outside of the boards are always clamped towards the dovetail base and all pieces are routed in an "inside-out" position. The boards are then reversed to assemble.
   NOTE: The material for front (B) and back (D) should be the same size and should be cut to fit the opening neatly. The side pieces (A and C) should also be the same size. See the chart on Page 5 for computing proper sizes and recommended material thicknesses.
5. Insert board (A) between front clamping bar and front surface of dovetail base with bottom edge toward the left 2 way stop. Temporarily clamp board (A) "inside-out" to the left front of the fixture so that it extends above the base. *See Figure 13.* This is done to assist in the proper positioning of board (B).
6. Insert board (B) between top clamping bar and top surface of dovetail base, with bottom edge against left 3 way stop, and flush with extended portion of board (A). *See Figure 13.*
7. Tighten wing nuts (E) on top clamping bar to hold board (B) securely.

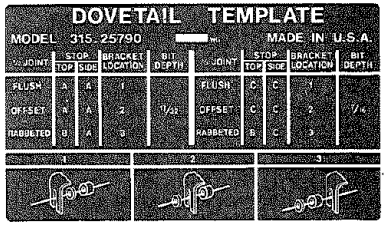


Fig. 9

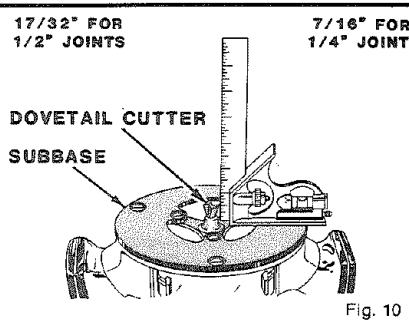


Fig. 10

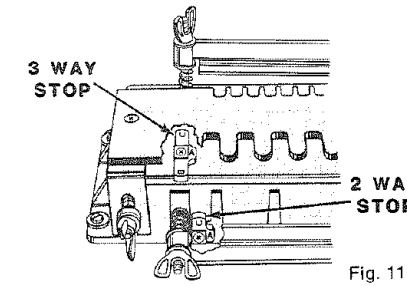


Fig. 11

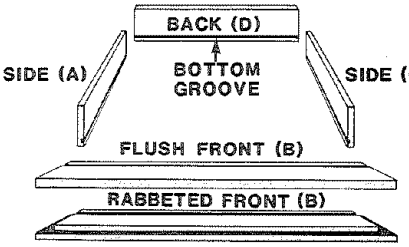


Fig. 12

Operation

8. Relocate board (A) so that it is flush with the top of board (B) and against 2 way stop on left front of dovetail base. *See Figure 14.*
9. Tighten front wing nuts (E) to hold board (A) securely.
10. Attach comb-shaped template (F) to the dovetail base with washers (G) & spacers (H) in their desired location. *See Figure 15.*
11. Hold the template flat on the boards with one hand, and tighten template wing nuts (E) securely. **NOTE:** Be sure template finger ends are parallel to edge of board (B) to assure even fitting after cutting.

ROUTING YOUR FLUSH DOVETAIL JOINTS

You are now ready to rout your first dovetail joint. As mentioned earlier, you should make a trial cut with scrap pieces of the same wood used for the finished work. Using scrap pieces allows for adjustments to be made in steps 1 thru 7.

1. Place your router so that the subbase is resting flat on the dovetail template. Make sure the cutter is not making contact with the edge of board (A), then turn your router on and let the motor build to its full speed.
2. Make a straight cut from **RIGHT TO LEFT** across board (A). *See Figure 16.* This shallow V-groove cut is made to prevent chipping of the wood when the router is moved in and out of the fingers of your dovetail template. **NOTE:** When making 1/4" dovetails, one or two extra passes may be necessary to cut away excess stock projecting beyond the fingers of the template.

⚠WARNING: USE CAUTION WHEN OPERATING ROUTER AT EITHER EXTREME END OF DOVETAIL TEMPLATE. YOUR DOVETAIL CUTTER WILL MAKE CONTACT WITH ANGLE BRACKET IF MOVED TOO FAR OUTSIDE FIRST OR FINAL CUT.

3. Cut your dovetail joint. Feed your router in and out each finger, moving from left to right.
4. Recut the dovetail moving your router from right to left. This will clean off any spots or imperfections that might have been missed.
5. To prevent possible serious injury or damage to your dovetail template, wait until the cutter has completely stopped before removing your router. When removing the router it should not be lifted but should be moved toward the operator until clear.
6. Check to make sure you have routed each dovetail evenly.
7. Once everything looks okay — remove the two pieces and tap them together. If properly set up, they will fit together. However, adjustments probably will need to be made at first.
8. See trouble shooting, page eleven, if adjustments are needed. Once all adjustments have been made, do not change setting until all dovetails are cut.
9. Repeat steps 1 thru 6 with your finished wood.

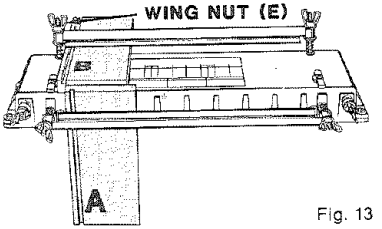


Fig. 13

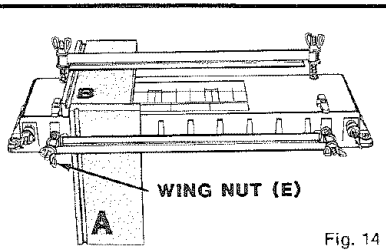


Fig. 14

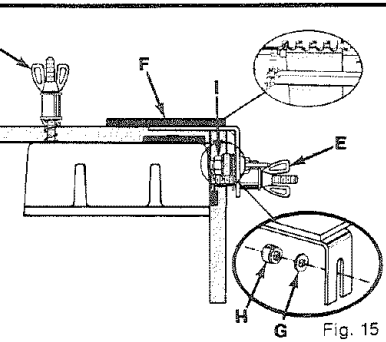


Fig. 15

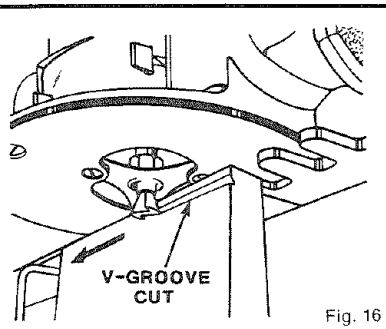


Fig. 16

Operation

You are now ready to rout your second dovetail joint. Do so by repeating the above procedure with boards (C) and (B) positioned against the right stops. *See Figure 17.* Insert board (C) between front clamping bar and front surface of dovetail base with bottom edge toward the right 2 way stop. Temporarily clamp board (C) "inside-out" to the right front of the fixture so that it extends above the base. This will assist in the proper positioning of board (B).

Insert board (B) between top clamping bar and top surface of dovetail base, with bottom edge against right 3 way stop, and flush with extended portion of board (C). Tighten wing nuts (E) on top clamping bar to hold board (B) securely. Relocate board (C) so that it is flush with the top of board (B) and against 2 way stop on right front of dovetail base. Tighten front wing nuts (E) to hold board (C) securely. Attach comb-shaped template (F) and cut dovetail joint as described above.

By following the instructions just described, you have cut dovetail joints for a drawer front and sides. If you desire to dovetail cut the back corners, position boards (A and D) and (C and D) in the dovetail fixture as shown in Figures 18 and 19. Then follow the same procedure described above. **NOTE:** Once your router is set-up and all adjustments made, you can refer to Figures 14, 17, 18 and 19 for proper placement of your boards each time you cut dovetail joints for a drawer or box.

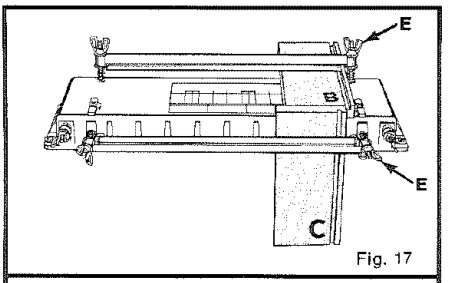


Fig. 17

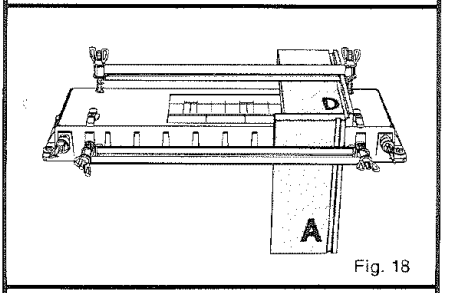


Fig. 18

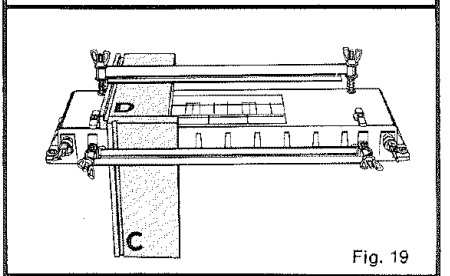


Fig. 19

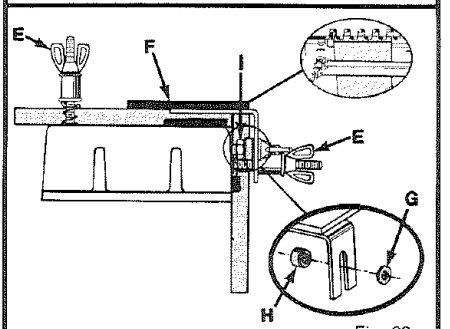


Fig. 20

OFFSET-FRONT DRAWER

⚠WARNING: UNPLUG ROUTER FROM POWER SUPPLY WHILE ASSEMBLING PARTS OR MAKING ADJUSTMENTS. FAILURE TO DO SO COULD RESULT IN ACCIDENTAL STARTING OF YOUR ROUTER CAUSING DAMAGE TO THE WORK SURFACE OR POSSIBLE SERIOUS PERSONAL INJURY.

An Offset-Front drawer, often called flush-Offset, is used when the drawer front is the same height as the drawer sides, but the drawer front is 1/8" longer than the width of the drawer. Therefore, the drawer sides are recessed 1/16" into each side of the drawer front. *See Figure 3.*

SET-UP

The Set-Up for an Offset-Front drawer is done exactly the same as a set-up for a FLUSH FRONT DRAWER OR BOX, page 6, with one exception. The exception being where the angle brackets of the comb-shaped template are located on the dovetail base. *See Figure 9.* The angle brackets of the comb-shaped template go between spacers (G) and (H). *See Figure 20.* After making this change, follow the same set-up procedure described above. **NOTE:** This set-up is used for the drawer front only. The drawer back is cut the same as a flush front drawer.

OPERATION

RABBETED FRONT DRAWER

⚠WARNING: UNPLUG ROUTER FROM POWER SUPPLY WHILE ASSEMBLING PARTS OR MAKING ADJUSTMENTS. FAILURE TO DO SO COULD RESULT IN ACCIDENTAL STARTING OF YOUR ROUTER CAUSING DAMAGE TO THE WORK SURFACE OR POSSIBLE SERIOUS PERSONAL INJURY.

A rabbeted front drawer is used when you want the drawer front to overlap the top, bottom, and both sides of the drawer opening. The drawer front is both 3/4" wider than the drawer sides and 3/4" longer than the drawer width. This will give you a 3/8" rabbet around your drawer front after you finish cutting your dovetail joints.

SET-UP

1. Cut a 3/8" wide x 7/16" deep rabbet around the drawer front.

2. Attach guide bushing to your router and install dovetail cutter. See INSTALLING TEMPLATE GUIDE BUSHING AND CUTTER, Page 4.

3. Adjust the base on your router until the cutter extends 17/32 inch below the router subbase for 1/2" joints. Adjust 7/16 inch below the router subbase for 1/4" joints. *See Figure 10.*

4. Loosen the stop screws and place the 3 way stop on top of your dovetail template and the 2 way stop on the side of your dovetail template in their proper position. *See Figure 9 & 11.* Re-tighten stop screws securely.

5. Mark the boards for the drawer or box on the inside with identifying letters near the bottom edge. *See Figure 12.*

NOTE: The reverse sides of the board will be the outside of the finished drawer or box. The outside of the boards are always clamped towards the dovetail base and all pieces are routed in an "inside-out" position. The boards are then reversed to assemble.

NOTE: The front piece (B) should be 3/4" longer and 3/4" wider than the back piece (D). The side pieces (A and C) should be the same size. See the chart on Page 5 for computing proper sizes and recommended material thicknesses.

6. Insert board (A) between front clamping bar and front surface of dovetail base with bottom edge toward the left 2 way stop. Temporarily clamp board (A) "inside-out" to the left front of the fixture so that it extends above the base. *See Figure 13.* This is done to assist in the proper positioning of board (B).

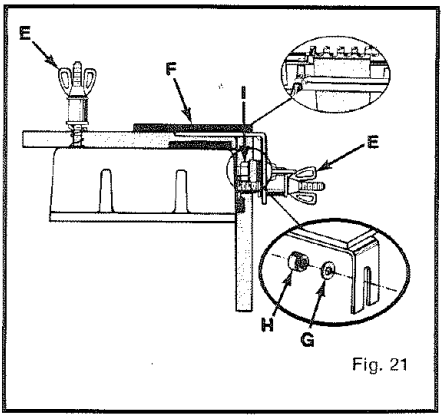


Fig. 21

7. Insert board (B) between top clamping bar and top surface of dovetail base, with bottom edge against left 3 way stop, and flush with extended portion of board (A). *See Figure 13.*

8. Tighten wing nuts (E) on top clamping bar to hold board (B) securely.

9. Relocate board (A) so that it is flush with the top of board (B) and against 2 way stop on left front of dovetail base. *See Figure 14.*

10. Tighten front wing nuts (E) to hold board (A) securely.

11. Attach comb-shaped template (F) to the dovetail base with spacers (G) and (H) in their desired location. *See Figure 21.*

12. Hold the template flat on the boards with one hand and tighten template wing nuts (E) securely.**NOTE:** Be sure template finger ends are parallel to edge of board (B) to assure even fitting after cutting.

13. Loosen wing nuts (E) on top clamping bar and remove board (B) from the base and replace with a scrap piece of the same wood. This will provide support for board (A) and help prevent splintering as the cutter moves in and out of the fingers.

OPERATION

ROUTING YOUR RABBETED DOVETAIL JOINTS

You are now ready to make your cut for a rabbeted dovetail joint.

1. Place your router so that the subbase is resting flat on the dovetail template. Make sure the cutter is not making contact with the edge of board (A), then turn your router on and let the motor build to its full speed.
2. Make a straight cut from **RIGHT TO LEFT** across board (A). *See Figure 16.* This shallow V-groove cut is made to prevent chipping of the wood when the router is moved in and out of the fingers of your dovetail template.

⚠WARNING: USE CAUTION WHEN OPERATING ROUTER AT EITHER EXTREME END OF DOVETAIL TEMPLATE. YOUR CUTTER WILL MAKE CONTACT WITH ANGLE BRACKET IF MOVED TOO FAR OUTSIDE FIRST OR FINAL CUT.

3. Cut your dovetail joint. Feed your router in and out each finger, moving from left to right.
4. Recut the dovetail moving your router from right to left. This will clean off any spots or imperfections that might have been missed.
5. Wait until the cutter has completely stopped before removing your router. This will prevent possible serious injury or any damage to your dovetail template. When removing the router, it should not be lifted but should be moved toward the operator until clear.
6. Check to make sure you have routed each dovetail evenly.
7. Loosen template wing nuts (E) and remove comb-shaped template (F). DO NOT REMOVE BOARD (A).
8. Loosen wing nuts (E) on top clamping bar and remove scrap piece of wood.
9. Replace the scrap piece of wood with the piece that is to be your finished front board (B).
10. Place it flush with the edge of board (A), and tighten wing nuts (E) on top clamping bar firmly.
11. Loosen wing nuts (E) on front clamping bar and remove board (A).
12. Attach comb-shaped template (F) to the dovetail base with spacers (G) and (H) in their desired location. *See Figure 22.* Hold the template flat on the boards with one hand and tighten wing nuts (E) securely.
13. *See Figure 23.* With your dovetail template setup as shown, cut your joint in board (B) as a single piece.
14. Recut the dovetail moving from right to left to clean off any spots or imperfections that might have been missed.

To rout the other side of your rabbeted front drawer, repeat the above procedure with boards (C) and (B) positioned against the right stops. *See Figure 24.* To rout dovetail cuts in board (D) and boards (A and C) follow the instructions for making a "FLUSH FRONT DRAWER OR BOX".

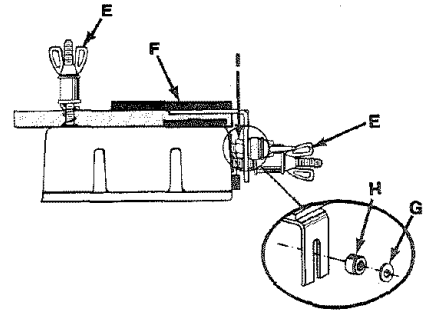


Fig. 22

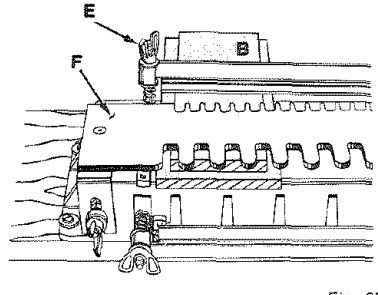


Fig. 23

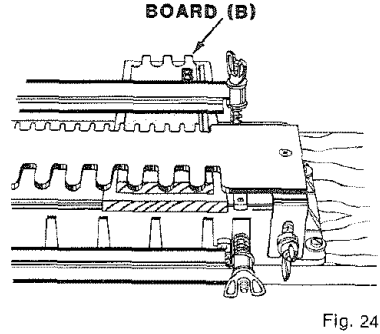
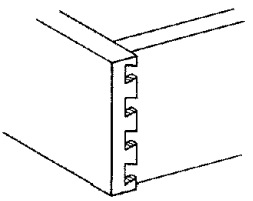
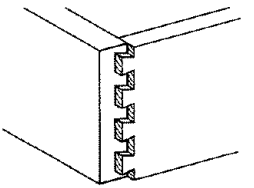


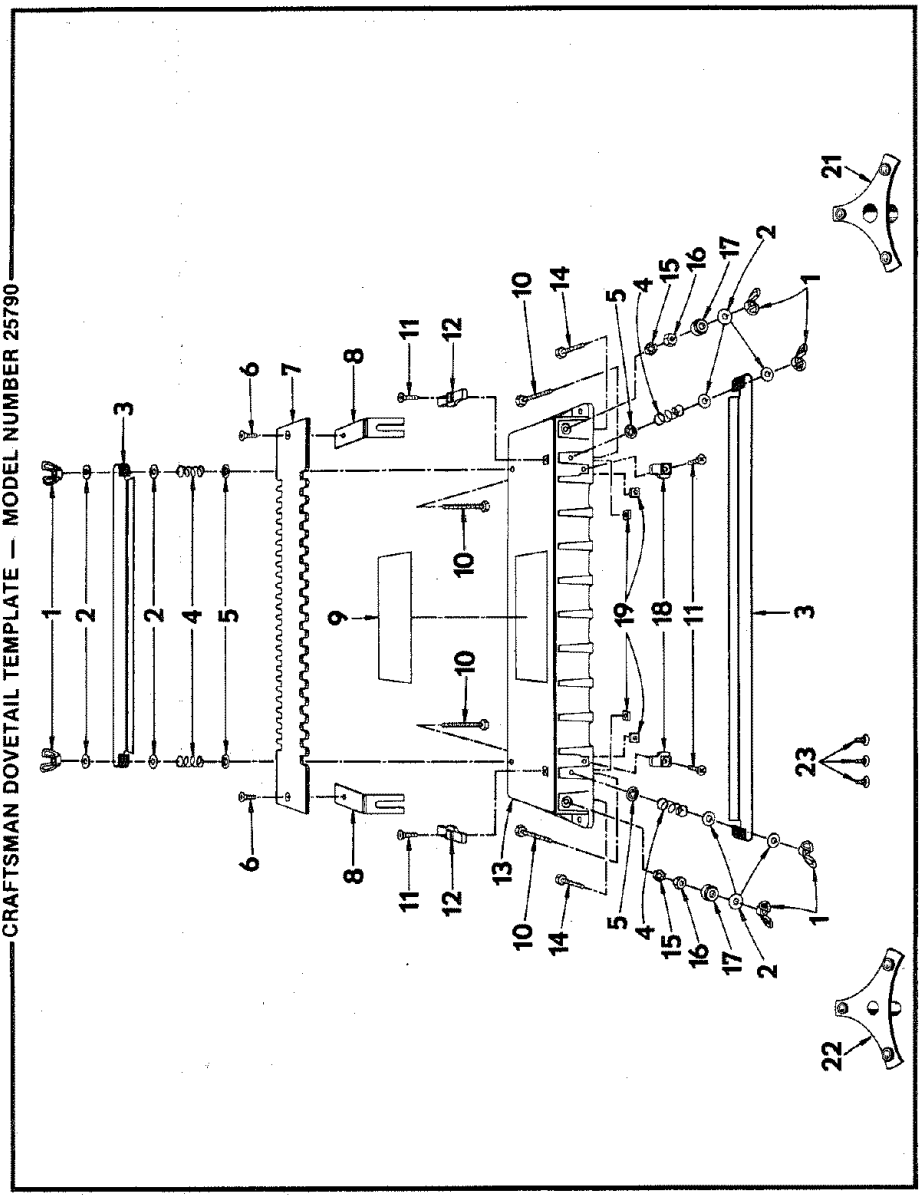
Fig. 24

HELPFUL HINTS

- Once all adjustments are made, do not make any further changes until all dovetails are cut.
- Always clamp workpiece securely for cutting.
- Rout dovetails from the front only.
- A safe operator is one who thinks ahead.
- Do not raise or lower your router or cutter while the bit is between the dovetail template fingers. Keep router base flat against template.
- Always wear eye protection when routing.
- Make certain the ends of all boards are square.
- Make set-up adjustments carefully. Then double check. Measure twice and cut once.
- **DO NOT** use warped boards.
- Keep cutters clean and properly sharpened.
- Be consistent when selecting the thickness of your boards.
- Don't let familiarity make you careless.
- Always bevel the drawer front for an offset-front drawer.
- Study all safety rules and do the job safely.
- Plan your drawer opening so that the boards will be in increments of 7/8 inch for 1/2 inch joints, or 29/64 inch increments for 1/4 inch joints. This will allow a half-pin to be on both the top and bottom edge of the drawer front. Don't forget to allow for clearances.
- **NEVER** place your hands in jeopardy.
- Make certain clamps can't loosen while in use.
- Test difficult set-ups on scrap — Don't waste lumber.
- Plan each operation before you begin.
- **THINK SAFETY BY THINKING AHEAD.**

TROUBLE SHOOTING

Problem		Solution
If the joint is too tight		Raise the cutter very slightly, this will make the cut more shallow (approximately 1/64"). See depth adjustment instructions as explained in your router owners manual.
If the joint is too loose		Lower the cutter bit very slightly to make the cut deeper (approximately 1/64").
If the fit is too deep	 Fig. 25	Turn the lock nut (l) in a counter-clockwise direction until desired depth is reached. *See Figures 15, 20, or 21.* **NOTE:** Be sure to adjust both lock nuts equally.
If the fit is too shallow	 Fig. 26	Turn the lock nut (l) in a clockwise direction until the desired depth is reached. **NOTE:** Be sure to adjust both lock nuts equally.


CRAFTSMAN DOVETAIL TEMPLATE — MODEL NUMBER 25790

CRAFTSMAN DOVETAIL TEMPLATE — MODEL NUMBER 25790

THE MODEL NUMBER WILL BE FOUND ON THE LABEL ON TOP OF YOUR DOVETAIL TEMPLATE BASE

PARTS LIST

Key No.	Part No.	Description	Qty.
1	621438-003	Wing Nut **STD541625	6
2	931744-059	Washer	10
3	990014-002	Clamp Bar	2
4	714801-000	Spring	4
5	990034-001	Push Nut	4
6	611114-002	*Screw (#10-32 x 1/2 Flat Head Thread Cutting)	2
7	990013-001	Template	1
8	990015-002	Angle Bracket	2
9	990035-001	Label	1
10	703427-806	Hex Bolt (1/4-20 x 2-7/8")	4
11	622183-018	*Screw (#8-32 x 7/8 Flat Head)	4
12	990016-001	3 Way Stop	1
13	990012-001	Base	1
14	703427-805	Hex Bolt (#1/4-20 x 1-3/4")	2
15	990044-001	Palnut	2
16	606162-001	Lock Nut (#1/4-20)	2
17	616564-004	Spacer	2
18	990017-001	2 Way Stop	2
19	709863-804	Square Nut (#8-32) **STD 541008	4
21	999883-002	7/16" Guide Bushing	1
22	999883-001	5/16" Guide Bushing	1
23	930980-009	*Screw (#10-32 x 1/2" Flat Head)	3
	612547-176	Owner's Manual	

*Standard hardware item — may be purchased locally

**Available from Division 98 — Source 980.00

NOTES

NOTES

SEARS

OWNERS MANUAL

MODEL NO. 315.25790

HOW TO ORDER REPAIR PARTS

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DOVETAIL TEMPLATE

FOR USE WITH ALL CRAFTSMAN ROUTERS

ALWAYS MENTION CATALOG NUMBER 25790 WHEN COMMUNICATING WITH US REGARDING YOUR CRAFTSMAN DOVETAIL TEMPLATE.

WHEN ORDERING REPAIR PARTS, ALWAYS GIVE THE FOLLOWING INFORMATION:

- PART NUMBER
- PART DESCRIPTION
- MODEL NUMBER 315.25790
- NAME OF ITEM DOVETAIL TEMPLATE

All parts listed may be ordered from any Sears Service Center and most Sears stores.

If the parts you need are not stocked locally, your order will be electronically transmitted to a Sears Repair Parts Distribution Center for handling.

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