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Wedge-Pro® & Wedge-Pro® II Segmented Cutting Jig Setup Instructions

Prepare the Setup Jig

1. Place the setup guide into the miter slot on the preferred side of the table saw blade as shown to the right.
2. With one hand, wiggle the setup guide back and forth until it is firmly seated, then with the other hand, slowly adjust the two leveling screws to prevent side to side rocking.

   ***** It is very important that the setup guide does not wiggle side to side.***

   ***** Verify the table saw blade is set to 90°.***

3. Raise the table saw blade 3/4”. Slowly make the indexing cut on the setup guide by keeping one hand firmly on top of the guide and fingers in between the two leveling screws. The setup guide is made of acrylic and will not damage your table saw blade. Proceed through the cut slowly.
4. Turn off the saw and lower the blade below the table surface.

Prepare the Sled

1. There are two 10-32 brass grub screws pre-installed on the miter bar and they need to be adjusted using a small, slotted screwdriver. Turn each grub screw so that it allows for easy movement of the miter bar in the miter bar slot on the table saw but does not allow any side-to-side wiggling. The miter bar is made from phenolic and can be trimmed to size using the table saw. If the miter bar needs to be trimmed down, remove the brass grub screws prior to cutting, and proceed through the cut slowly.
2. Loosely attach the miter bar to the underside of the sled using two 1/4” x 3/4" slotted sidewalk bolts. Do not tighten. Set the sled aside.
3. Make sure the setup guide is still firmly seated in the miter slot and then place the sled with the miter bar in the miter slot. Carefully align the 1/8” kerf notch on the edge of the sled with the indexing cut on the setup guide as shown below. The kerf notch gives you the precise location of where the blade will be.

4. Firmly tighten the two 1/4” x 3/4” slotted sidewalk bolt.

   ***** Make sure that the setup guide does not wiggle during this alignment or when tightening the sidewalk bolts.***

   ***** It is critical that the sled be set perpendicular to the miter slot, not the blade.***

5. Set the setup guide aside, but do not discard as it may be needed in the future.

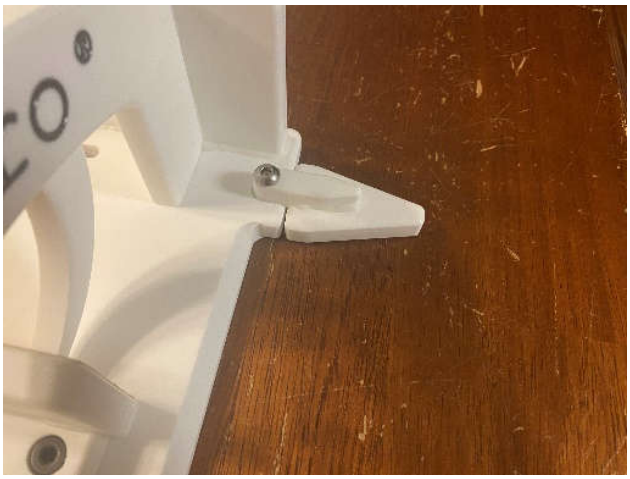
6. You will now make a full depth cut through the sled. Position the sled away from the blade. Raise the blade to perform a 2-1/2” cut.

7. Proceed slowly with this zero-clearance cut. Cut all the way through the sled, from the back to the front.

   ***** Only place your hands on the provided handles when making a cut. These handles keep your hands clear of the cutting blade.***

   ***** Be mindful of how table saw sleds allow the blade to exit the front of the sled. If your hand is improperly positioned, an accident might occur.***

8. Install the sweeper by removing it from its shipping location and attach it to the sled using the attachment point closest to the back of the table saw using one 1/4" x 3/4” button head screw.

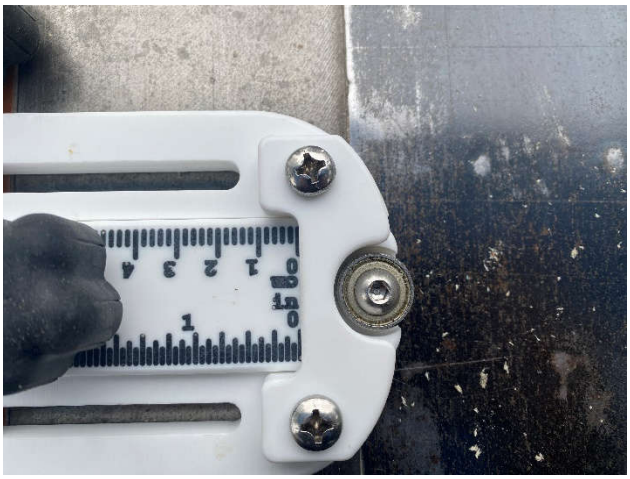


Prepare the Material Stop

1. Make sure the adjustable fence is seated fully on the base.

2. Place the material stop in the miter slot opposite the sled.

3. Slide the material stop so that the 0in and 0cm marks are both aligned with the edge of the bridge and tighten the adjustment knob.



4. Position the material stop so that it overhangs the blade just slightly.

5. Secure the miter bar to the material stop using two 1/4“ x 3/4" slotted sidewalk bolts.

6. Slowly make the indexing cut on the material stop by keeping one hand firmly on top of the material stop. The material stop is made of acrylic and will not damage your table saw blade. Proceed through the cut slowly.

Using the Sled

1. The table saw ripping fence is not needed when using the sled and should be removed.

2. Set the fence for the desired number of segments by placing the 5mm indexing pin in the corresponding hole of the number of segments.

3. Tighten the fence using the adjustment know while verifying that the fence is placed firmly against the central pivot pin and the segment count pin.

4. Place the material in front of the fence while utilizing the spring clamp.

5. Proceed with cutting. After each cut, the material must be rotated 180° to achieve the opposing miters.

***** It is very important that when preparing strips that will be used to cut segments, that both opposing faces of the strip must be parallel. If not, the quality of segments and rings might be affected.***

Using the Material Stop

1. For segmented cutting, place the material stop in the miter slot opposite the sled and set the desired segment length by loosening the adjustment knob and measuring the desired segment length at the base of the stop close to the bearing. Tighten the adjustment knob.

2. For thin ripping, the material stop is placed opposite the table saw ripping fence with the material stop pointing away from the fence. The purpose of the thin-rip bearing is to allow for the "keep" strip to not be between the blade and then fence. Slide the material stop while still in the miter slot close to beside the blade and set the gap for the desired strip width from the edge of the bearing to the side of the blade. Move the material stop 6" from the front of the blade and tighten the two knobs on the material stop to prevent movement. Place the material against the bearing and bring the ripping fence to the other side of the material. After each successive cut, the fence is moved closer to the material stop.

Adjusting and Troubleshooting the Sled

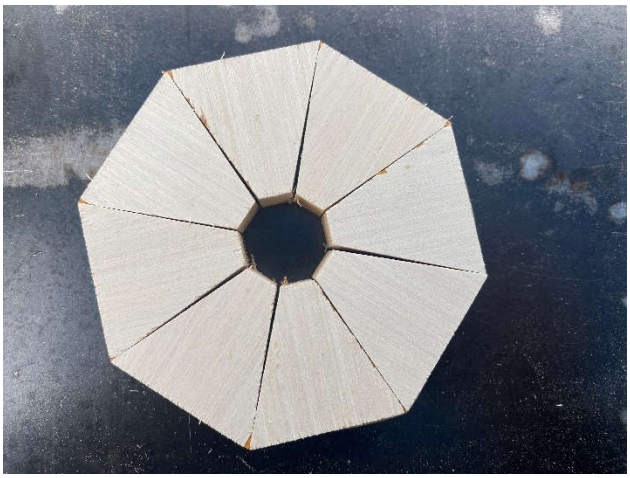
The Wedge-Pro & Wedge-Pro II may require minor one-time adjustments to dial in the accuracy of the fence to make sure it is perfectly perpendicular to the miter slot. It is important to note that the blade relationship to the fence does not matter. When cutting test rings using the Wedge-Pro II, it is important that you only use one fence, not both. After each cut, just flip the strip and continue cutting.

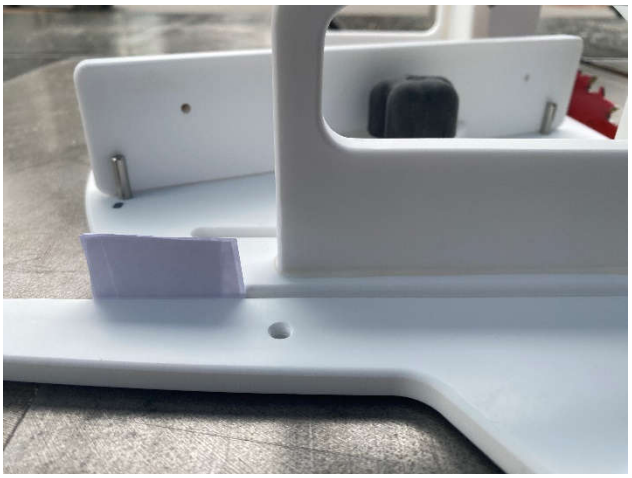
1. To test the accuracy of the initial setup, cut a test ring using the setting for 8 segments, and set the material stop to 1-1/2” for the segment length.

   ***** If the test ring is tight, no adjustments are necessary, happy cutting!***

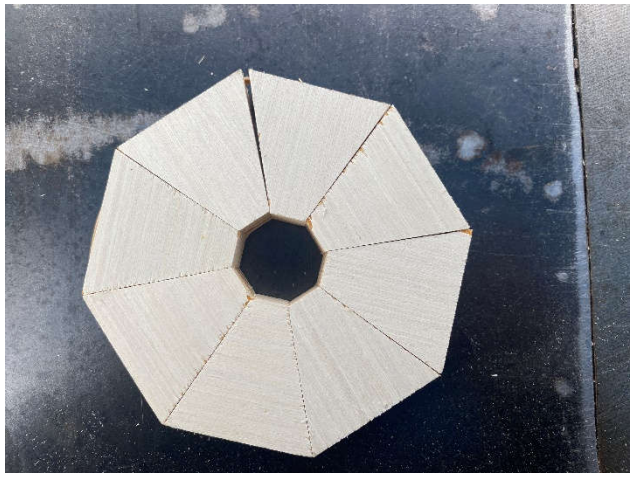
2. If the test ring has small gaps, you will need to place paper shims in between the setup guide and the sled and retighten the bolts securing the miter bar. It is preferred to start with 5 shims, as a single shim may not have a noticeable change.

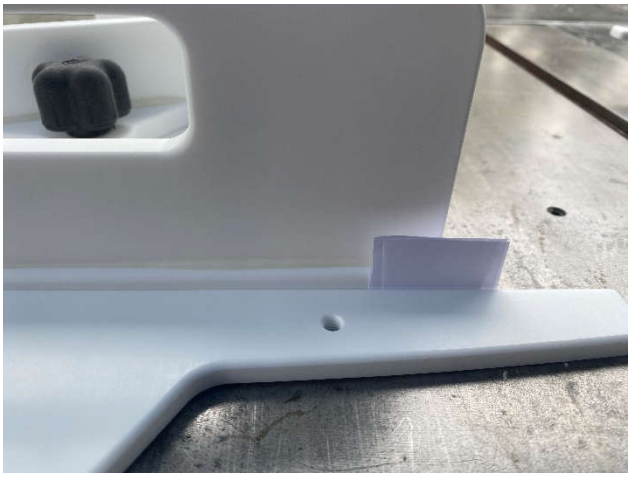
3. If the gaps are on the inside of the ring as shown below, you will need to shim the left side of the sled. Start with 5 pieces of printer paper for shims as shown in the photo below.





4. If the gaps are on the outside of the ring as shown below, you will need to shim the right side of the sled. Start with 5 pieces of printer paper for shims as shown in the photo below.



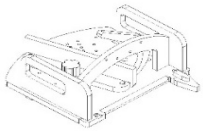


5. After shimming, recut a test ring. If the gaps are larger, move the shims to the opposite side. If the gaps are smaller, add more shims on the same side and continue as necessary.

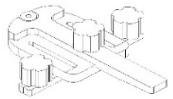
***** Please note that the two test rings above were intentionally cut using 20 shims for each to show dramatic gaps.***

Safety Guidelines & Warnings

- Do NOT modify this product in any way.
- ALWAYS wear eye protection.
- ALWAYS use safety push sticks when cutting small pieces and small strips.
- ALWAYS keep the table saw blade height to a minimum.
- BEFORE using this product, make sure you are confident in using your table saw.
- YOU assume all risk and responsibility for the proper and safe use of this product.
- YOU have sole responsibility for ensuring that anyone you allow to use this product reads and understands all instructions and safety precautions outlined in this manual.
- Sharp tools are safe tools. You should never have to force a cut.
- The miter bar MUST be installed for this sled to function properly.
- The table saw ripping fence is not used in conjunction with this sled.
- Hands should only be placed on the designated handles while cutting.



Wedge-Pro® - Segmenting Cheat Sheet



Segment Count & Miter Angle

Ring Diameter in Inches

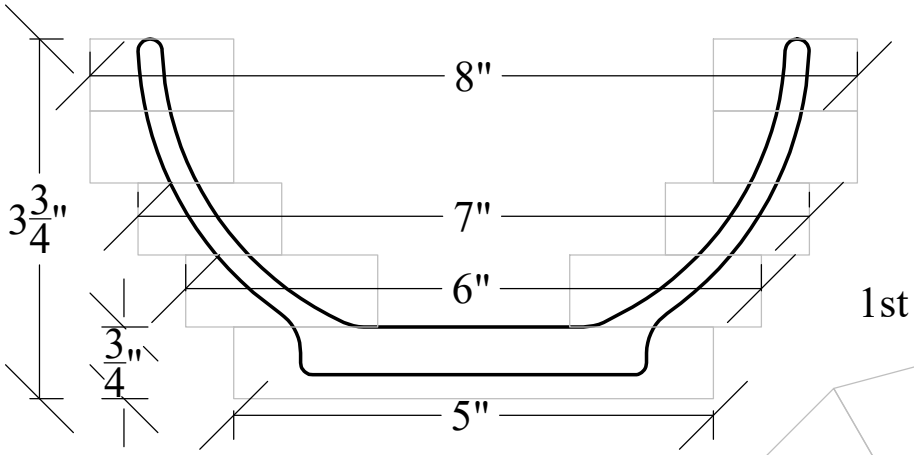
	8 22.50°	10 18.00°	12 15.00°	16 11.25°	18 10.00°	20 9.00°	24 7.50°	32 5.63°	36 5.00°	40 4.50°	48 3.75°	60 3.00°	72 2.50°
3	1 3/16	15/16	13/16	9/16	1/2	1/2	3/8	5/16	1/4	1/4	3/16	3/16	1/8
3 1/2	1 3/8	1 1/8	15/16	11/16	5/8	9/16	7/16	5/16	5/16	1/4	1/4	3/16	1/8
4	1 9/16	1 1/4	1 1/16	13/16	11/16	5/8	1/2	3/8	3/8	5/16	1/4	3/16	3/16
4 1/2	1 3/4	1 7/16	1 3/16	7/8	13/16	11/16	9/16	7/16	3/8	3/8	5/16	1/4	3/16
5	1 15/16	1 9/16	1 5/16	1	7/8	13/16	5/8	1/2	7/16	3/8	5/16	1/4	3/16
5 1/2	2 3/16	1 3/4	1 7/16	1 1/16	15/16	7/8	3/4	9/16	1/2	7/16	3/8	5/16	1/4
6	2 3/8	1 7/8	1 9/16	1 3/16	1 1/16	15/16	13/16	9/16	1/2	1/2	3/8	5/16	1/4
6 1/2	2 9/16	2 1/16	1 11/16	1 1/4	1 1/8	1	7/8	5/8	9/16	1/2	7/16	5/16	5/16
7	2 3/4	2 3/16	1 13/16	1 3/8	1 1/4	1 1/8	15/16	11/16	5/8	9/16	7/16	3/8	5/16
7 1/2	2 15/16	2 3/8	1 15/16	1 1/2	1 5/16	1 3/16	1	3/4	5/8	9/16	1/2	3/8	5/16
8	3 1/8	2 1/2	2 1/8	1 9/16	1 3/8	1 1/4	1 1/16	13/16	11/16	5/8	1/2	7/16	3/8
8 1/2	3 5/16	2 11/16	2 1/4	1 11/16	1 1/2	1 5/16	1 1/8	13/16	3/4	11/16	9/16	7/16	3/8
9	3 9/16	2 13/16	2 3/8	1 3/4	1 9/16	1 7/16	1 3/16	7/8	13/16	11/16	9/16	1/2	3/8
9 1/2	3 3/4	3	2 1/2	1 7/8	1 11/16	1 1/2	1 1/4	15/16	13/16	3/4	5/8	1/2	7/16
10	3 15/16	3 1/8	2 5/8	1 15/16	1 3/4	1 9/16	1 5/16	1	7/8	13/16	5/8	1/2	7/16
10 1/2	4 1/8	3 5/16	2 3/4	2 1/16	1 13/16	1 5/8	1 3/8	1	15/16	13/16	11/16	9/16	7/16
11	4 5/16	3 7/16	2 7/8	2 3/16	1 15/16	1 3/4	1 7/16	1 1/16	15/16	7/8	3/4	9/16	1/2
11 1/2	4 1/2	3 5/8	3	2 1/4	2	1 13/16	1 1/2	1 1/8	1	7/8	3/4	5/8	1/2
12	4 11/16	3 3/4	3 1/8	2 3/8	2 1/8	1 7/8	1 9/16	1 3/16	1 1/16	15/16	13/16	5/8	1/2
12 1/2	4 15/16	3 15/16	3 1/4	2 7/16	2 3/16	1 15/16	1 5/8	1 1/4	1 1/16	1	13/16	5/8	9/16
13	5 1/8	4 1/16	3 3/8	2 9/16	2 1/4	2 1/16	1 11/16	1 1/4	1 1/8	1	7/8	11/16	9/16
13 1/2	5 5/16	4 1/4	3 9/16	2 5/8	2 3/8	2 1/8	1 3/4	1 5/16	1 3/16	1 1/16	7/8	11/16	9/16
14	5 1/2	4 3/8	3 11/16	2 3/4	2 7/16	2 3/16	1 13/16	1 3/8	1 1/4	1 1/8	15/16	3/4	5/8
14 1/2	5 11/16	4 9/16	3 13/16	2 7/8	2 1/2	2 1/4	1 7/8	1 7/16	1 1/4	1 1/8	15/16	3/4	5/8
15	5 7/8	4 11/16	3 15/16	2 15/16	2 5/8	2 3/8	1 15/16	1 1/2	1 5/16	1 3/16	1	13/16	5/8
15 1/2	6 1/16	4 7/8	4 1/16	3 1/16	2 11/16	2 7/16	2	1 1/2	1 3/8	1 3/16	1	13/16	11/16
16	6 5/16	5	4 3/16	3 1/8	2 13/16	2 1/2	2 1/8	1 9/16	1 3/8	1 1/4	1 1/16	13/16	11/16
16 1/2	6 1/2	5 3/16	4 5/16	3 1/4	2 7/8	2 9/16	2 3/16	1 5/8	1 7/16	1 5/16	1 1/16	7/8	3/4
17	6 11/16	5 5/16	4 7/16	3 5/16	2 15/16	2 11/16	2 1/4	1 11/16	1 1/2	1 5/16	1 1/8	7/8	3/4
17 1/2	6 7/8	5 1/2	4 9/16	3 7/16	3 1/16	2 3/4	2 5/16	1 11/16	1 1/2	1 3/8	1 1/8	15/16	3/4
18	7 1/16	5 5/8	4 11/16	3 9/16	3 1/8	2 13/16	2 3/8	1 3/4	1 9/16	1 7/16	1 3/16	15/16	13/16

** Formula to Calculate Segment Length -> (Ring Diameter x 3.14) / Number of Segments

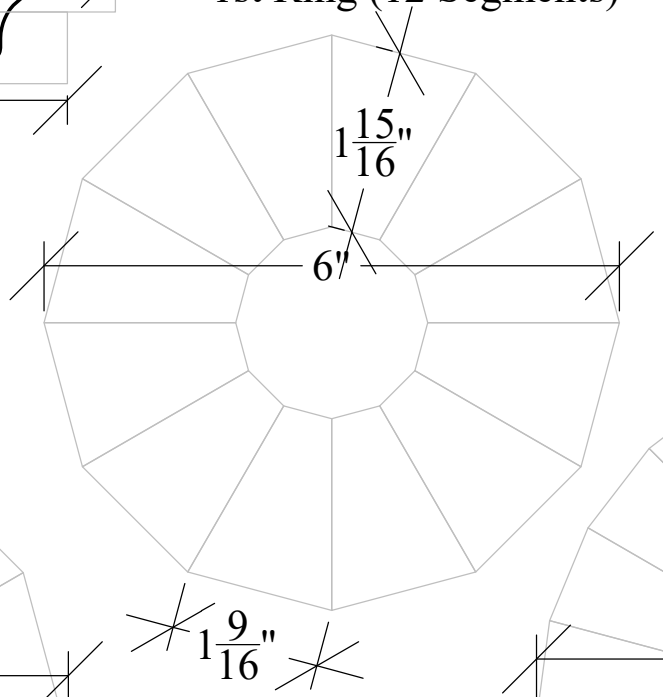
** Finished ring will be a little larger than anticipated as the formula provides an exact arc length, whereas the actual cut is a straight line.

7" Segmented Bowl Plan

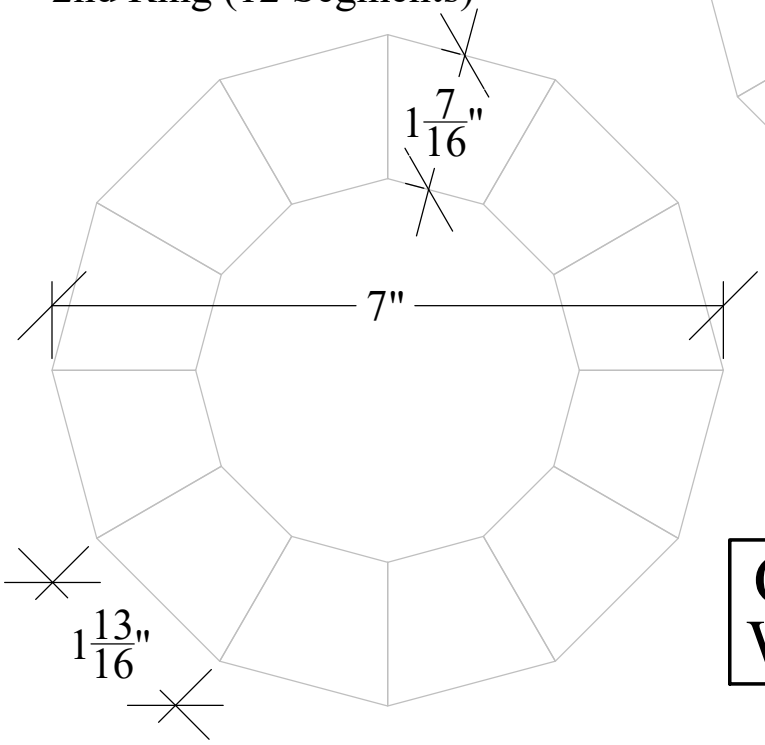
Materials			
	QTY	Cut Length	Depth
Base	1	5" Diameter	
1st Ring	12	1-9/16"	2"
2nd Ring	12	1-13/16"	1-1/2
3rd Ring	24	1-1/16"	1-1/2"
4th Ring	24	1-1/16"	1-1/2"



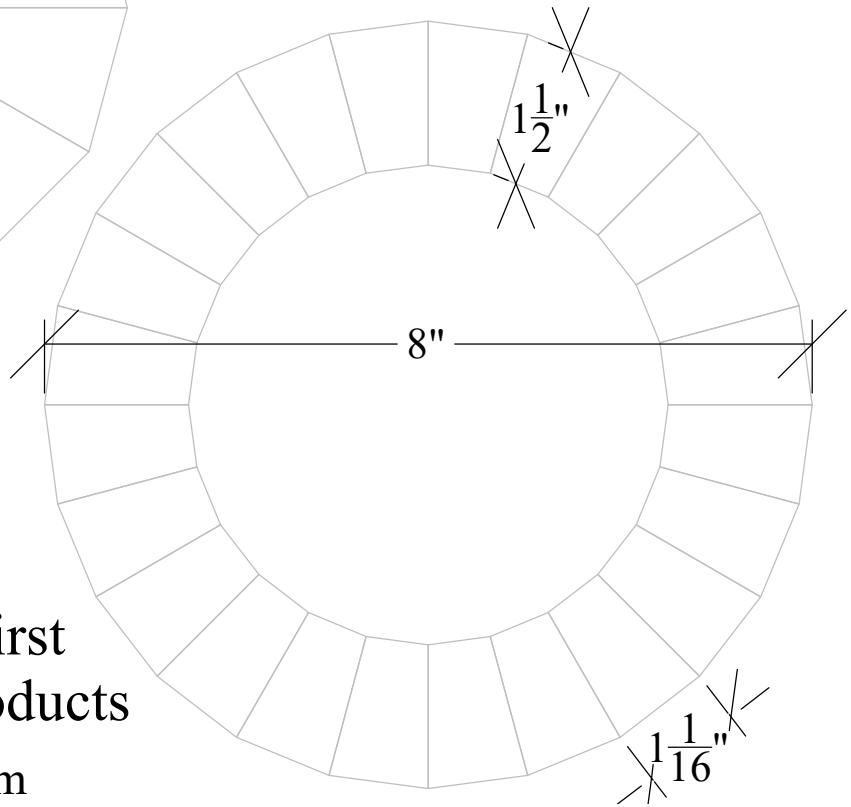
1st Ring (12 Segments)



2nd Ring (12 Segments)



3rd & 4th Rings (24 Segments)



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