

The Veritas® Work Hold-Down is simple to set up and use for quick and effective control of a variety of stock sizes. It keeps your work pressed tightly against both the fence and the table, allowing you to keep your fingers well away from the bit. The spring pressure is infinitely variable. It keys into the top slot in the Veritas® Router Table Fence and can be set anywhere along the length.

ASSEMBLING THE WORK HOLD-DOWN

To install the Work Hold-Down, assemble the parts as shown in Figure 1. The side-spring post and side spring are pre-assembled and just have to be slipped into the hole in the side-spring arm as shown. The top spring must be inserted into the top-spring arm and the two #8-32 setscrews tightened with the hex key provided. As shown in **Figure 1**, initially position the top spring with approximately 1" extending out the back end of the top-spring arm. The side spring should be positioned with approximately 1 1/4" extending out the back end of the side-spring post. Both spring tips should be curved away from your work to prevent any scoring. This positioning of the springs is suitable for most routing; extending the springs farther out will give them more flex. Conversely, retracting them will make them more rigid. To install the assembled Work Hold-Down to your Veritas® Router Table Fence, loosen the long 1/4"-20 cap screw that holds the T-nut, and slide the unit onto the upper rail of your fence, allowing the T-nut to enter into the upper slot of your fence. With the 3/16" hex adapter provided in the 4-in-1 screwdriver (supplied with your fence), the Work Hold-Down can be locked at any point along the upper rail.

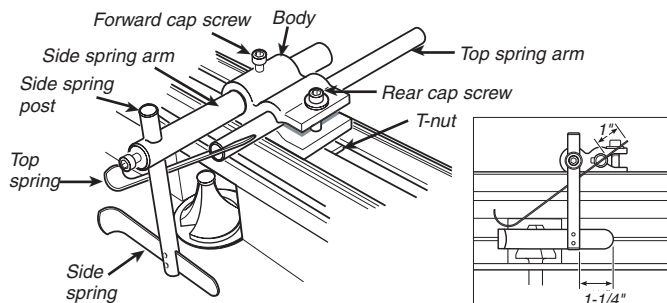


FIGURE 1 - View of assembled Work Hold-Down

ADJUSTING THE WORK HOLD-DOWN

Set your Work Hold-Down so that both springs are in line, as shown in **Figure 2**, with the curved ends approximately 1/4" past the lower outfeed rail. This gives you plenty of room to hold your workpiece until it is restrained by the springs, and full spring pressure until the work has passed the bit (where holding the work is less convenient). Never position the springs over the fence opening, because the spring tension will cause the workpiece to be pushed into the rotating bit as your work clears the lower infeed rail. The only time we would not recommend putting the Work Hold-Down on the outfeed rail is when your machining operation changes the maximum width of the workpiece.

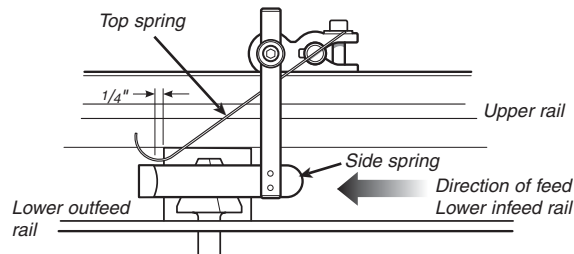


FIGURE 2 - Positioning of Work Hold-Down springs

Adjust both springs in position by first resting them on the workpiece, then tensioning them as shown in **Figures 3 and 4**. Try running the workpiece through the Work Hold-Down before routing to make sure that everything is running smoothly and you have the desired spring tension. Any later adjustment of the fence will not change this spring tension.

Rotate and position top-spring arm until spring touches workpiece, then rotate with top spring and tighten rear cap screw.

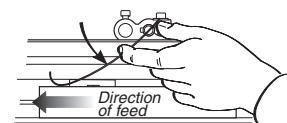
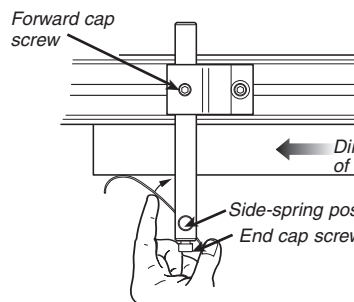


FIGURE 3 - Side view of top spring (side spring removed for clarity)



1. Slide side-spring arm until the spring touches the workpiece, then tighten the forward cap screw.
2. To tension the spring, rotate the side-spring post with the side spring, then tighten the end cap screw.

FIGURE 4 - Top view of side spring (top spring removed for clarity)

⚠ Safety Note:

Do not assume that if the springs do not contact the stationary bit, it is safe to begin using the Work Hold-Down. Depending on the angle of the springs, relaxed height of their setting and the bit projection, there is still a possibility that the springs can momentarily contact the bit once the workpiece has cleared.

When the workpiece clears the Work Hold-Down, the springs will oscillate slightly before settling. If either spring is too close to the bit, the largest (first) springback can cause the springs to contact the rotating bit, **risking serious injury**. One way to check this **while the router is off**, is to insert the unrouted workpiece between the Work Hold-Down and the fence from the outfeed side. Withdraw the workpiece by advancing it in the normal routing direction, checking to see if the springs come anywhere near the bit upon their release. If they do, advance the Work Hold-Down along the fence so both springs are farther away from the bit.

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