

PRAZI

GROOVECENTER

ROUTER TABLE FENCE POSITIONING SYSTEM

Patent Pending

USER'S
MANUAL
MODEL
#PR-6000



*Router bit not included.

**Please read
this manual
in its entirety
before using
the PRAZI
GrooveCenter.**

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LIMITED LIFETIME WARRANTY

What is covered under the lifetime warranty?

This **warranty** covers all defects in workmanship or materials and normal wear items in this PRAZI tool for the lifetime of the tool. Warranties for other PRAZI USA products may vary.

How to obtain warranty service.

To obtain service for this PRAZI USA tool you must return it, freight prepaid, to PRAZI USA. You may obtain the location of PRAZI USA, by calling (toll free) 1-800-262-0211 or by logging on to the PRAZI USA web site, www.praziusa.com. When requesting **warranty** service, you must present the proof of purchase documentation, which includes a date of purchase. PRAZI USA will replace any part covered under the **warranty**, at our option at no charge to you.

What is not covered?

This warranty applies only to the original purchaser at retail and may not be transferred. This warranty only covers defects arising under normal usage and does not cover malfunction, failure, or defect resulting from misuse, abuse, neglect, alteration, modification or repair by others.

***PRAZI USA makes no warranties, representations or promises as to the quality or performance of its tools other than those stated in its warranty.**

Additional limitations.

To the extent permitted by applicable law, all implied warranties, including warranties of **Merchantability or Fitness for a Particular purpose**, are disclaimed. Any implied warranties, including warranties of Merchantability or Fitness for a Particular Purpose, that cannot be disclaimed under state law are **limited** to three years from the date of purchase. PRAZI USA, is not responsible for direct, indirect, incidental or consequential damages. Some states do not allow limitations on how long an implied **warranty** lasts and/or do not allow the exclusion or limitation of incidental or consequential damages, so the above limitations may not apply to you. This **warranty** gives you specific legal rights, and you may also have other rights, which may vary by state.

BEFORE USING:

BEFORE YOU BEGIN:

1. Read this owners manual in its entirety before using the Prazi GrooveCenter
2. Read the owner's manual for your router before using the Prazi GrooveCenter.

IMPORTANT!:

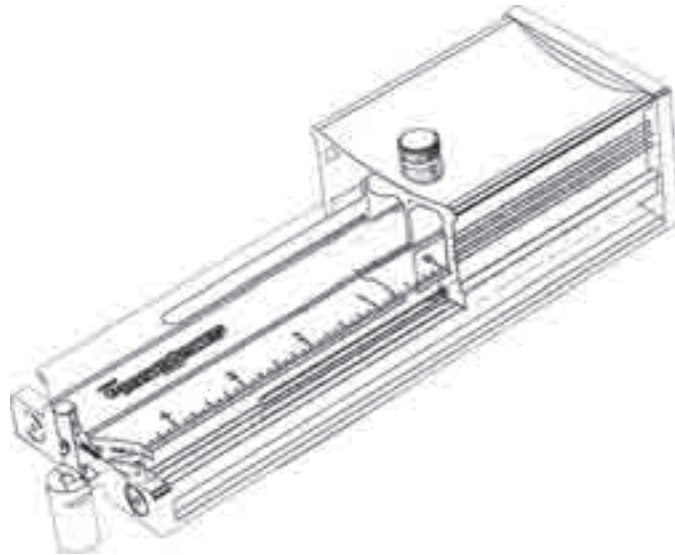
TO AVOID DAMAGE TO THE GROOVECENTER PLEASE READ

IMPORTANT THINGS TO REMEMBER WHEN USING THE PRAZI GROOVECENTER.

1. Read these instructions in their entirety before using the GrooveCenter.
2. Do not force the Collet Pin insert into the router collet.
3. Make yourself familiar with the use of your GrooveCenter, Router, and Router Table before use.

PARTS LIST:

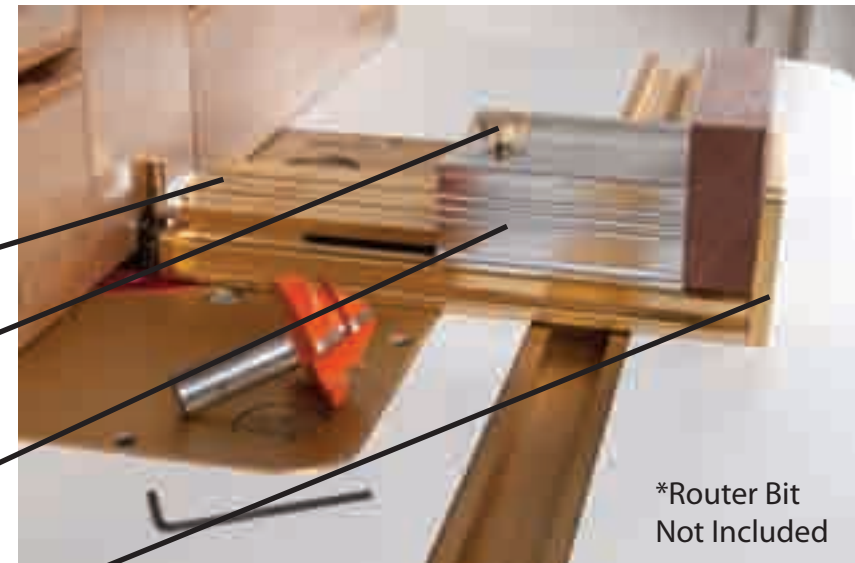
Part #	Qty.	Name
P6001	1	Main Housing
P6002	1	Sliding Carriage
P6003	1	Carriage Stop
P6004	1	Sliding Fence Stop
P6005	1	Fence Stop Pin
P6006	1	Sliding Pin Insert
P6007	1	Collet Pin
P6008	1	Zero Stop
P6009	1	Inner Gear
P6010	1	Hardware Kit



*Complete parts breakdown is located on page ****

PARTS LIST:

- Part # Name
- P6001 Main Housing
- P6002 Thumbscrew
- P6003 Sliding Carriage
- P6005 Carriage Stop Rear
- P6006 Fence Stop Pin
- P6007 Sliding Fence Stop
- P6008 Carriage Stop Front
- P6009 Collet Pin
- P6010 Collet Pin Plate
- P6011 Zero Stop
- P6012 Inner Gear (Not Shown)
- P6013 Hardware Kit (Not Shown)



*Router Bit Not Included



Fig 1.

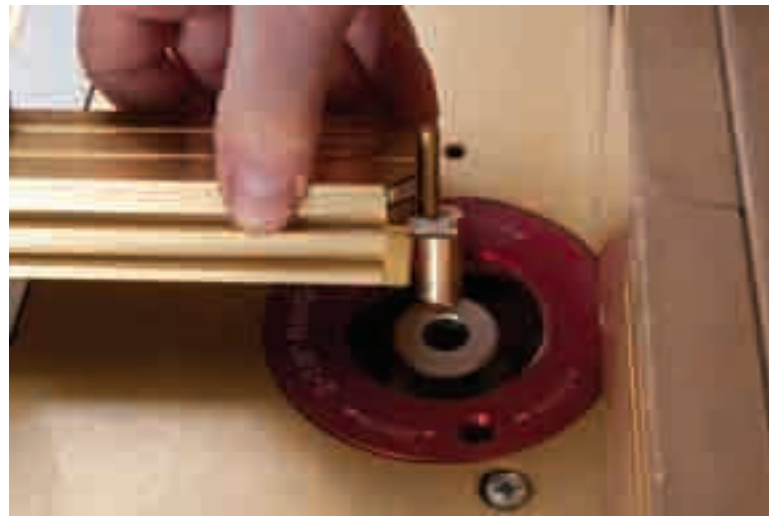


Fig 2.

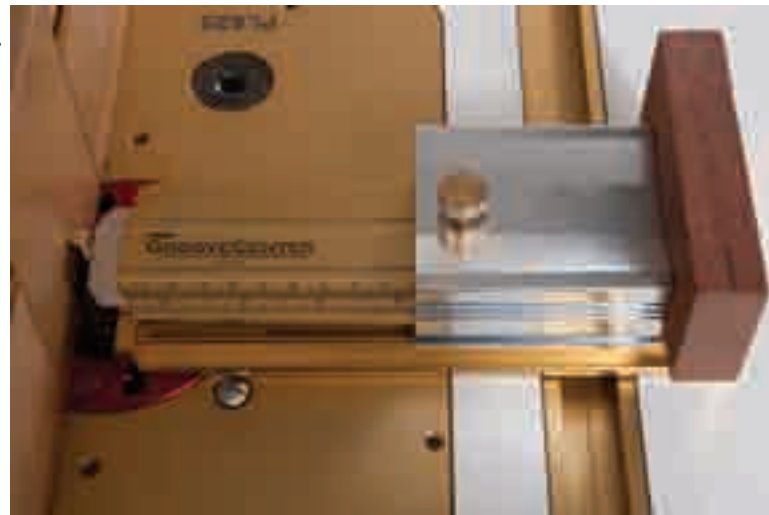


Fig 3.

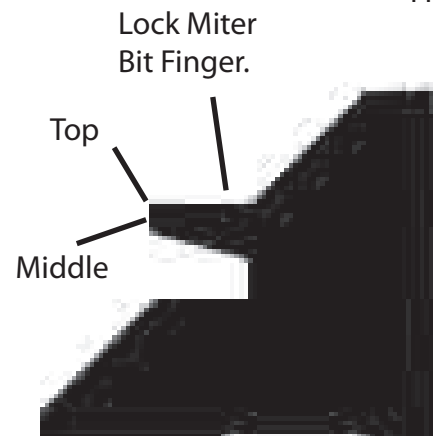


Fig 4.

Introduction to the GrooveCenter

1. Unpack and inspect your GrooveCenter for damage or missing parts.
2. Choose the proper Collet Pin for your router collet. A 1/2" Collet Pin is supplied.
3. The GrooveCenter comes from the factory preset for use. In case the GrooveCenter needs to be reset, follow these steps.
 - A. Loosen the ALLEN screw holding the Fence Stop Pin on and rotate the Fence Stop Pin from horizontal to vertical. Now retighten the screw.
 - B. Loosen the three ALLEN screws located on the underside of the GrooveCenter. (fig3)
 - C. Slide the fence stop back to the zero location. This is when the GrooveCenters Sliding Carriage is fully closed.
 - D. Turn the GrooveCenter over so that you can access the three ALLEN screws on the bottom. Now move the Sliding Pin Insert forward until it contacts the Fence Stop Pin. The Fence Stop Pin should be nesting in the half circle recess located on the Sliding Pin Insert. Now tighten the three ALLEN screws making sure that the Zero Stop is making contact with the rear of the Sliding Pin Insert.
 - E. The Fence Stop Pin is best used in the horizontal position, which allows it to span the gap in a split fence. In case of a continuous fence, the Fence Stop Pin can be used vertically.

Pic A.



Pic C.



Pic B.



Pic D.



Routing Centered Grooves

1. Select the proper size Collet Pin for your router collet. A 1/2" Collet Pin is supplied.
 2. Open the Sliding Carriage of the GrooveCenter and insert your workpiece.
 3. Close the Sliding Carriage around your workpiece and then lock it in place by tightening the Thumb Screw (Do not over-tighten).
 4. Move your router table's fence away from router collet. This will give you room to insert the GrooveCenter.
 5. Bring your router collet up so that it sits just below the table surface. Insert the GrooveCenter's Collet Pin into the collet (fig 1). Do not force it! It is a precision measuring device and should be handled as such.
 6. With the Collet Pin inserted into the router's collet, move the router table's fence towards the GrooveCenter. The fence is in the proper position when it is just touching the Fence Stop Pin of the GrooveCenter.(fig 2)
 7. Secure the router table fence in place and make sure it does not move before the start of your routing operation.
 8. Remove the workpiece from the GrooveCenter by loosening the thumb screw and sliding the fence stop away from the fence.
 9. Remove the GrooveCenter from the router collet.
 10. Insert and tighten your router bit in the router collet. Now raise or lower the bit to the desired height for operation.
- *If the fence is positioned too near to the router collet to insert the router bit, mark the fence position with stop blocks and remove the fence for insertion of the bit.*

Setting up Lock Miter Bits.

Using the GrooveCenter to set up lock miter bits is a very simple process. Follow these steps and you will be cutting perfect lock miters in a matter of minutes.

1. Obtain the proper offset measurement from our database (located at www.praziusa.com) or attached list for the lock miter bit that you will be using. If your bit is not listed check our website or contact us and we will supply you with the appropriate offset number.
2. Making sure the GrooveCenter is properly zero'ed and the stop is snug against the Sliding Pin Insert, flip the GrooveCenter upside down and loosen the set screws 1 and 2 (fig3). Using a caliper, ruler, or spacer adjust the Sliding Pin Insert forward until the gap between it and the stop is equal to the offset measurement from our database.
3. Tighten the set screws.
4. Now insert your workpiece and position the fence just as you would during a normal operation starting at step 1.
5. With your fence in the correct position you will need to measure the proper height for the bit. Using a depth gauge, measure the distance from the lock miter bit's finger (fig 4.) to the fence. Using this measurement raise or lower the bit until the lock miter bit's finger reaches it.

BRAND	PART #	DIAMETER	OFFSET (Magic Number)
AMANA	55389	1.750"	0.501"
	55390	2.687"	0.762"
	55391	1.625"	0.526"
	055393	1.500"	0.505"
CMT	855.503.11	2.75"	0.788"
	855.504.11	2.000"	0.587"
EAGLE AMERICA	192-1602	1.5"	0.464"
	192-2812	2"	0.608"
	192-2815	2"	0.608"
	192-4405	3.125"	0.915"
FREUD	99-034	2.750"	0.813"
	99-035	2.171"	0.637"
INFINITY	55-502	2.000"	0.564"
	55-503	2.750"	0.803"
KATANA	17849	1.75"	0.500"
	17850	2.75"	0.840"
MLCS	5547	1.375"	0.442"
	5548	2"	0.613"
	7847	1.375"	0.431"
	7849	2"	0.625"
	7850	2.75"	0.828"
PORTERCABLE	43503	3.125"	0.875"
PRICE CUTTER	P16-4022	1.5"	0.489"
	P16-4023	2"	0.614"
	P16-4024	2"	0.614"
	P16-4025	3.125"	0.950"
VALUEMAX	807508A	2.000"	0.594"
	807699A	2.750"	0.828"
WHITESIDE	3362	2.000"	0.594"
	3360	3.125"	0.906"

NOTES ABOUT USE

The "magic number" (offset) given by PRAZI USA for each Lock Miter Bit, is based on the manufacturer-supplied specifications. However, small tolerances are possible in Manufacturing processes and it is advisable to calibrate any set-up for a particular Lock Miter Bit.

Therefore, the user is advised to find the "sweet spot" (where both horizontal and vertical distances to the fence and the table respectively are equal), for each particular router bit, and note the finding for future reference. There can be a tiny variation. Generally speaking, for the smaller Lock Miter Bits, this is half-way the small vertical part of the "finger", and for the larger ones, in the top corner.