

ASSEMBLY, OPERATING INSTRUCTIONS  
AND PARTS LIST FOR  
**DOVETAIL TEMPLATE**

**MODEL NUMBER 315.25720**

This is the model number of your Template. It will be found on a decal located on the upper clamping bar. Always mention this model number when communicating with us regarding your Template or when ordering parts.

**HOW TO ORDER REPAIR PARTS**

All parts listed herein may be ordered through Sears, Roebuck and Co. or Simpsons-Sears Limited. When ordering parts by mail from the mail order house which serves the territory in which you live, selling prices will be furnished on request or parts will be shipped at prevailing prices and you will be billed accordingly.

WHEN ORDERING REPAIR PARTS, ALWAYS GIVE THE FOLLOWING INFORMATION AS SHOWN IN THIS LIST:

- |                    |  |
|--------------------|--|
| 1. The PART NUMBER | 3. The MODEL NUMBER—315.25720            |
| 2. The PART NAME   | 4. The NAME of item—DOVETAIL<br>TEMPLATE |

**COAST TO COAST NATION-WIDE  
SERVICE FROM SEARS  
FOR YOUR DOVETAIL TEMPLATE**



SEARS, ROEBUCK AND CO.  
AND SIMPSONS-SEARS LIMITED  
back up your investment with  
quick expert mechanical service  
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If and when you need repairs or  
service, call on us to protect your  
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SEARS, ROEBUCK AND CO.—Chicago, Illinois 60607 U.S.A.  
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# ASSEMBLY AND OPERATING INSTRUCTIONS

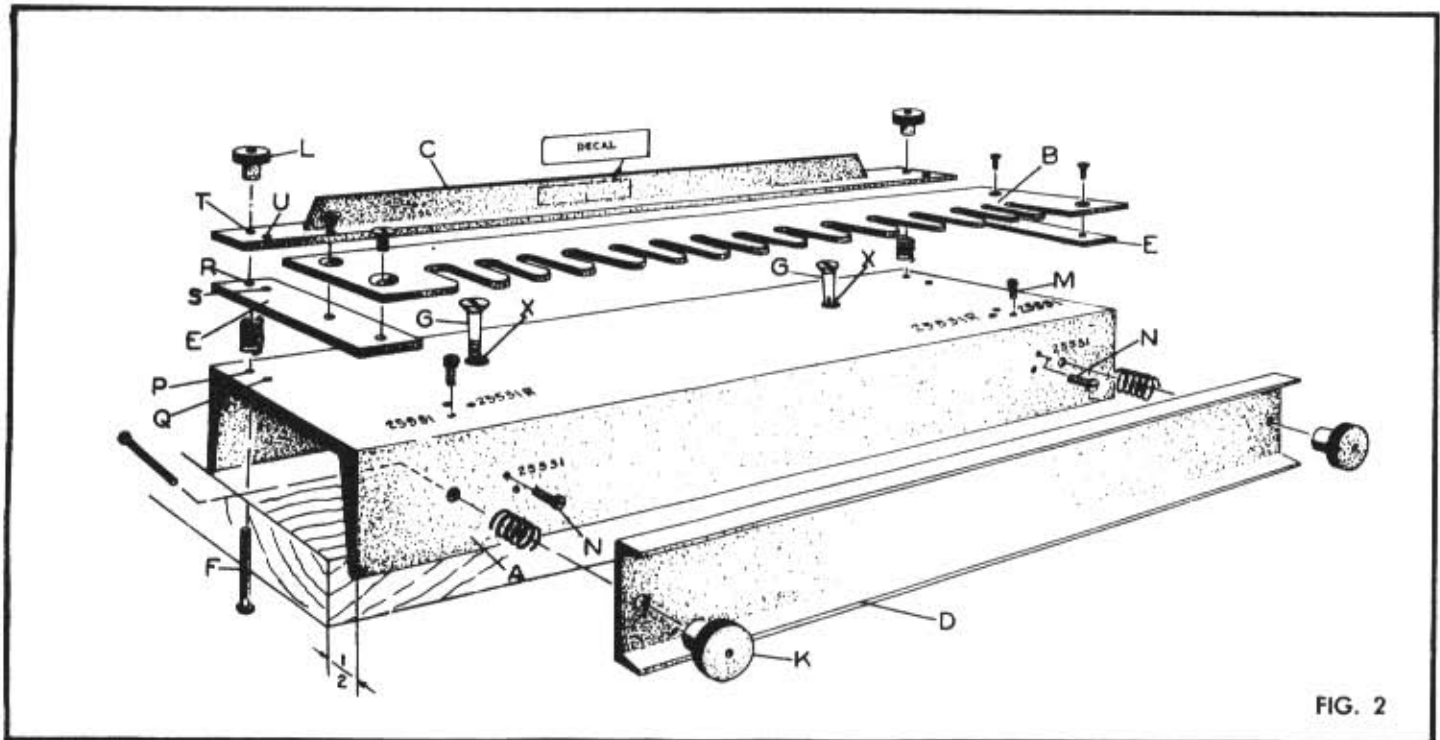


FIG. 2

## GENERAL INFORMATION:

This template is designed for making flush or rabbeted  $\frac{1}{2}$ " dovetail joints using Sears Router Base Model No. 315.25056 and Routers Model No's. 315.25030, 315.25031, 315.25060, 315.25070 and 315.25580 with Adapter and Guide Bushings Cat. No's. 2576, 25059 and Dove-tail Cutter Cat. No. 25531. For proper assembly of the Guide Bushings to your Router consult the operating instructions of the Adapter and Guide Bushing which you are using. Ad-

just the power unit in the router base until the cutter extends  $\frac{19}{32}$ " beyond the base. The Guide Bushing with pilot O.D. of  $\frac{7}{16}$ " must be used with the Dovetail Template.

All of the above mentioned Routers are designed so that the rounded edge of the router base acts as a stop against the clamping bar "C" in Fig. 2. NOTE: If you have Router Model No. 315.25031, it has a flat edge on each side of the base. Always butt the rounded edge of the base, not the flat edge, against the clamping bar "C" to insure proper dovetail length.

## DRAWER SECTIONS

Suggested proportions of drawer section are as follows:

$$\begin{aligned} \text{SIDES} &= \text{DESIRED DEPTH} \\ &- \text{FRONT THICKNESS} \\ &- \text{BACK THICKNESS} + \frac{5}{8}'' \end{aligned}$$

Part	Thickness	Length	Width
Back	$\frac{3}{4}$ " or $\frac{1}{2}$ "	Equal to length of opening less clearance	Equal to height of opening less clearance
Sides	$\frac{3}{4}$ " or $\frac{1}{2}$ "	Opening Depth less $\frac{1}{2}$ "	Equal to height of opening less clearance
Bottom	$\frac{1}{4}$ "	Side length less $\frac{1}{2}$ "	Width is the back length less 2 times side thickness plus $\frac{1}{2}$ "
Flush Front	$\frac{3}{4}$ "	Back length	Back height
Rabbeted Front	$\frac{3}{4}$ "	Back length plus $\frac{3}{4}$ "	Back height plus $\frac{3}{4}$ "

Note: Sides, front and back to be grooved for bottom.

## ASSEMBLY AND MOUNTING INSTRUCTIONS

Your template is packaged completely assembled for making flush or rabbeted dovetail joints using Router Base Model No. 315.25056 and Routers Model No's. 315.25030, 315.25031, 315.25060, 315.25070 or 315.25580. Fig. 2 illustrates the component adjustments required for making flush or rabbeted dovetails with the above Routers. When using Routers Model No's. 315.25030, 315.25031 or Router Base

Model No. 315.25056, insert screws "F" into holes "P" in base "A" and through holes "R" in brackets "E". When using Routers Model No's. 315.25580, 315.25060 and 315.25070 insert screws "F" into holes "Q" in base "A" and through holes "S" in brackets "E".

For flush dovetail drawers insert screws "F" into holes "T" in clamp bar "C". Insert locating screws "M" and "N" in base holes marked 25531.

# ASSEMBLY AND OPERATING INSTRUCTIONS (Continued)

## ROUTING A DOVETAIL DRAWER

Prior to routing the actual drawer sections use two sections of similar scrap wood to check the cutter extension and locating screw positions. To facilitate assembly mark the mating sides of the drawer sections. Mount drawer sections in the fixture with their outer surfaces facing the base. All drawer sections should be flat and the sides should be square. A rabbeted drawer front should be routed  $\frac{3}{8}$ " wide by  $\frac{7}{16}$ " deep around all the edges prior to dovetailing.

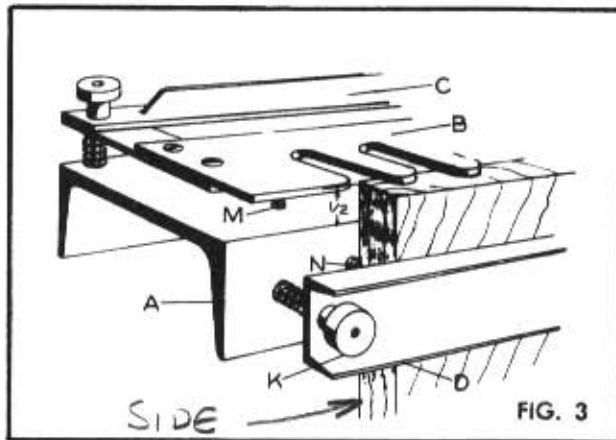


FIG. 3

Figure 3 shows the drawer side placed between clamping bar "D" and base "A". Butt against the left locating screw "N". Extend top of drawer side  $\frac{1}{2}$ " above top of base. Clamp lightly in place with thumb nuts "K". This is a temporary setting.

Position drawer front between clamping bar "C" and base "A" as shown in Fig. 4. Butt the front edge of the drawer front against the drawer side and the side of the drawer front against the left locating screw "M". Clamp tightly in place.

Loosen thumb nuts "K" and position the drawer side against the left locating screw "N" and the finger template. The finger template should be held flat against the drawer front. Clamp the side drawer tightly in place.

Adjust the power unit in the router base until the cutter extends  $\frac{1}{8}$ " beyond the base.  $\frac{18}{32}$  IS CLOSER!

Using the pilot of the router bushing, guide the cutter between and around the template "B" fingers. Always inspect the work before removing it from the fixture, to insure that all sections are clearly routed as shown in Figure 5.

Assemble the two pieces of scrap wood that have been routed. If the joint is too loose, extend the cutter beyond the router base by  $\frac{1}{4}$ ". If the joint is too tight, retract the cutter by  $\frac{1}{4}$ ". Continue using scrap wood until a satisfactory joint is attained.

After attaining the desired router cutter setting, complete the routing of the first dovetail joint using finished wood for the drawer sections. Upon completing this step, reverse the drawer front section end to end (outer surface toward base) and position it against the right locating screw "M". Replace the routed drawer side with the opposite drawer side and position it against the right locating screw "N". The setup and positioning of these drawer sections shall be as previously described except that they shall be located against the right locating screws.

To dovetail the back of the drawer sections follow the above procedure for routing the drawer front sections with the following exceptions:

The drawer side that was originally mounted on the left side of the fixture shall be reversed end to end (outer surface towards base) and shall be mounted on the right side of the fixture.

Likewise, the drawer side that was originally mounted on the right side of the fixture shall be mounted on the left side of the fixture. The drawer back shall be mounted and dovetailed in the same manner as the drawer front.

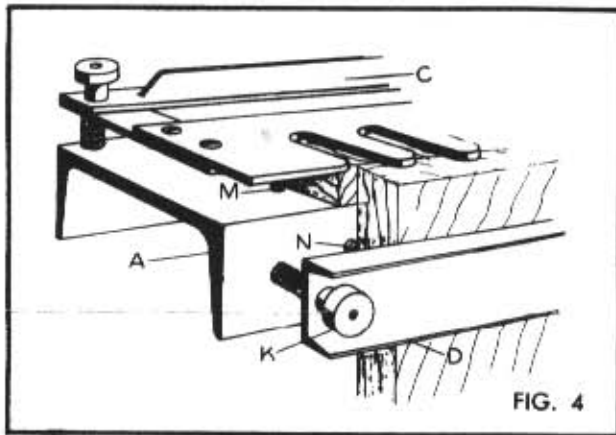


FIG. 4

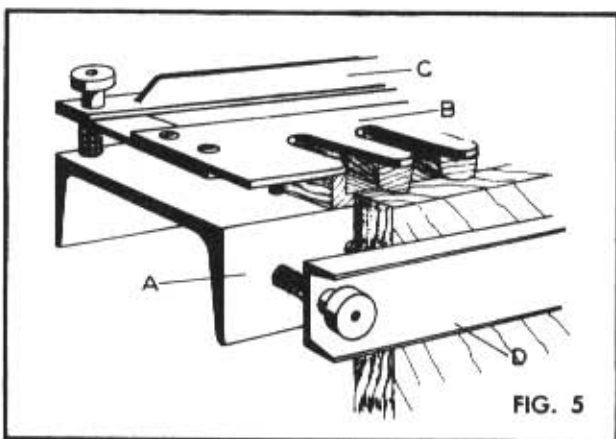


FIG. 5

For a front rabbeted drawer, insert screws "F" into holes "U" in clamp bar "C". Insert locating screws "M" in base holes marked 25531R and locating screws "N" in base holes marked 25531. This setting is used for routing the drawer front only. For the drawer back, change the setting for a flush dovetail as described in the first paragraph under "Assembly and mounting instructions."

## CAUTION

**ROUTE DOVETAIL FROM THE FRONT ONLY — DO NOT LIFT OR LOWER ROUTER WHILE CUTTER IS BETWEEN DOVETAIL TEMPLATE FINGERS.**

# MODEL NUMBER 315.25720 - PARTS LIST - DOVETAIL TEMPLATE

WHEN ORDERING REPAIR PARTS, ALWAYS GIVE THE FOLLOWING INFORMATION:

1. THE PART NUMBER  
2. THE PART NAME

3. THE MODEL NUMBER—315.25720  
4. THE NAME OF ITEM—DOVETAIL TEMPLATE

**DO NOT USE KEY NOS. WHEN ORDERING REPAIR PARTS. ALWAYS USE PART NUMBERS.**

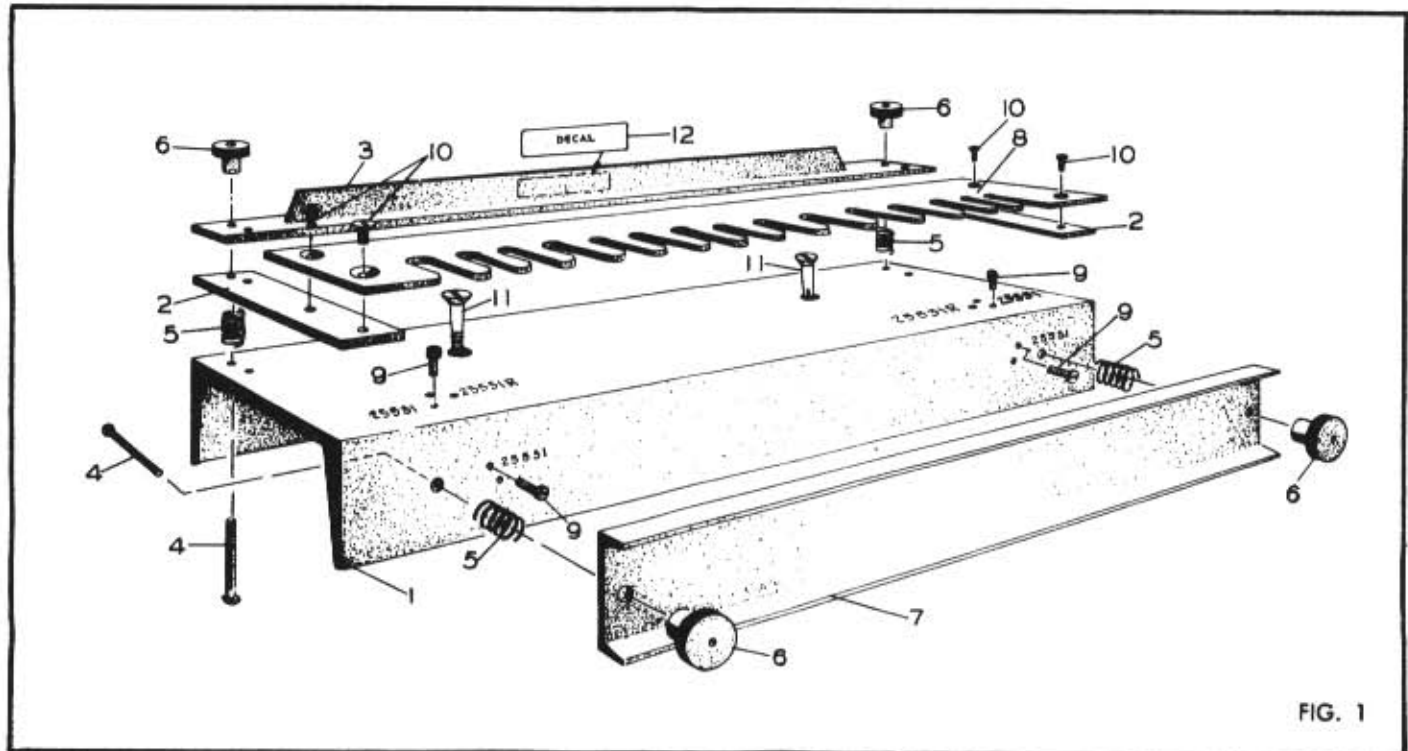


FIG. 1

KEY NO.	PART NO.	DESCRIPTION
1	4-714795-02	Base with Base Supports
2	3-714798-00	Bracket
3	3-714796-00	Clamping Bar
4	1-930517-74	*Clamping Bar Screw (1/4-20 Round Head 2" Long)
5	1-714801-00	Spring
6	1-714800-00	Knob
7	2-714799-00	Clamping Bar
8	3-714797-00	Dovetail Template
9	1-930330-60	*Screw (# 10-32 Fillister Head 3/16" Long)
10	1-930174-14	*Screw (1/4-20 Flat Head 3/8" Long)
11	1-714784-02	*Wood Screw (# 12 Flat Head 2 1/2" Long)
12	1-992027-00	Decalcomania
13	EN-2996	Instruction Sheet

\*Standard Hardware Item, may be purchased locally.

This sheet is intended for instruction and repair parts only and is not a packing slip.

The parts shown and listed may include accessories not necessarily part of this tool.

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