

Create with Confidence™

Small Parts Taper Jig instructions

Effective May 2020



Safety equipment removed for clarity

Review full instructions prior to use for important safety information.
Always check [Rockler.com](https://www.rockler.com) to confirm that you are using the most recent version of instructions for your product.

GENERAL SAFETY WARNINGS

This product is designed only for specific applications as defined in the instructions and should not be modified or used for any manner not described in these instructions. Use only recommended accessories. Before using the Small Parts Taper Jig: **READ, UNDERSTAND** and **FOLLOW ALL INSTRUCTIONS AND SAFETY WARNINGS. KEEP THESE INSTRUCTIONS READILY AVAILABLE FOR FUTURE REFERENCE.**

- > Always confirm that you are using the most recent version of the Instructions and safety warnings for your product (see the Instructions link on the product page at Rockler.com).
- > Before using another tool with this product, always read, understand and follow the instructions and safety warnings in the owner's manual for that tool. If you do not have the owner's manual, obtain one from the tool's manufacturer before using it with this product.
- > Before using any chemical with this product, always read, understand and follow all safety warnings and guidelines in the manufacturer's Safety Data Sheet (SDS; formerly called "MSDS"), especially regarding:
 - How to safely use the chemical, including potential hazards and recommended first aid measures;
 - Personal safety equipment required to safely use the chemical (e.g. gloves, eye protection, mask/respirator, etc.);
 - Proper and safe handling, storage and disposal of the chemical.
- > Before using this product, review and verify that all tools to be used with it have safety equipment installed and are in proper working order as defined by the tool's owner's manual.
- > Do not use this product until you have read and are confident you understand:
 - Product Specific Warnings (p. 3);
 - Assemble the Fence (p. 4);
 - Assemble the Base (pp. 4 - 5);
 - Mount the Fence to the Base (p. 5);
 - Set Up at the Saw (pp. 5 - 6);
 - Jig Use (pp. 6 - 7).
- > The user assumes all risk and responsibility for the proper and safe use of this product and for ensuring product suitability for the intended application.
- > It is the sole responsibility of the purchaser of this product to ensure that any anyone you allow to use this product reads and complies with all instructions and safety precautions outlined in this manual prior to use.
- > Follow all standard shop safety practices, including:
 - Keep children and bystanders away from the tool operating area;
 - Do **NOT** use power tools in explosive environments, or in the presence of flammable liquids, fumes or dust;
 - **TURN OFF AND UNPLUG** all power tools **BEFORE** making any adjustments or changing accessories;
 - Remain alert and use good judgment. Do not use this product if you are in any way impaired by medications, alcohol, drugs or fatigue;
 - Keep your work area well lit and clean;
 - Dress appropriately. Secure loose clothing, remove all jewelry and tie up long hair before using this product;
 - **ALWAYS** wear safety glasses, hearing protection and respiratory protection that complies with NIOSH/OSHA/ANSI safety standards;
 - Use dust collection tools and dust face masks to reduce exposure to dust;
 - Use safety equipment such as featherboards, push sticks and push blocks, etc., when appropriate;
 - Maintain proper footing at all times and do not overreach;
 - Do **NOT** force woodworking tools.
- > These warnings and instructions do **NOT** represent the total of all information available regarding tool safety, use and technique. Always seek out opportunities to learn more and improve your skills and knowledge.

⚠ WARNING: Drilling, sawing, sanding or machining wood products can expose you to wood dust, a substance known to the State of California to cause cancer. Avoid inhaling wood dust or use a dust mask or other safeguards for personal protection. For more information go to www.P65Warnings.ca.gov/wood.

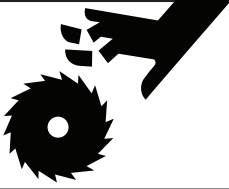
⚠ DANGER Danger indicates a hazardous situation that, if not avoided, will result in death or serious injury.

⚠ WARNING Warning indicates a hazardous situation that, if not avoided, could result in death or serious injury.

⚠ CAUTION Caution indicates a hazardous situation that, if not avoided, may result in minor or moderate injury or property damage.

NOTICE Notice indicates important or helpful information and/or user tips.

PRODUCT SPECIFIC SAFETY WARNINGS

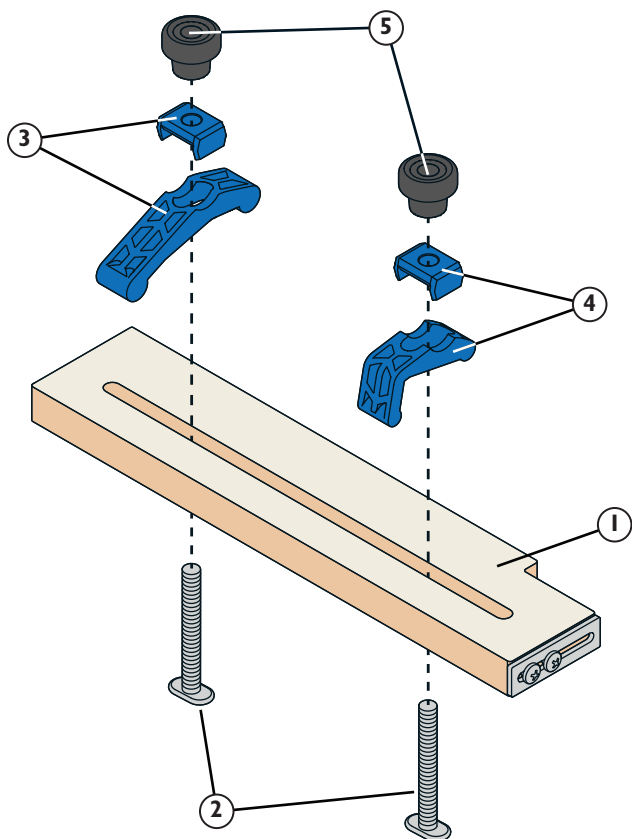


DANGER

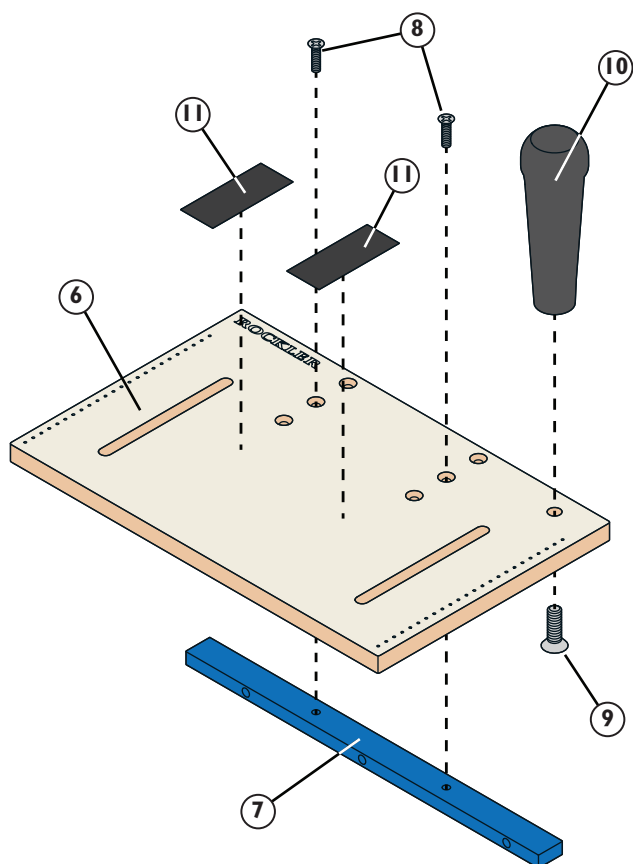
- > To avoid serious injury, keep hands and fingers out of the path of the spinning blade. Maintain awareness of the blade and safe hand position at all times. Make sure fingers and hands are not positioned in the path of the blade.

WARNING

- > The Small Parts Taper Jig is intended for use by intermediate to experienced woodworkers. It requires a comprehensive understanding of how to safely use a table saw and avoid dangerous risks.
- > The Small Parts Taper Jig is intended for use only on table saws with a standard 3/4" W x 3/8" D miter slot. Do **NOT** use with a router table.
- > The Small Parts Taper Jig is designed for use on table saws whose right miter slot is between 4" and 6½" from the right edge of the saw blade.
- > **Maximum workpiece thickness: 7/8"**
Maximum workpiece width: 4"
Maximum workpiece length: 11½"
- > **Minimum workpiece size:** Both Hold Down Clamps must be used to secure the workpiece to the jig. **Workpieces that are too small or narrow to be held by both Hold Down Clamps MUST NOT be cut with the jig.**
- > Do **NOT** use the jig without the Tall Handle (10) installed. Before each use, make sure that the Tall Handle is fully tightened to the jig Base (6).
- > Do **NOT** use without the Adjustable Fence (1) installed. The 1" Round Knobs (5) securing the Adjustable Fence to the jig Base (6) must be fully tightened to prevent dangerous shifting during the cut.
- > The metal Adjustable Stop at the end of the Adjustable Fence (1) **MUST** be used during cuts. Make sure it is extended far enough to support the workpiece but not so far as to contact the blade as the jig is advanced through the cut. Make sure the screws securing the Adjustable Stop are fully tightened (but not overtightened).
- > Hold Down Clamps (3 and 4) must be positioned so that they will not come into contact with saw blade, guard or riving knife at any point during the cut.
- > To minimize the chance of dangerous kickback, tighten Hold Down Clamps (3 and 4) to secure the workpiece after making any adjustments and before making the cut. Do **NOT** overtighten.
- > In the setup process on many saws, your initial cut will remove a narrow piece of the jig's Base to fit your specific saw and to create zero-clearance support. Read the instructions carefully to complete this essential setup step. Do **NOT** remove more than 1/2" from the edge of the jig Base (6).
- > Keep the saw blade as low as possible to make the cut as specified by your table saw's instruction manual.
- > Before making the actual cut, become familiar with the cutting process by practicing the motion of the cut with the blade lowered and the power turned off.
- > When making cuts, the Miter Bar (7) **MUST** be securely attached to the jig. The table saw fence must not be used for taper cuts.
- > Before every use, make sure the 1/4"-20 Countersunk Screws (8) holding the Miter Bar (7) to the jig Base (6) are fully tightened. If loosening becomes a problem, apply thread-locking liquid to the screws and fully tighten them.
- > When using the Small Parts Taper Jig, the Miter Bar (7) should be positioned in the miter slot on the right side of the saw blade.
- > The Miter Bar (7) **MUST** be able to slide freely forward and backward without side-to-side play. **NEVER** attempt to force the jig if it fails to slide freely.
- > **STOP USING THE JIG IMMEDIATELY** if any component develops a crack or other sign of the loss of structural integrity.



Assembly the Fence



Assemble the Base

PARTS LIST

Quantity

1	Adjustable Fence	1
2	5/16"-18 x 2½" T-Bolt	2
3	Large Hold Down Clamp with Pivot	1
4	Small Hold Down Clamp with Pivot	1
5	Easy-to-Grip 1" Round Knob	2
6	Base	1
7	Miter Bar	1
8	1/4"-20 Countersunk Screw	2
9	5/16"-18 Countersunk Screw	1
10	Easy-to-Grip Tall Handle	1
11	Anti-Slip Strip	2
12	5/16"-18 x 1½" T-Bolt	2

Assemble the Fence

1. Fit the 5/16"-18 x 2½" T-Bolts (2) up through the slot in the Adjustable Fence (1).
2. Fit the Small Hold Down Clamp with Pivot (4) onto the 5/16"-18 x 2½" T-Bolt (2) nearest the end of the fence with the Adjustable Stop and thread on an Easy-to-Grip 1" Round Knob (5).
3. Fit the Large Hold Down Clamp with Pivot (3) onto the other 5/16"-18 x 2½" T-Bolt (2) and thread on an Easy-to-Grip 1" Round Knob (5).

Assemble the Base

⚠WARNING

- > The Small Parts Taper Jig is designed for use on table saws whose right miter slot is between 4" and 6½" from the right edge of the saw blade.

NOTICE

- The Small Parts Taper Jig has three sets of holes for mounting the Miter Bar (7) to the jig Base (6) to accommodate the varying distance on different table saws from the right miter slot to the right edge of the saw blade. Choose the set of holes that will result in trimming the least amount from the jig Base.

1. Choose the appropriate set of Miter Bar (7) mounting holes for your particular saw.

⚠WARNING

- Before every use, make sure the 1/4"-20 Countersunk Screws (8) holding the Miter Bar (7) to the jig Base (6) are fully tightened. If loosening becomes a problem, apply thread-locking liquid to the screws and fully tighten them.

2. Attach the Miter Bar (7) to the underside of the jig Base (6) with the two 1/4"-20 Countersunk Screws (8) driven through the top of the jig Base. Make sure that the screws are fully tightened.

3. Fit the 5/16"-18 Countersunk Screw (9) up through the hole in the back corner of the Base (6) and thread on the Easy-to-Grip Tall Handle (10). Fully tighten the Tall Handle.
4. Apply the two Anti-Slip Strips (11), spacing them evenly between the slots in the Base (6).

Mount the Fence to the Base

1. Fit the 5/16"-18 x 1½" T-Bolts (12) up through the slots in the jig Base (6). Then Fit the Adjustable Fence assembly onto the T-Bolts.
2. Thread the 1" Round Knobs (5) onto the 5/16"-18 x 1½" T-Bolts (12) to secure the Adjustable Fence assembly to the Base (6).

Set Up at the Saw

THESE WARNINGS PERTAIN TO ALL REMAINING STEPS:

⚠ DANGER

- > To avoid serious injury, keep hands and fingers out of the path of the spinning blade. Maintain awareness of the blade and safe hand position at all times. Make sure fingers and hands are not positioned in the path of the blade.



⚠ WARNING

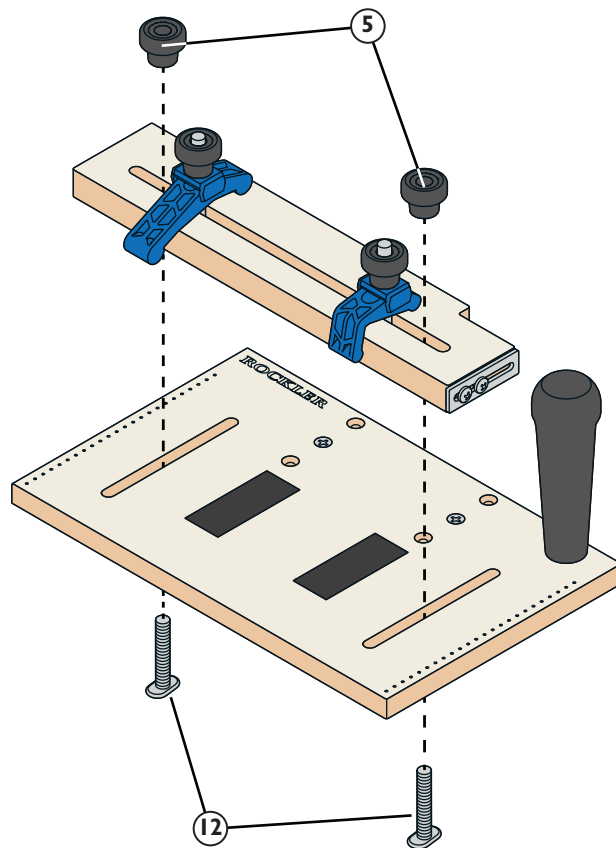
- > When using the Small Parts Taper Jig, the Miter Bar (7) should be positioned in the miter slot on the right side of the saw blade.
- > In the setup process on many saws, your initial cut will remove a narrow piece of the jig's Base (6) to fit your specific saw and to create zero-clearance support. Do NOT remove more than 1/2" from the edge of the jig Base.
- > Do NOT use the jig without the Easy-to-Grip Tall Handle (10) installed. Before each use, make sure that the Tall Handle is fully tightened to the jig Base (6).

1. With your table saw unplugged, confirm that the blade is parallel with the miter slot. If it is not, adjust it according to the manufacturer's guidelines.

⚠ WARNING

The Miter Bar (7) **MUST** be able to slide freely forward and backward without side-to-side play. **NEVER** attempt to force the jig if it fails to slide freely.

2. Lower the saw blade and place the jig on the saw table. Adjust the nylon set screws in the Miter Bar (7) with the included Mini Screwdriver so the jig slides freely in the saw's miter track. **Fig. 1.**



Mount the Fence to the Base



Fig. 1



Fig. 2

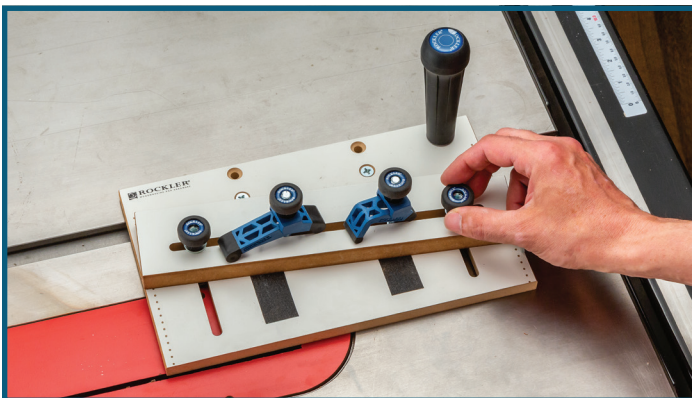


Fig. 3



Fig. 4

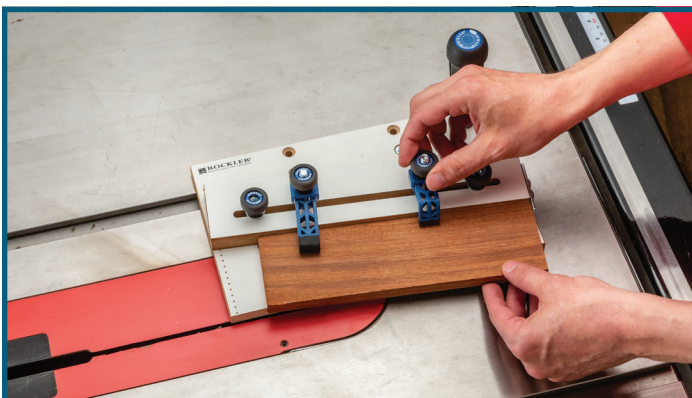


Fig. 5

⚠ WARNING

Keep the saw blade as low as possible to make the cut as specified by your table saw's instruction manual.

Before making the actual cut, become familiar with the cutting process by practicing the motion of the cut with the blade lowered and the **power turned off**.

3. With the jig's Miter Bar (7) seated fully in the saw's right miter slot, pull the jig back so that it is clear of the cutting area. Raise the saw blade, plug in and turn on the saw and then advance the jig past the blade to trim the Base (6) and establish the zero-clearance edge. **Fig. 2.**

Jig Use

THESE WARNINGS PERTAIN TO ALL REMAINING STEPS:

⚠ DANGER

- > To avoid serious injury, keep hands and fingers out of the path of the spinning blade. Maintain awareness of the blade and safe hand position at all times. Make sure fingers and hands are not positioned in the path of the blade.



⚠ WARNING

- > When using the Small Parts Taper Jig, the Miter Bar (7) should be positioned in the miter slot on the right side of the saw blade.
- > Before every use, make sure the 1/4"-20 Countersunk Screws (8) holding the Miter Bar (7) to the jig Base (6) are fully tightened. If loosening becomes a problem, apply thread-locking liquid to the screws and fully tighten them.
- > The Miter Bar (7) **MUST** be able to slide freely forward and backward without side-to-side play. **NEVER** attempt to force the jig if it fails to slide freely.

For safe operation of the Taper/Straight-Line Jig, your workpiece **must not be more than 7/8" thick, 4" wide and 11 1/2" long.**

1. Position the Adjustable Fence (1) to achieve the desired taper and to remove the desired amount of stock. **Fig. 3.** There are several ways to set the taper angle:
 - A. Use the indexing marks at both ends of the jig to set the taper. The marks are 1/4" apart.
 - B. Align marks on your stock indicating the beginning and end of the taper with the zero-clearance edge of the jig.
2. Secure the Adjustable Fence (1) in position by tightening the 1" Round Knobs (5) at each end.

3. Place your stock tight against the Adjustable Fence (1), with the eventual narrow end flush against the Adjustable Stop at the end of the fence. Position the Adjustable Stop so that it will support the stock but won't come into contact with the saw blade during the cut. Make certain that it is securely fastened. **Fig. 4.**

⚠WARNING

Hold Down Clamps (3 and 4) must be positioned so that they will not come into contact with saw blade, guard or riving knife at any point during the cut.

To minimize the chance of dangerous kickback, tighten Hold Down Clamps (3 and 4) to secure the workpiece after making any adjustments and before making the cut. Do not overtighten.

4. Position the Large and Small Hold Down Clamps (3 and 4), spacing them proportionally along the workpiece. Make sure that the Hold Down Clamps will not come into contact with the saw blade, guard or riving knife during the cut. Turn the Easy-to-Grip 1" Knobs (5) to tighten the Hold Down Clamps and secure the workpiece. **Fig. 5.**
5. With the saw turned off, lower the blade and rehearse the cut by using the Easy-to-Grip Tall Knob (10) to move the jig forward.

6. Position your hand on the jig as shown and push the jig past the retracted blade, keeping your hands well clear of the cutting area and making sure that the Adjustable Stop won't come into contact with the saw blade during the cut. **Fig. 6.**

7. Make any adjustments necessary and check to be sure all knobs are secure.

⚠WARNING

Keep the saw blade as low as possible to make the cut as specified by your table saw's instruction manual.

Before making the actual cut, become familiar with the cutting process by practicing the motion of the cut with the blade lowered and the **power turned off**.

8. Return the jig to the starting position, raise the blade, turn the saw on and carefully make the cut.

Check Rockler.com for updates. If you have further questions, please contact our Technical Support Department at 1-800-260-9663 or support@rockler.com

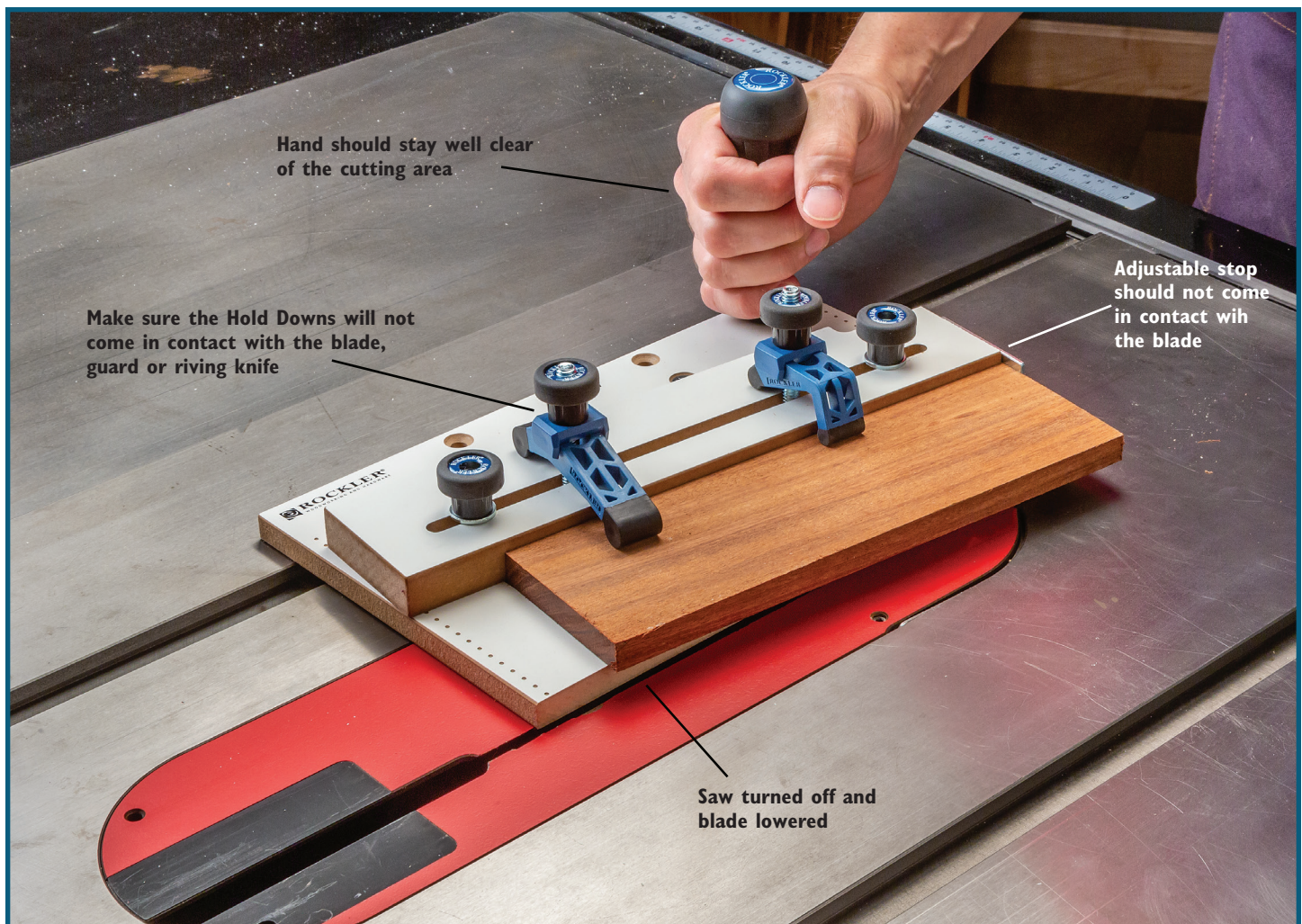


Fig. 6 - Safety equipment removed for clarity

