



ROCKLER®

CREATE WITH CONFIDENCE

ProMax Fence Instructions

Effective October 2023



Review full instructions prior to use for important safety information.
Always check 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 ProMax Fence: **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 Safety Warnings (p. 3);
 - Parts List (p. 4);
 - Assembly (p. 4);
 - Adjusting the MDF Fence Faces (p. 5);
 - Using the Micro-Adjust Function (p. 6);
 - Using the Jointer Bars (p. 7);
 - Fine-Tuning the Infeed Fence (p. 8).
 - > 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 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.

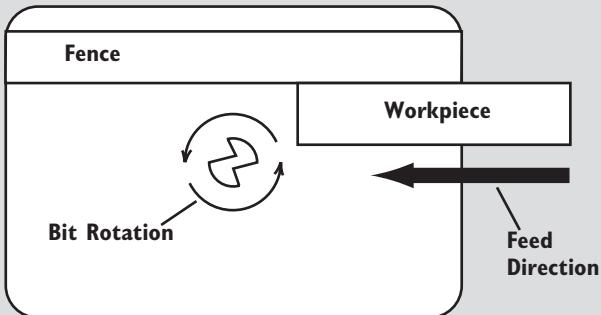
PRODUCT SPECIFIC SAFETY WARNINGS



⚠ DANGER

- > To avoid serious injury, keep hands and fingers away from the spinning router bit. Maintain awareness of the bit at all times.

⚠ WARNING



AVOID THIS SITUATION!

- > **NEVER FEED YOUR WORKPIECE BETWEEN THE BIT AND THE FENCE.** Because of the direction of the bit's rotation, the bit could "grab" the workpiece and propel it away from the table at a high velocity, potentially resulting in property damage and serious injury to anyone in its path.
- > Additionally, when the bit grabs the workpiece, your hands could be drawn into the bit, resulting in serious injury.

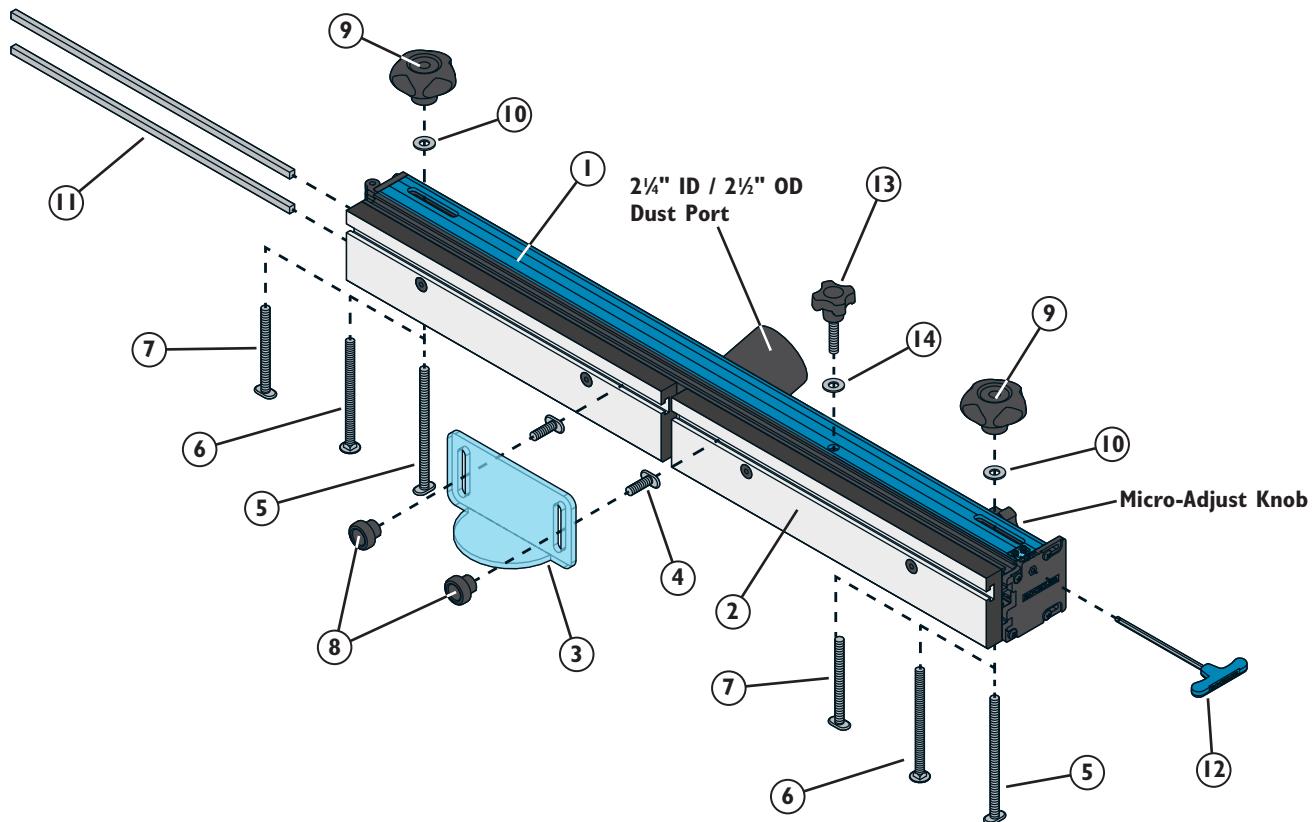
- > Turn off and unplug your router before installing or adjusting the bit or adjusting the ProMax Fence.
- > **BEFORE** beginning any routing operation, **ALWAYS** make sure that **ALL** knobs on the ProMax Fence — including the Fence Locking Knob — have been tightened and the fence will not shift during use.
- > Always feed the workpiece against the rotation of the bit. A table-mounted router spins the bit counterclockwise, so feed the workpiece from right to left as you face the table. This provides better control because the rotation of the bit is backward and toward the fence instead of forward and away from it.
- > **NEVER** attempt to machine a workpiece at the router table without using the ProMax Fence or a starter pin with a bearing-guided bit. Failure to use these guides diminishes your ability to control the workpiece and greatly increases the chance of damage to the workpiece and/or serious personal injury.
- > **BEFORE** plugging in and turning on the router, always check to be sure that the MDF Adjustable Fence Faces (2) are fully secured and that the bit can rotate freely without

touching the Fence Faces. An exception to this is if you have set up the infeed Fence Face to provide zero-clearance support for the workpiece, as described in the "Adjusting the Fence Faces" section on Page 5.

- > Do **NOT** attempt to use the ProMax Fence to joint board edges that are thicker than 1 $\frac{1}{4}$ ". The maximum material thickness might be further limited by the cutting height of the router bit being used. For example, a bit with a 3/4" cutting height will be able to joint only boards that are 3/4" thick or less.
- > When working with narrow boards, use a push block or push stick to advance the workpiece to avoid fingers from contacting the bit and causing serious injury.
- > Use only 1/2" shank router bits for jointing. The thicker shank will provide less chatter and cleaner cuts. The bit's cutting height must not exceed 1 $\frac{1}{2}$ ".
- > Never use a router bit that is damaged or dull.
- > Never exceed the manufacturer's recommended maximum operating speed for your router bit.

⚠ CAUTION

- > Set the Bit Safety Guard (3) directly over the router bit, at least 1/2" above the top of the bit or the top of the workpiece (whichever is highest) to make sure that the bit doesn't cut into the Bit Safety Guard.
- > When adjusting the position of the ProMax Fence, make sure that no part of the aluminum body will contact the router bit.
- > If using the Jointer Bars (11), always use them in pairs. Failure to install both Jointer Bars is likely to yield poor results.



PARTS LIST

Quantity

Quantity

1 Fence Body	1	8 5/16"-18 1" Round Knob	2
2 MDF Adjustable Fence Face	2	9 5/16"-18 Five-Star Knob	2
3 Bit Safety Guard	1	10 5/16" Nylon Washer	2
4 5/16"-18 x 1" T-Bolt	2	11 Jointer Bar	2
5 5/16"-18 x 5" T-Bolt	2	12 Hex Key	1
6 5/16"-18 x 4 1/2" Carriage Bolt	2	13 Fence-Locking Knob	1
7 5/16"-18 x 3 1/2" T-Bolt	2	14 1/4" Nylon Washer	1

Assembly

NOTICE

Three different types of bolts are included for mounting the ProMax Fence to any of Rockler's router tabletops: 5/16"-18 x 5" T-Bolts; 5/16"-18 x 3 1/2" T-Bolts; and 5/16"-18 x 4 1/2" Carriage Bolts. Use the bolts that work with your tabletop.

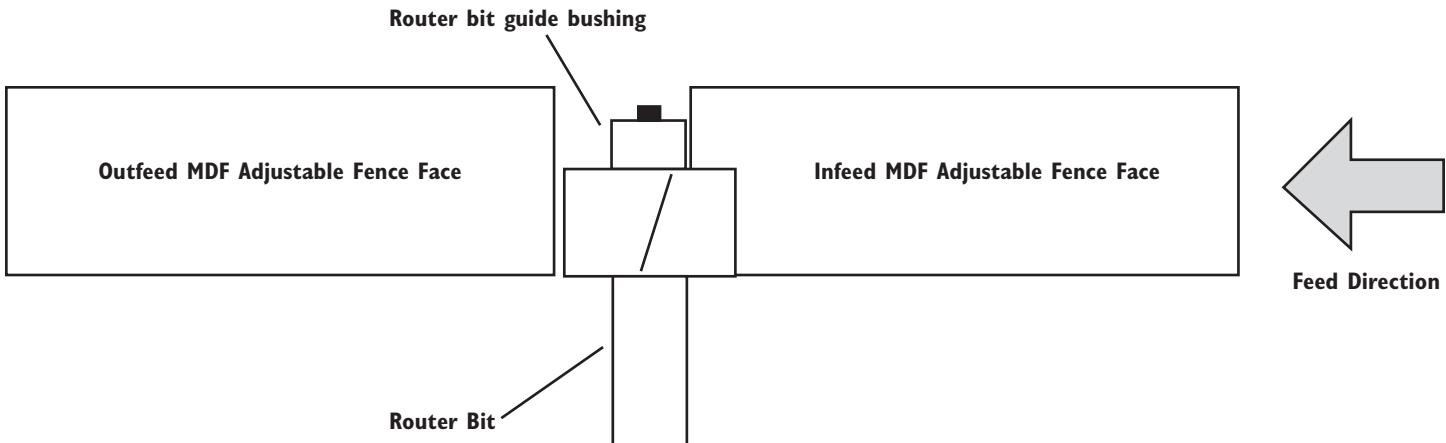
CAUTION

Set the Bit Safety Guard (3) directly over the router bit, at least 1/2" above the top of the bit or the top of the workpiece (whichever is highest) to make sure that the bit doesn't cut into the Bit Safety Guard.

When adjusting the position of the ProMax Fence, make sure that no part of the aluminum body will contact the router bit.

1. Slide a 5/16"-18 x 1" T-Bolt (4) into the forward-facing T-Slot of each MDF Adjustable Fence Face (2). Fit the Bit Safety Guard (3) over the T-Bolts and secure with a 1" Round Knob (8) on each T-Bolt.
2. Insert the appropriate 5/16"-18 Bolts for your router tabletop (5, 6 or 7) into the slots in the bottom of the Fence Body (1) and out the slots in the top. Then fit a 5/16" Nylon Washer (10) and loosely thread a 5/16"-18 Five-Star Knob (9) on each.
3. Fit the bottoms of the appropriate 5/16"-18 Bolts (5, 6 or 7) into the mounting slots in your router table.

4. Slide the ProMax Fence to the desired position and tighten the 5/16"-18 Five-Star Knobs (9) to lock it in position.
5. Fit a 5/16" Nylon Washer (10) onto the post of the Fence-Locking Knob (13) and then thread the post into the hole in the top of the fence.



Infeed Fence Face Adjusted to Provide Zero-Clearance Support

Adjusting the MDF Fence Faces



The two MDF Adjustable Fence Faces (2) are designed to slide about 2" along the fence. As a result, the opening for the router bit can be adjusted from 0" up to 3 $\frac{1}{4}$ ". Generally, you want to set the Adjustable Fence Faces (2) as close to the bit as possible (without contacting the cutter) to provide support for your workpiece during the cut. Setting both infeed and outfeed Adjustable Fence Faces close to the bit helps prevent the ends of the workpiece from drifting too far into the cutter at the beginning and end of the cut, providing enhanced safety and cut quality.

In some cases, you might want “zero-clearance” support to deliver an even cleaner cut. This involves cutting the router bit profile into the front edge of the infeed Adjustable Fence Face so that there’s virtually no gap between the cutter and the Fence Face. It delivers a cleaner cut because the workpiece fibers are fully supported throughout the cut.

If a zero-clearance setting is necessary, follow these steps:

WARNING Turn off and unplug your router before installing or adjusting the bit or adjusting the Router Table Fence.

Never use a router bit that is damaged or dull.

Never exceed the manufacturer’s recommended maximum operating speed for your router bit.

CAUTION Set the Bit Safety Guard (3) directly over the router bit, at least 1/2" above the top of the bit or the top of the workpiece (whichever is highest) to make sure that the bit doesn’t cut into the Bit Safety Guard.

When adjusting the position of the Router Table Fence, always ensure that no part of the Aluminum Fence (1) will contact the router bit.

1. Use the blue-handled Hex Key (12) to slightly loosen the flat-head hex screws that secure the MDF Adjustable Fence Faces to the Fence Body (1). (Don’t loosen them too far, however, or they could disengage from the weld nuts that snug them to the Fence Body.) Slide the MDF Adjustable Fence Faces outward enough that they won’t contact the bit when the fence is moved into position.
2. Set the bit height and use a straightedge to position the fence so that the faces of the MDF Adjustable Fence Faces (2) are flush with the router bit’s guide bearing. Set both Fence Faces close to the bit, but not touching it, and tighten the flat-head hex screws on the outfeed Fence Face. The Fence Faces **MUST NOT** contact the bit at this time.
3. Install and secure the Bit Safety Guard (3).
4. Start the router and slowly slide the infeed MDF Adjustable Fence Face (2) into the spinning router bit, stopping when the edge reaches the bit’s guide bearing or midpoint (for bits that don’t have a guide bearing).
5. Turn off the router. Fully tighten the flat-head hex screws on the infeed MDF Adjustable Fence Face (2) to secure it in position.

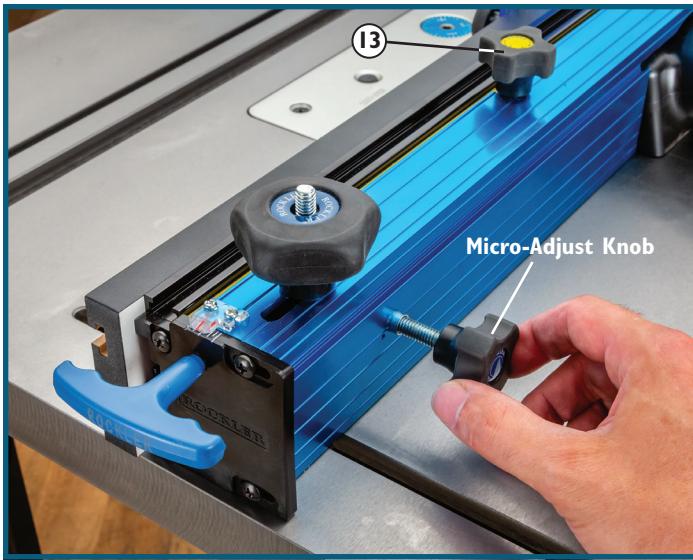


Fig. 1

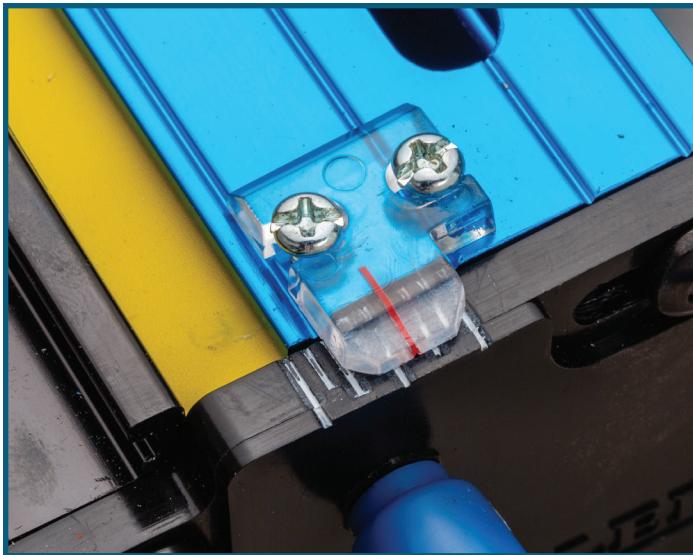


Fig. 2

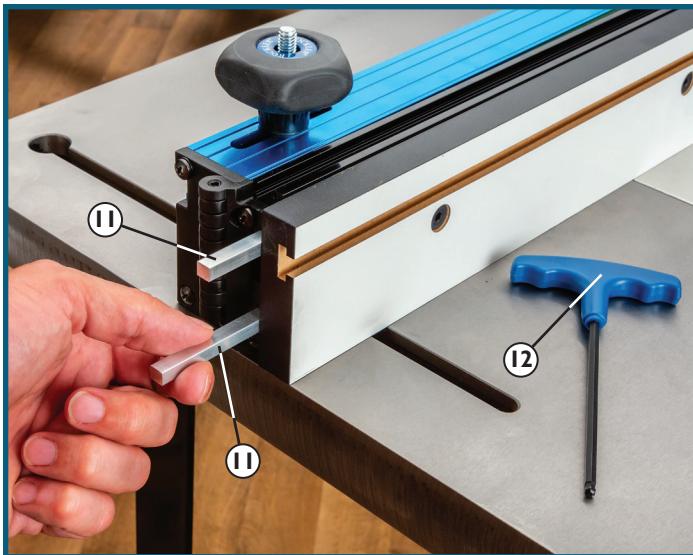


Fig. 3

Using the Micro-Adjust Function

WARNING

> **BEFORE** beginning any routing operation, **ALWAYS** make sure that **ALL** knobs on the ProMax Fence — including the Fence Locking Knob — have been tightened and the fence will not shift during use.

> **BEFORE** plugging in and turning on the router, always check to be sure that the MDF Adjustable Fence Faces (2) are fully secured and that the bit can rotate freely without touching the Fence Faces. An exception to this is if you have set up the infeed Fence Face to provide zero-clearance support for the workpiece, as described in the “Adjusting the MDF Fence Faces” section on Page 5.

NOTICE

As with most jigs, we recommend making test cuts with offcuts or scrap pieces matching the thickness of your final workpieces to achieve the proper setup before machining your final workpieces.

The ProMax Fence's two-part pivot design and micro-adjust function allow the MDF Adjustable Fence Faces (2) to be fine-tuned forward (or back) without having to move the rest of the fence. Whether the movement is forward or back depends on how you initially set the Micro-Adjust Knob on the fence.

For example, if you are routing an edge profile on a board that's prone to router burn, you might want to do it in several lighter passes, moving the fence face backward a bit with each pass. In this application, you would start with the fence adjusted out.

If you want to make it easier to align the fence face with the guide bearing on a router bit, you might start with the fence face adjusted back as far as it will go and set the fence close to but a little back from the edge of the guide bearing. Then you can turn the Micro-Adjust Knob to move the fence out until it's perfectly flush.

To use the micro-adjust function:

1. Loosen the Fence-Locking Knob (13) on the top of the fence. **Fig. 1.**
2. Slightly turn the Micro-Adjust Knob on the back of the fence to move the fence face forward or back, as desired. You can track the adjustment using the clear indicator and scale on the end of the ProMax Fence. Yellow tape on the top of the black part of the fence also will become visible as you adjust the fence face outward. Note that the middle of the fence (where the bit is located) will move about half the distance shown with the indicator lines. We recommend that you make small adjustments to sneak up on the right setting. **Fig. 2.**
3. Tighten the Fence-Locking Knob (13) on the top of the fence to secure the fence face in position.
4. Make another test cut to verify that the setting is correct.
5. Repeat Steps 1-3 until you achieve the desired results.

Using the Jointer Bars

THESE WARNINGS PERTAIN TO ALL REMAINING STEPS:



⚠ DANGER

- > To avoid serious injury, keep hands and fingers away from rotating cutter. Maintain awareness of the cutter at all times.

⚠ WARNING

- > Turn off and unplug your router before installing or adjusting the bit or adjusting the ProMax Fence.
- > Do NOT attempt to use the ProMax Fence to joint board edges that are thicker than 1 1/4". The maximum material thickness might be further limited by the cutting height of the router bit being used. For example, a bit with a 3/4" cutting height will be able to joint only boards that are 3/4" thick or less.
- > **BEFORE** beginning any routing operation, **ALWAYS** make sure that **ALL** knobs on the ProMax Fence — including the Fence Locking Knob — have been tightened and the fence will not shift during use.
- > Always feed the workpiece against the rotation of the bit. A table-mounted router spins the bit counterclockwise, so feed the workpiece from right to left as you face the table. This provides better control because the rotation of the bit is backward and toward the fence instead of forward and away from it.
- > Use only 1/2" shank router bits for jointing. The thicker shank will provide less chatter and cleaner cuts. The bit's cutting height must not exceed 1 1/2".
- > When working with narrow boards, use a push block or push stick to advance the workpiece to avoid fingers from contacting the bit and causing serious injury.

⚠ CAUTION

- > If using the Jointer Bars (11), always use them in pairs. Failure to install both Jointer Bars is likely to yield poor results.
- > When adjusting the position of the ProMax Fence, make sure that no part of the aluminum body will contact the router bit.

Jointing is the process of cutting flat, square, straight edges on a board. It's typically done on a free-standing power jointer but can be done on a router table for boards that are no thicker than the cutting height of the router bit used. The ProMax Fence has integral slots to accept the included aluminum Jointer Bars (11). When installed in pairs in the slots, these bars "shim out" the outfeed Fence Face by 1/32".

1. Unplug the router and install a straight or spiral up-cut router bit, setting the cutting height according to the capacity of the bit and the thickness of your stock.
2. Use the blue-handled Hex Key (12) to slightly loosen the flat-head hex screws securing the **outfeed** MDF Adjustable Fence Face (2) to the Fence Body (1). (Don't loosen them too far, however, or they could disengage from the weld nuts that snug them to the Fence Body.)
3. Slide both Jointer Bars (11) out from the slots behind the outfeed MDF Adjustable Fence Face (2) and turn them 90°. Then slide them back into the slots. This will push the outfeed MDF Adjustable Fence Face out by 1/32". **Fig. 3.**
4. Use the blue-handled Hex Key (12) to tighten the flat-head hex screws securing the **outfeed** MDF Adjustable Fence Face (2) to the Fence Body (1).
5. Set the fence position so that the plane of the outfeed MDF Adjustable Fence Face (2) is just slightly behind the front edge of the bit.
6. Using a straightedge held flush against the outfeed MDF Adjustable Fence Face (2) as a guide, loosen the Fence-Locking Knob on the top of the fence and turn the Micro-Adjust Knob on the back of the fence to align the outfeed side precisely with the cutting edge of the bit.
7. Remove the straightedge. If necessary, adjust the MDF Adjustable Fence Faces (2) to make the gap between the faces and the bit as small as possible without making contact with the bit. Adjust the Bit Safety Guard (3).
8. Plug in the router and make a test cut in scrap stock. If adjustments are needed, unplug the router and use the ProMax Fence's micro-adjust function to fine-tune the fence position.

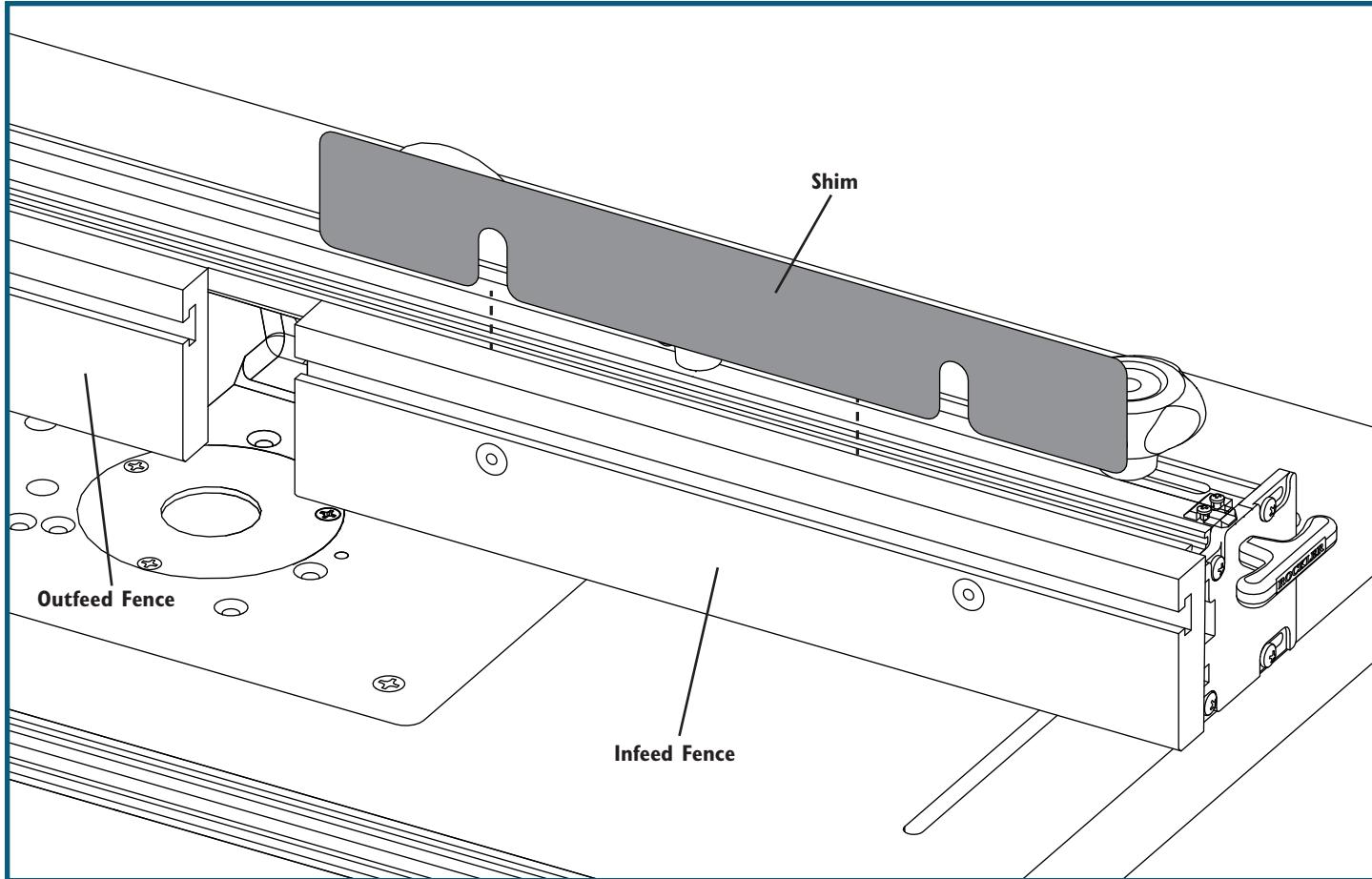


Fig. 4 - Bit guard removed for clarity

Fine-Tuning the Infeed Fence

WARNING

- > Turn off and unplug your router and then fully retract or remove the bit before performing the following steps.

It is possible that the infeed and outfeed MDF Adjustable Fence Faces (2) might not align perfectly. To determine whether this is an issue and fix it if it is:

1. Tighten the Five-Star Knobs (9) to lock the Fence Body (1) to the router table, and use the Hex Key (12) to snug the MDF Adjustable Fence Faces (2) up to the fence. Also tighten the Fence Locking Knob (13).
2. Place a straightedge or a straight piece of wood at least 12" long against the fence. Push the board from the infeed side to the outfeed and notice whether the front end catches on the outfeed side.
3. If the board catches on the outfeed side, loosen the MDF Adjustable Fence Face (2) on the infeed (right) side.
4. Gather the included Shims (15-17). Fit the Blue .008 Shim (15) between the aluminum Fence Body (1) and the MDF Adjustable Fence Face (2) on the infeed side, taking care that the slots align with the bolts used to secure the Fence Face to the fence. **Fig. 4.** Make sure the Shim slides all the way down, and retighten the MDF Fence Face.

PARTS LIST

	Quantity
15 Blue .008 Shim	1
16 Gray .010 Shim	2
17 White .020 Shim	1

5. Double-check that the Fence Locking Knob (13) remains tight. Then place your straight board against the fence, and push it from the infeed side to the outfeed to check whether the front end still catches on the outfeed side.
6. If the board slides without catching, you are done. If the board still catches, loosen the MDF Adjustable Fence Face (2); install a Gray.010 Shim (16); tighten the Fence Face; and repeat the test with your board. If necessary, add the other Gray.010 Shim and the White .020 Shim (17), one at a time, until the board slides across the fence without catching.

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