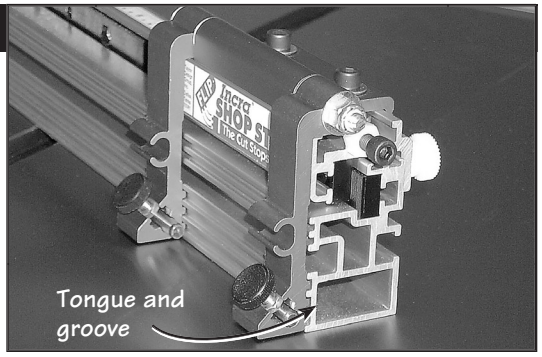
Flip Shop Stop Instructions

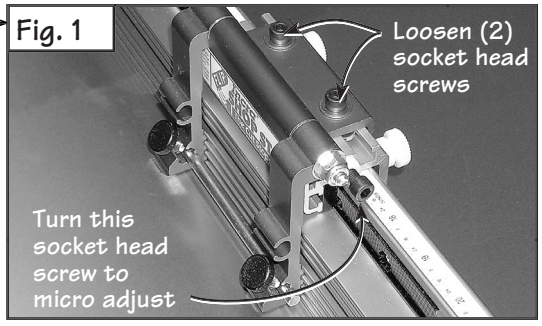


Introduction

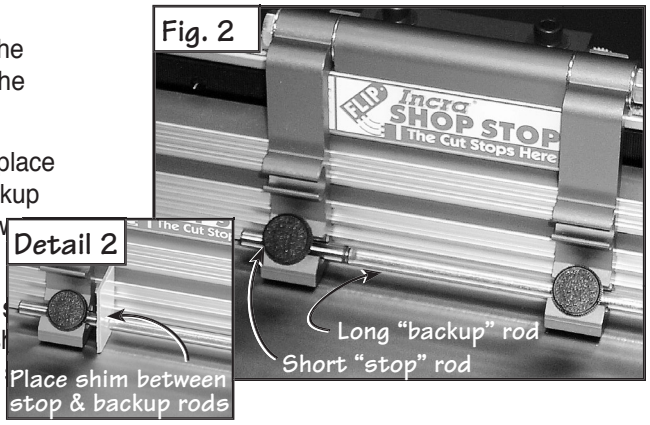
As you look at your new INCRA Flip Shop Stop and fence for the first time you will no doubt see a most interesting detail. The front face of the fence uses a tongue and groove arrangement to accept a mating feature on the flip arms. When the flip arm is down with the two opposing tongue and grooves engaged, it becomes impossible for the sharp corner of a mitered board end to wedge between the fence and flip arm. Combined with the already famous incremental positioning capabilities of the Incra saw-toothed racks, you'll soon be duplicating cut off lengths with machine shop precision.

Micro Adjusting

Micro adjusting your stop position can be accomplished in a variety of ways. Use the supplied hex tool to loosen the two socket head screws located on the top of the stop body and then turn the micro adjust socket head screw to fine tune the stop position. **Fig 1**. When unscrewing the micro adjust screw, apply pressure to the stop body to keep it against the screw end. After adjustment, always tighten the two socket head screws on top of the stop body.



When using the stop rods in the flip arms, another way to micro adjust is to simply shift the position of the rod. A dual rod setup can provide the most controlled means of adjusting. Place a short rod in one flip arm and a long rod in the other, then slide the rods to contact each other between the two flip arms before tightening the thumbscrews. With this setup in place, one rod will be in a "backup" position to the actual "stop" rod. **Fig. 2**.

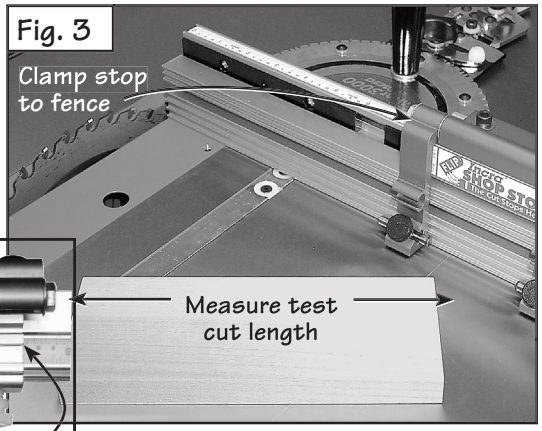


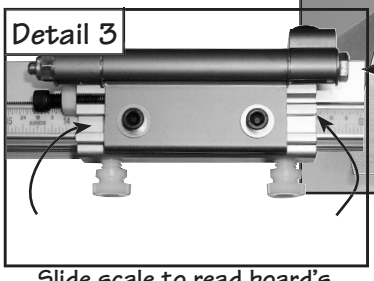
To micro adjust the stop rod forward, loosen the thumbscrew that secures it and place a shim or spacer, equal in thickness to the adjustment required, between the backup and the stop rod. Slide the stop rod against the shim and tighten the thumbscrew. **Detail 2**.

To micro adjust the stop rod backward, first loosen the backup rod and place the shim or spacer between the backup and stop rods. Slide the backup rod against the shim and tighten the thumbscrew. Remove the shim, loosen the stop rod thumbscrew, slide the stop rod to contact the backup rod and tighten in place.

Zeroing to the Blade

To zero the stop and scale to the blade, begin by locating the fence a safe distance from the blade and tightening the socket head screws that secure the fence. Clamp the stop to the fence about 10" away from the blade. Crosscut a piece of scrap stock with this setup. Measure the length of the cut piece. **Fig 3**. If the cut piece measurement is some multiple of 1/32" (i.e.: 10 1/32, 10 1/16, 10 3/32, 10 1/8 etc.), slide the scale on the fence to read the length of the piece directly under one end of the stop. **Detail 3**.





If the cut piece measurement is not a multiple of 1/32 (example: 10 1/64), micro adjust the stop forward 1/64", and recut the board. When the test cut measurement equals some multiple of 1/32", slide the scale on the fence to read the length of the piece directly under one end of the stop. Note: When zeroing the scale for mitering setups, the test cuts must be made with the fence locked to the selected angle.

About your Fence Scales

All INCRA products use overlapping 16" long Lexan scales. The overlap allows fine-tuning the scale from one end to the other to agree with the high degree of accuracy provided by the Incra saw toothed positioning racks. These scales are printed initially in 16" lengths (0-16", 16-32", 32-48" etc.). As they are slid into the scale slot on the fence, the ends are overlapped and aligned using the optical window located at the end of the second scale. **Fig 4**. The friction fit will keep the scales in place. If you wish, you can use a small piece of double faced tape at the overlap to ensure that the scales move together when changing your zeroed setups for mitering.