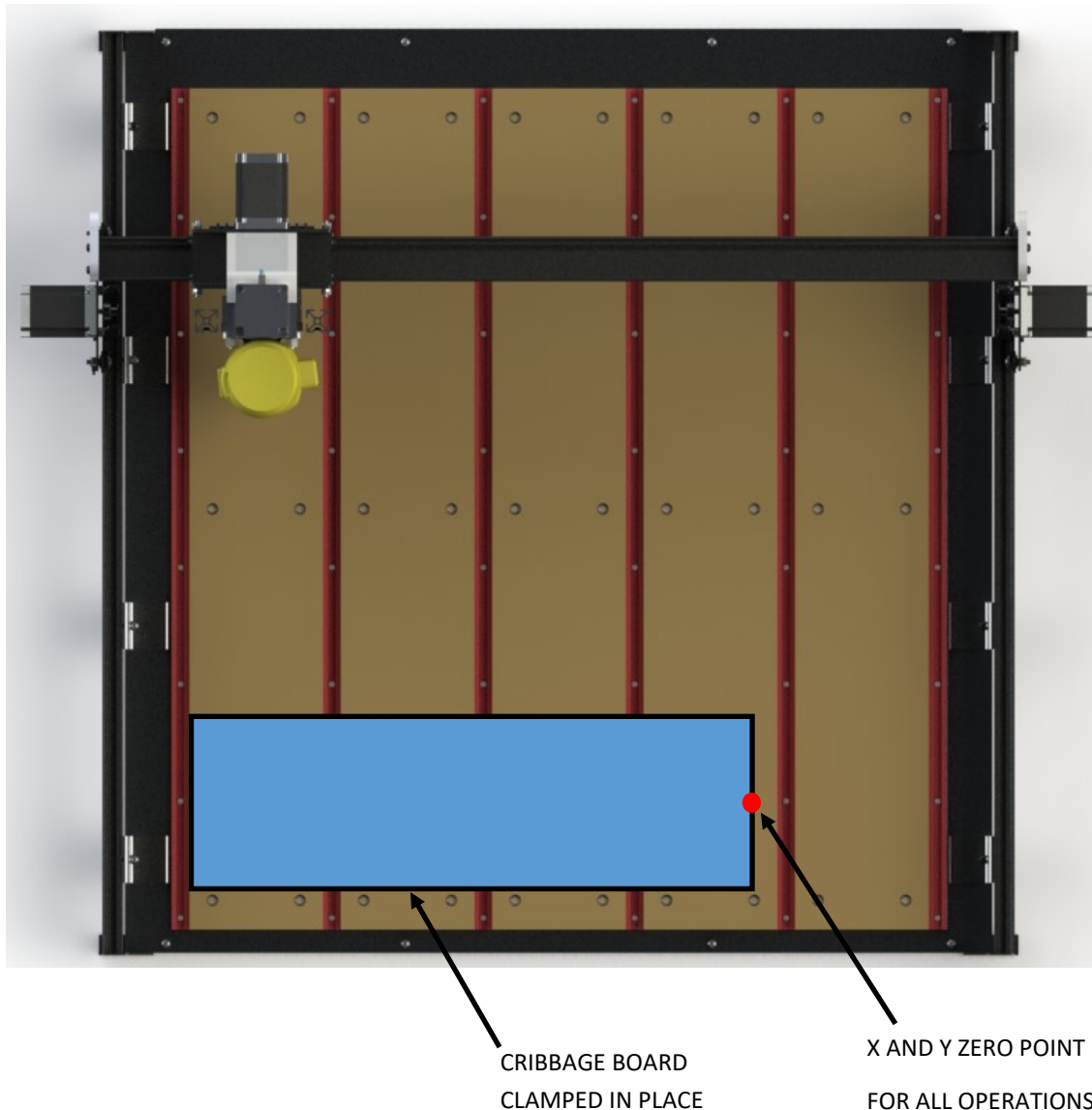


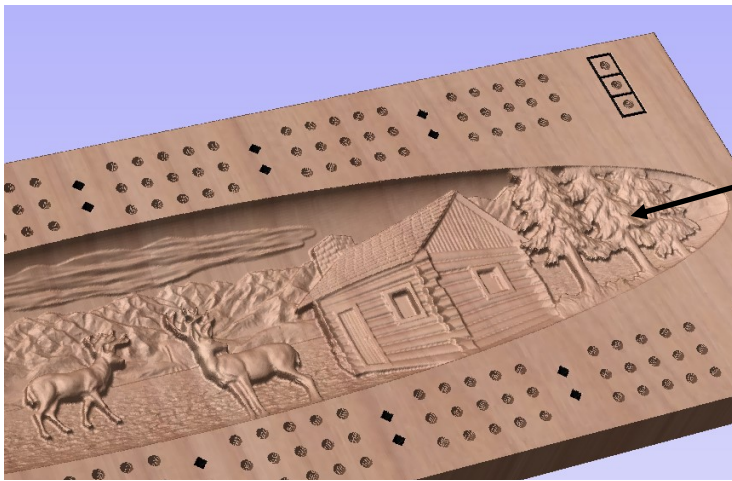
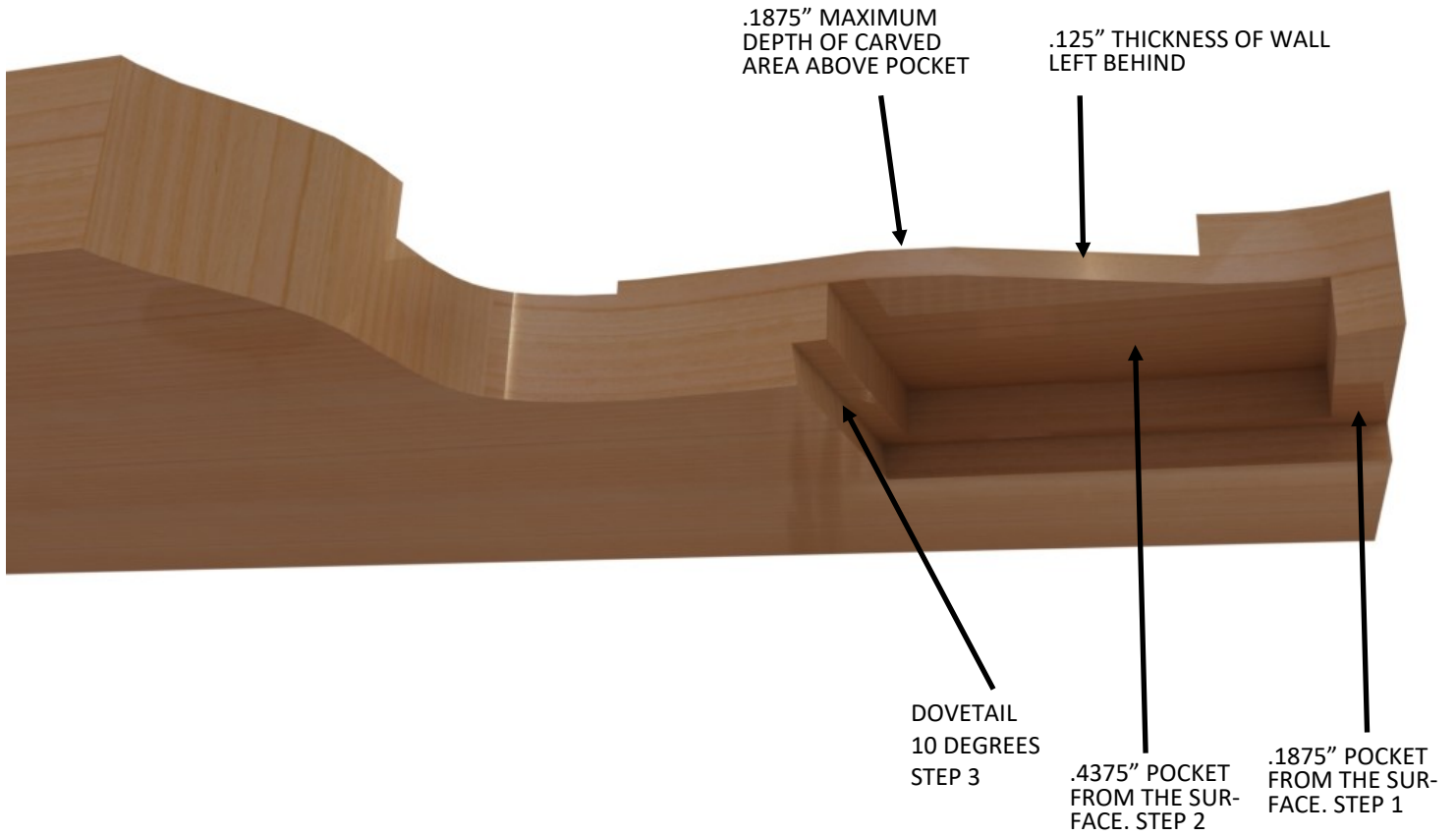
THE SET UP



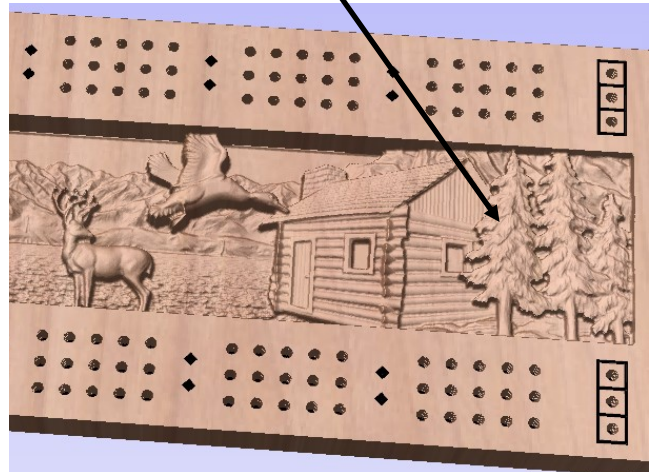
This pocket requires an are on the end of the cribbage board, 2.25" tall and 2.50" wide, to be carved no deeper than .1875" deep on a .75" board. The pocket will be .4375" deep leaving a wall thickness only .125" thick. All operations use the same X and Y zero point so you can just hit the "USE LAST X AND Y" button every time or in the case of the second operation which uses the same bit as the first, hit "MANUAL" and "USE LAST HOME POSITION". It first uses a 1/4" flat end mill (I use a down spiral) to create the pockets. You could combine the first 2 work pages into one carve, But I chose not to. Next, you use a Dovetail bit with a 10 degree slope to under cut the lip for the sliding door. The final page is for an 1/8" bit to carve the pull pocket on the sliding door. I use a table saw tilted at 10 degrees to cut the sides and one end. The last end which is the outside edge gets cut flat. I use a drum sander to quickly round the 2 sloped corners to match the radius left by the dovetail bit.

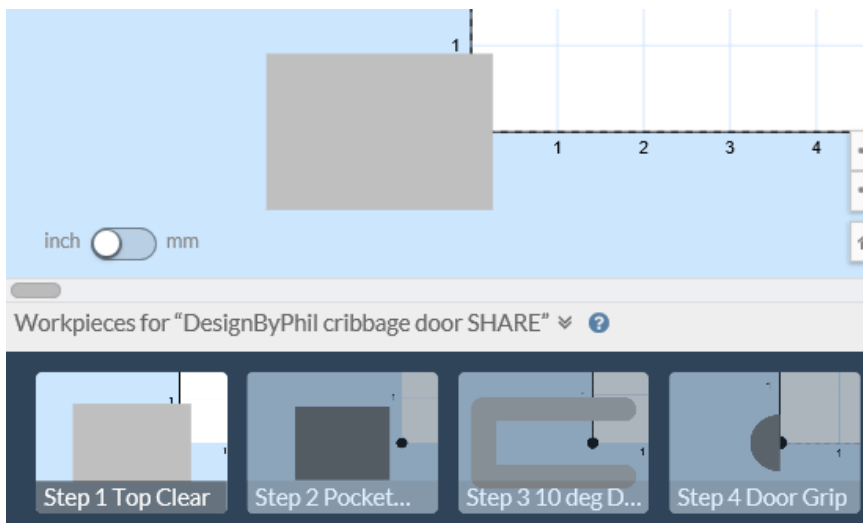
The following pages will walk you through the process step by step.

POCKET ANATOMY



You can plan your design to have shallower elements on one side to leave the .1875" MAXIMUM DEPTH OF CARVED AREA ABOVE POCKET



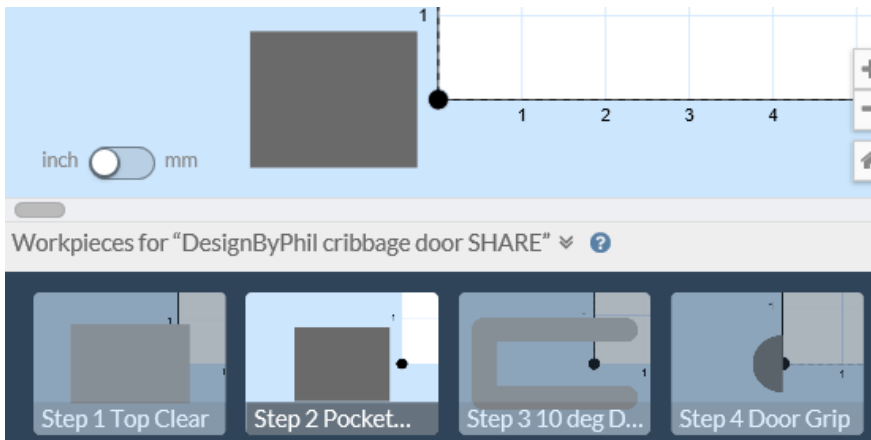


STEP 1

BIT: 1/4" Flat end mill (I use a down spiral)

Zero the bit where shown one page 1, Right edge of the board centered vertically. The shape goes out to the right of the edge to ensure no radius is left on that edge.

You can adjust the depth of cut and the feed rate for this step.

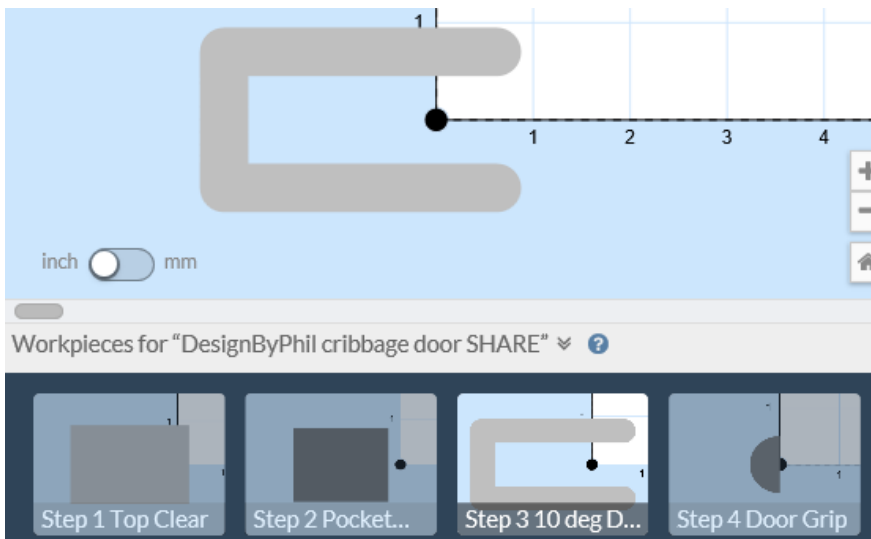


STEP 2

BIT: 1/4" Flat end mill (same bit as step 1)

You can hit "MANUAL" on the walkthrough and "USE LAST HOME POSITION". This cuts the rest of the pocket leaving a small lip to help with the sliding door.

You can adjust the depth of cut and the feed rate for this step.



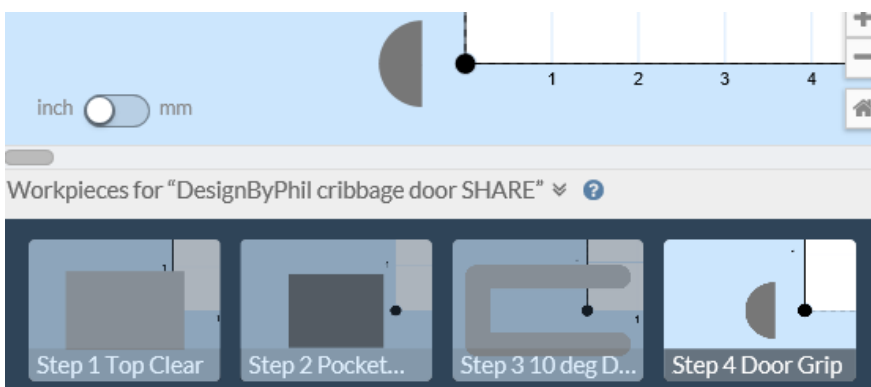
STEP 3

BIT: 1/2" diameter Dovetail with a 10 degree slope

I zero by jogging down and left 1 inch each. I use the probe. Remember to use last X and Y or jog back. This tool path will start on one end of the open path, plunge all the way down to .1875", and under cut the lip.

DO NOT adjust the depth of cut for this step!!!

You can, however, change the feed rate for this step.



STEP 4

BIT: 1/8" Flat end mill (I use a down spiral)

First cut the door using 2" wide 3/16" thick Mulling strips from Menards or what ever you have on hand. Use a table saw tilted to 10 degrees on 3 sides. Slide the door in place and use a single clamp or other to hold in place. Zero on top of door in place. I use the probe. Remember to use last X and Y .

You can adjust the depth of cut and the feed rate for this step