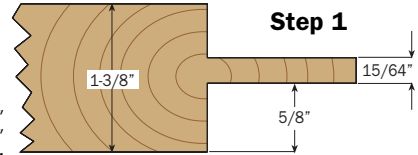


Your CMT set makes it easy!

In our step by step example for window sash construction, we used the following:

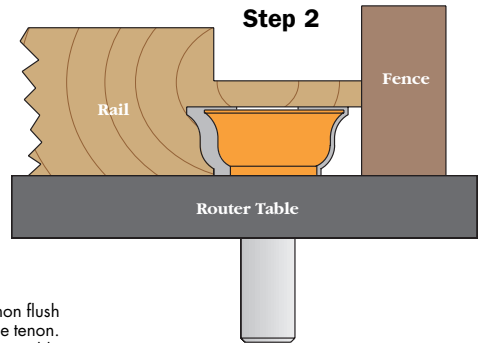
- CMT Window Sash Set (item No. 855.801.11)
- stile cut 1-3/8" thick
- rail cut 1-3/8" thick
- scrap stock

The CMT Window Sash Set was designed ideally for the construction of windows in 1-3/8" stock, however variations as narrow as 1-7/64" can be used. Stock thicker than 1-3/8" exceeds the milling range of the cutter. Remember to adjust your measurements and cutting depths according to the wood thickness you use. We suggest making a trial joint in scrap stock according to the following steps before milling all of the cope and stick profiles.



STEP 1 - Measurements and Making the tenons

The ideal thickness of the stiles when using the CMT sash set is 1-3/8". The desired width of the stiles will determine the length to make your tenons while the length of the stile will represent the desired full height of the sash. When cutting the rails to length, make sure to add the length of the two tenons to the overall length of the rail. The length of the tenons should be at least half the width of the stile. Mill 5/8" measuring from the front face of the stock using a table saw, radial saw or router as shown in illustration 1. This measure remains invariable since it is calculated to the height of the CMT sash routers. The width of the tenon is 15/64". Rotate the stock and mill the other side. For our example, the second milling will be 33/64" but this measure will vary if you are using thinner stock.



STEP 2 - Making the cope profile on rails, sash bar and muntins

To make the cope profile, place the rail face front down on the router table with the tenon flush to the bit as shown in illustration 2. Adjust the fence so the bit mills 1/4" deeper than the tenon. To mill the sash bar and the muntins (cross bars), position front face down on the router table and mill without changing the height of the bit.

STEP 3 - Making the stick profile on rails, stile, sash bar and muntins

To mill the stick profile along the inside edges of all sash parts, place the already milled cope profile front face down on the router table and adjust the sash bit so that the lower edge of the top cutter will exactly touch the upper edge of the tenon as shown in illustration 3. With the rail still face front down on the table, turn it so the inside edge of the rail is to the bit and mill the stick profile. Mill the inside edge of the stiles and mill both edges of the front face of the sash bar and muntins. To cut the slots for the tenons, measure 5/8" from the front face of the stiles and rout with a table saw.

