



# MJ Splitter™

Kit (Model # SP-0125)

## Low Profile 1/8" Kerf Splitter with "Feather Board" Effect Installation Manual (V1.0) 1203

For Installation on Zero Clearance Insert with no existing splitter opening ONLY!  
For making 90° cuts ONLY – MJ Splitter will NOT accommodate cuts with a tilted arbor!

This model is for use with 1/8" kerf saw blade ONLY!

Made in USA - Patent Pending

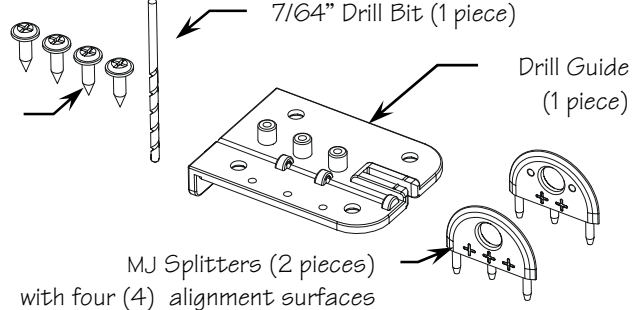
**Micro Jig, Inc.**  
PO Box 195607  
Winter Springs, FL 32719  
USA

Tel: 1-407-696-6695  
Web site: [www.microjig.com](http://www.microjig.com)  
Email: [sales@microjig.com](mailto:sales@microjig.com)

Copyright © 2003 Micro Jig, Inc.

### Package Contents

#8 x 1/2"  
Wood Screws  
(4 pieces)

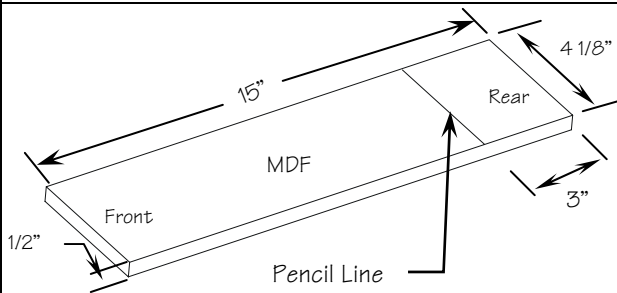


MJ Splitters (2 pieces)  
with four (4) alignment surfaces

### Preparation - For best results, we suggest that you read this Installation Manual thoroughly before you start.

- Rip fence must be parallel to the saw blade if the MJ Splitter is used with the GRR-Ripper® System.
- Zero Clearance Insert (ZCI) must be leveled with the table saw top.
- To achieve a "feather board" effect, the ZCI must fit snugly in the opening.
- A kerf in the ZCI must be created at 90° with the saw blade (without stiffener) raised to its **highest** setting.

**Note:** ZCI used should be made of sturdy material, as any deflection on the ZCI when downward pressure is applied may cause the work piece to be pulled away from the fence, resulting in a cut that is not parallel to the fence.

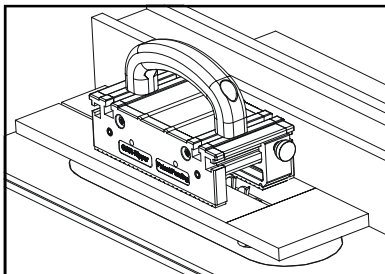


### Installation Procedure

These procedures are for use with a standard 10" diameter 1/8" kerf saw blade. Please follow the exact order of steps and sequences.

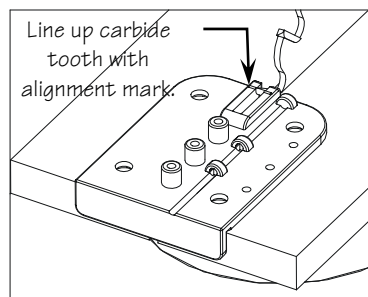
#### Step 1 - Prepare a Setup Board

Prepare a Setup Board from a 1/2" thick man-made sheet stock (preferably 1/2" MDF) - 15" L x 4-1/8" W. The front edge must be 90° to the long edges. Draw a pencil line across the width that is 3" from the rear end.



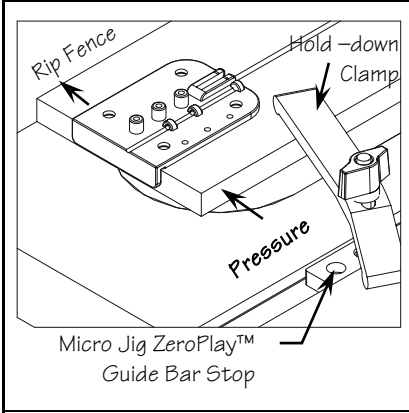
#### Step 2 - Create a Saw Kerf on the Setup Board

- 1) Set the saw blade at 1/4" above the top surface of the setup board. Be sure the table saw top is clean and free from sawdust and other debris.
- 2) Secure the rip fence at 2" to the right of and parallel to the saw blade.  
**IMPORTANT:** Keep the rip fence locked in position until the installation is complete. The 1/8" saw kerf that you are going to create in the next step will be the alignment path for the Drill Guide. It is extremely important that the saw kerf is parallel to the right edge of the Setup Board. Using the GRR-Ripper® for this ripping procedure is the best way to ensure a parallel cut.
- 3) Feed the Setup Board through the saw blade and stop at the pencil line.
- 4) Turn off the saw motor while maintaining firm pressure on the GRR-Ripper®, and wait until the saw blade comes to a complete stop.



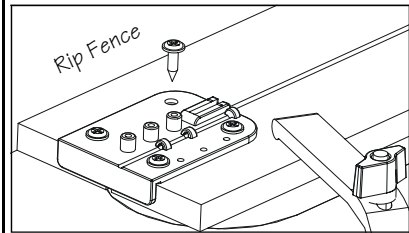
#### Step 3 - Establish the Guide Hole Distance from the Saw Blade

- 1) Disconnect the power to the table saw.
- 2) Pull back the Setup Board so the saw blade (without stiffener) can be raised to its **maximum** height within the saw kerf.
- 3) Place the bottom center rib of the Drill Guide into the saw kerf and push the Drill Guide toward the saw blade until its cheek comes in contact with the front edge of the Setup Board, and one of the carbide teeth becomes engaged in the front opening of the Drill Guide. Align that tooth with the alignment mark on the Drill Guide's opening. Make sure that all guide holes are still within the ZCI. This will establish the distance of the guide holes behind the saw blade when it is fully raised.



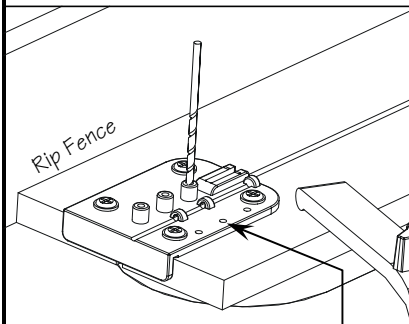
**Step 4 - Securing the Setup Board**

1) Lower the saw blade completely without altering the position of the Setup Board and the Drill Guide.  
 2) Clamp the Setup Board in position while applying firm finger or feather board pressure on the Setup Board against the fence so that the Drill Guide is tight in the saw kerf. This ensures that the right edge of the bottom rib on the Drill Guide is in full contact with the right edge of the saw kerf. This will also align the centers of the guide holes at the pre-determined distance from and parallel to the right edge of the saw kerf, regardless of the actual width of the saw kerf. (Vibration will inevitably cause the saw kerf to be slightly wider than the width of your saw blade.)  
**Note:** The illustration shows a fast and simple way of clamping the Setup Board by using a Hold-Down Clamp and the Stop from Micro Jig's ZeroPlay™ Guide Bar System. You may also clamp a board bridged over the Setup Board from the edge of your table saw top.



**Step 5 - Securing the Drill Guide**

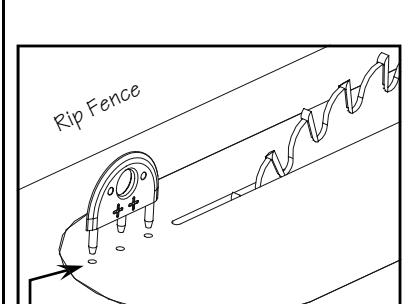
1) Secure the Drill Guide onto the Setup Board using (4) #8 x 1/2" wood screws (provided). Pilot holes are not required if you use a power hand drill (the bottom of the screw holes are countersunk to accommodate any swarf from the drilling operation). DO NOT drive the screws all the way with the power drill to prevent stripping the threads - lightly tighten the screws with a Robertson or Phillips screwdriver.  
 2) If you prefer pilot holes, use the 7/64" drill bit (provided) to drill the pilot holes NOT MORE than 1/8" deep, and lightly tighten the screws by hand.



**Step 6 - Drilling the Splitter Location Holes**

1) Make sure the Drill Guide is secured on the Setup Board and that there is no debris or gap between them. The guide holes must be perpendicular to the Setup Board.  
 2) Chuck the 7/64" drill bit into a power hand drill and carefully line up the drill with one of the guide holes. Hold the hand drill as perpendicular and steady as possible and drill through the guide hole to make that MJ Splitter location hole on the ZCI.  
**IMPORTANT:** Drill each hole in one single quick and continuous motion. DO NOT stop and go or re-drill the same hole, as this will enlarge the MJ Splitter location hole and the guide hole, thus resulting in a loosely fitting MJ Splitter.  
 3) Drill the other two holes in the same manner.  
**Note:** The pins on the MJ Splitters are 3/8" in length. Preferably, drill through holes on the ZCI. If your ZCI uses replaceable blanks thinner than 3/8" and has a metal frame under the required hole locations, the pins of the MJ Splitters need to be shortened accordingly. If your ZCI is made out of hard plastic or other material that does not "give," e.g., phenolic or solid surface material, you may need to ream the location holes lightly with the same 7/64" bit.

Do not drill the storage holes onto the MDF in this step, drill them in Step 9.



**Step 7**  
 Push the MJ Splitter completely down - by hand only - so that it fits tightly in the holes.

Surface A0   Surface A3

Splitter A

Surface B1   Surface B2

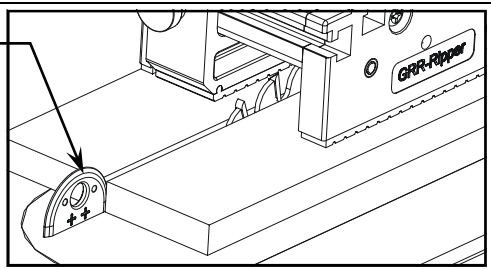
Splitter B

Use a fine point marker to highlight all the "+" signs for easy identification.

**Step 7A -** Each surface of the two MJ Splitters, A & B, extends a different distance from the center of the pins. In use, each additional "+" sign indicates that surface is 0.003" ± closer to the fence than the surface that has one less "+" sign. This option also allows you to select a surface that protrudes slightly into the left edge of the keeper piece by thousandths of an inch, which generates slight tension - like a mini feather board - behind the saw blade.

Test both surfaces of each MJ Splitter facing the rip fence and select the surface that best suits your preference. When cutting material other than wood, such as aluminum or plastic, use the surface that provides no tension against the material.

**Step 8**  
 MJ Splitter is ready for use with or without the GRR-Ripper®. To remove, insert a screwdriver through the hole and pull upward.



**Step 9**  
 Store both MJ Splitters and the drill bit in the Drill Guide (drill through the first two tabs). Shorten the MDF Setup Board for easy storage.

