

Using The Burgess Edge

Before You Begin: The Burgess Edge comes with two .016" (steel) shims already in each bit. This will work for most 3/4" plywood. You can add .010" (copper) shims to both bits in order to produce a thinner veneer edge. The thicker .048" shims are for melamine and MDF. The bits are designed to cut .662" without shims. When you add two .016" shims, you are cutting .694". Because plywood measures approximately .724", you want to leave about .013" of veneer on both sides of the plywood. (.750" is equal to 3/4")

To create the edge band:

1. Insert the "two bearing" (plywood) bit into the router. Check the tightness of the nut on the router bit.
2. Adjust the router base so that approximately 1/64" of the upper bearing is visible between the cutting profile of the bit and the router base. Test the cut on a scrap of 3/4" plywood.
3. Check your test cut for two things:
 - Make sure the width of the cut removes core material approximately half way through the outer veneer of both faces of the plywood. The width of the cut can be adjusted with shims between the cutters as necessary. If you shim to less than .032" between the cutters, make certain the carbide of the upper cutter slips between the wings of the lower cutter.
 - Center the cut on the plywood. This is achieved by incremental changes in the router base height moving 1/64" at a time.
4. When the bit is centered and cutting into the face veneer, route the plywood that you intend to edge.
5. Insert the "center bearing" (insert) bit in the router. If you adjusted the width of the "two bearing" bit in step 3, adjust the insert bit with the same thickness shim at this time. It may be necessary to add an extra .010" shim to ensure a snug fit of the insert in the plywood.
6. Prepare 3/4" boards of the same species as the plywood veneer.
NOTE: The thickness of the boards to be used for filler do not have to match exactly the plywood, as the router bit will properly size the insert. Adjust the router base so the "center bearing" bit is centered on the wood board.
7. When the adjustment is correct, route the edge of the board and with the table saw rip to approximately 1/2" so that you are left with a 1/2" x 3/4" ripping with the insert profile. Repeat this operation until you have as many inserts as you have plywood edges
NOTE: The inserts are intentionally ripped wider than necessary at this stage because it lends some structural integrity during the gluing process.

To apply your edges and finish up:

1. Apply glue according to manufacturer's instructions.
2. Insert the positive wood edge banding into the negative recess on the edge of the plywood.
3. Clamp your assembly and allow it to dry.
NOTE: It is not necessary to clean glue as long as you do not allow the glue to run over the face of the plywood veneer.
4. When the glue has set, remove the excess of the insert by ripping on the table saw to the extent of the plywood face veneer.
5. You can join the edge on the joiner, or sand to finish. Or, use your shaper to create a bull nose or other decorative edge.

It is as simple as that. You have recreated the patented, strong and beautiful Burgess Edge.