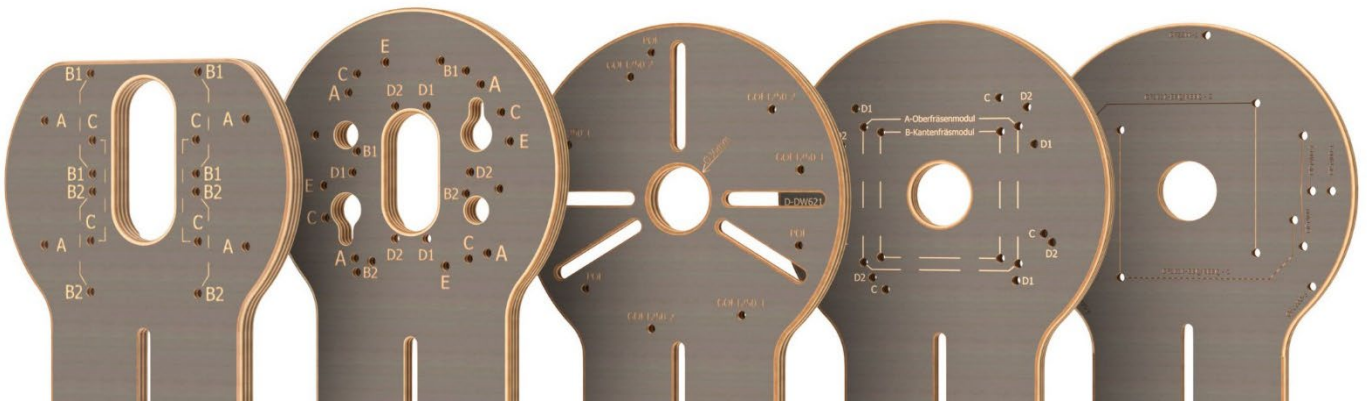




MaKoen milling compass

GOF-POF

DRT-RT

OF

GKF

DWT

Manufacturer information



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Member of the "Fairness in Trade" initiative

Participant in the "Der Grüne Punkt" recycling system

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Safety instructions

Our safety instructions can be found at

https://makoen.com/files/sicherheitshinweise/DE_Sicherheitshinweise_fraeszirkel.pdf

Notes

We are delighted that you have chosen our product. Despite taking every care, mistakes can still occur. If you notice anything, please contact us. We will find a quick and convenient solution.

Apart from a few standard parts, our products are manufactured in-house. Phenolic resin-coated veneer plywood panels serve as the base material for this. These are usually made of birch wood. Wood is a natural material and therefore has irregularities. We endeavour to reduce visual irregularities and, where necessary, to sort them out. We **do not** sort out small visual defects that do not impair functionality in any way **and** originate from the natural material.

This is for the benefit of the environment and in the interests of a good cost-benefit ratio.

Product data & scope of delivery

	Millimetres	Inches
EAN code:	GOF-POF: 4270003319607	4262426890597
	DRT-RT: 4270003319614	4262426890498
	OF: 4262426890009	4262426890511
	GKF: 4262426890023	4262426890504
	DWT: 4262426890443	4262426890528
Dimensions: Length:	650 mm	
	Width:	150 mm – 170 mm
	Height:	58 mm
Material:	12 mm birch plywood, coated on both sides with phenolic resin film	
Application:	Router jig for producing circular cut-outs and components	
Scale tolerance:	±1 mm	
Scope of delivery:	1x base body of the selected model 1x rotatable cylinder handle 1x aluminium cone slide 86 mm x 20 mm (slide)* 1x DIN7991 M4x10 countersunk head screw* 1x DIN7979 Ø6x16 cylindrical pin m6 fit & M4 internal thread* 1x DIN7991 M5x20 countersunk head screw 1x DIN9021 washer 5.2 with 3x nominal diameter 1x M5 star knob (max. tightening torque 2Nm) 4x DIN7991 M4x16 countersunk head screw 4x DIN7991 M4x20 countersunk head screw	

*The components marked with * are pre-assembled.*

First steps

Check the scope of delivery.

Please check that the parts listed in the scope of delivery are included.

Assembling the cylinder handle

Please mount the cylinder handle with an Allen key at the rear end of the milling compass.

Maximum tightening torque 1 Nm.

Measuring scales

Scale design

The scales are available in two versions.

Millimetres or inches.

Millimetre scale

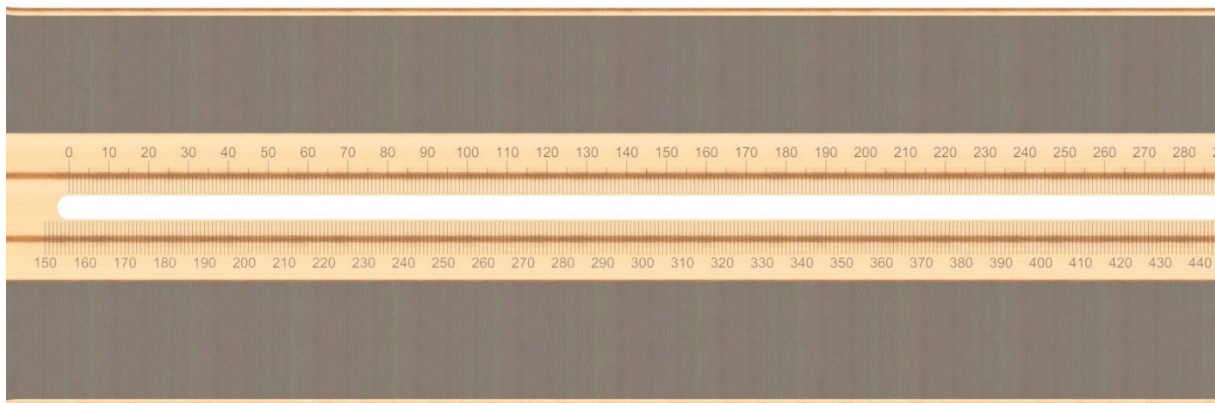


Figure1: Millimetre scale

Inch scale

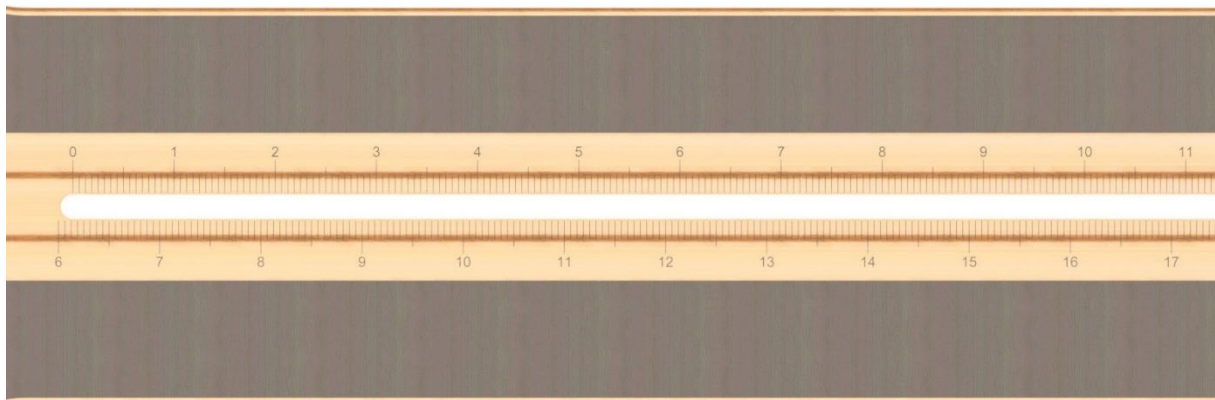


Figure2: Inch scale

Using the sliding carriage

The milling compass has two measuring scales. This is due to the design of the sliding carriage. The offset between the locking screw and the centring pin allows for a minimum radius. This means that there are two ways to insert the sliding carriage.



Figure3: Close-up of the sliding carriage

The two arrows on the sliding carriage point to the scale that is currently valid.

Using the slide for the upper scale

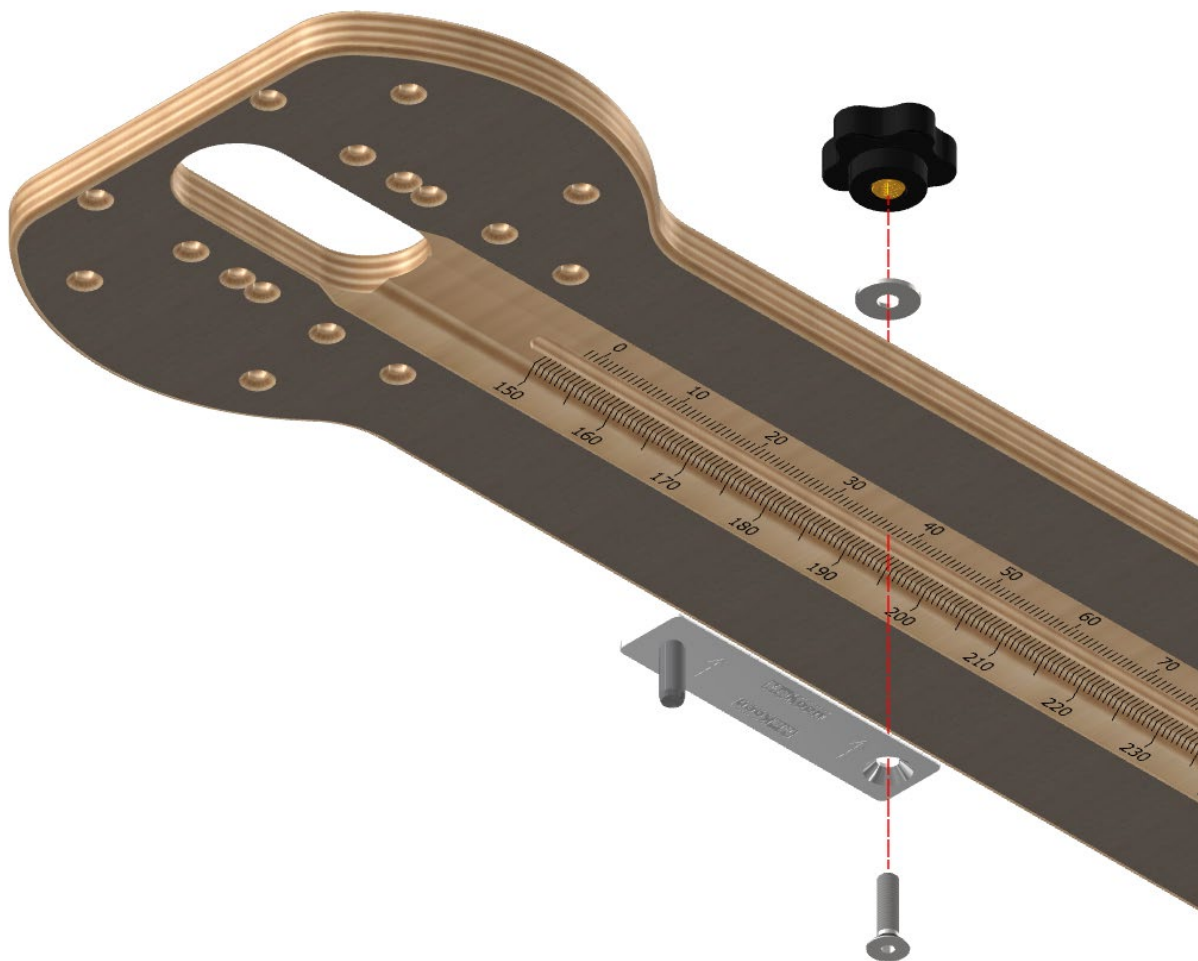


Figure4: Inserting the slide block – upper scale

If the slide is inserted in this orientation, the two arrows point to the upper scale. This then shows the valid measurement.

Inserting the slide block for the lower scale

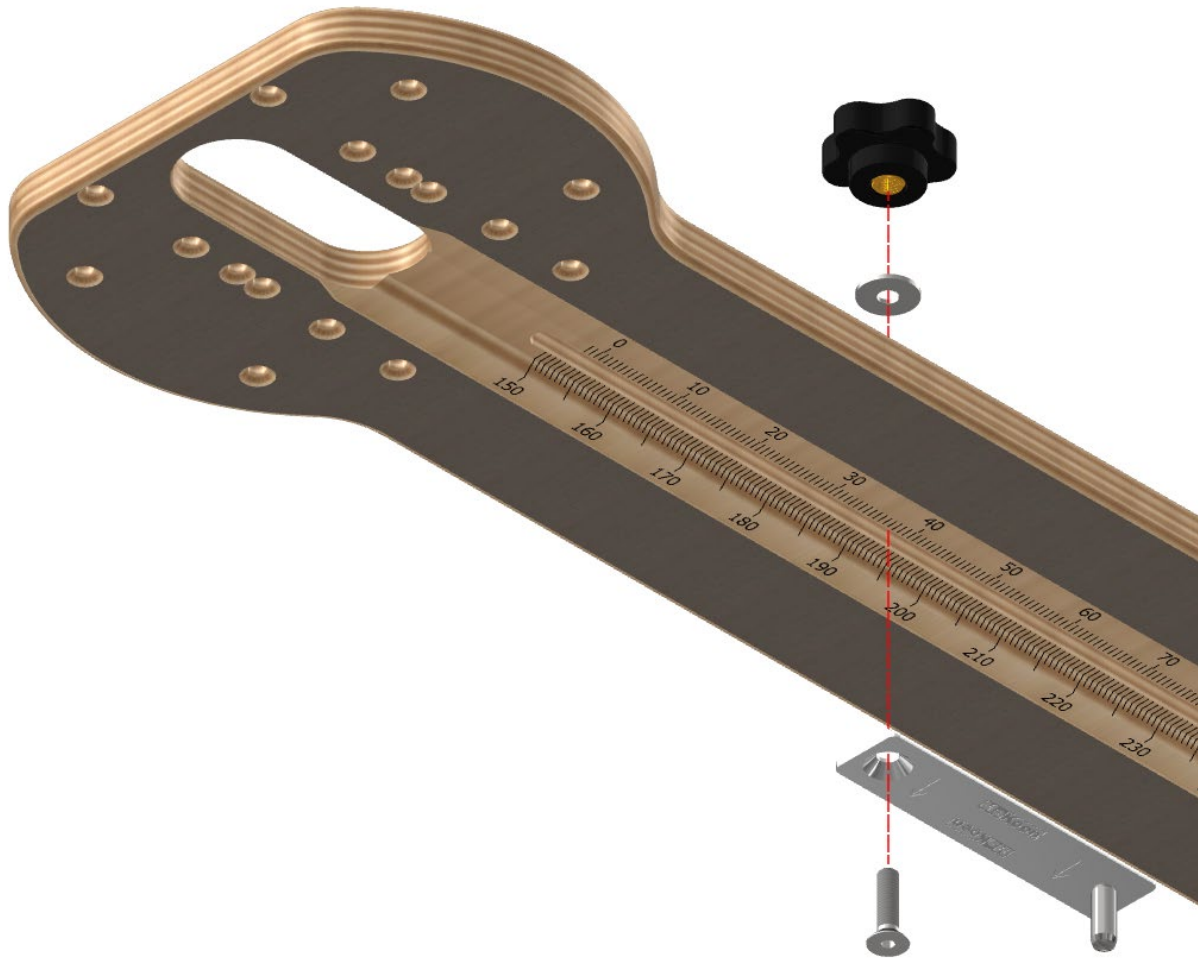


Figure5: Inserting the slide block – scale at the bottom

If the slide block is inserted in this orientation, the two arrows point to the lower scale. This then shows the valid measurement.

Assembly sequence of the milling compass.

- Inserting the slide from below into the milling circle
- The direction depends on which scale is used.
- Insert the M5 countersunk screw from below through the sliding carriage.
- Place the washer on the screw.
- Screw on the M5 star knob. The maximum tightening torque is 2Nm.

When do I use which alignment?

It's simple. If the cut-out or disc to be produced is larger than the dimension allowed by the upper scale, the slide carriage is inserted with the orientation facing backwards. This orientation allows the maximum area to be machined.

Reading dimensions

The sliding carriage displays the dimension directly.



Figure6: Edge for reading the set dimension

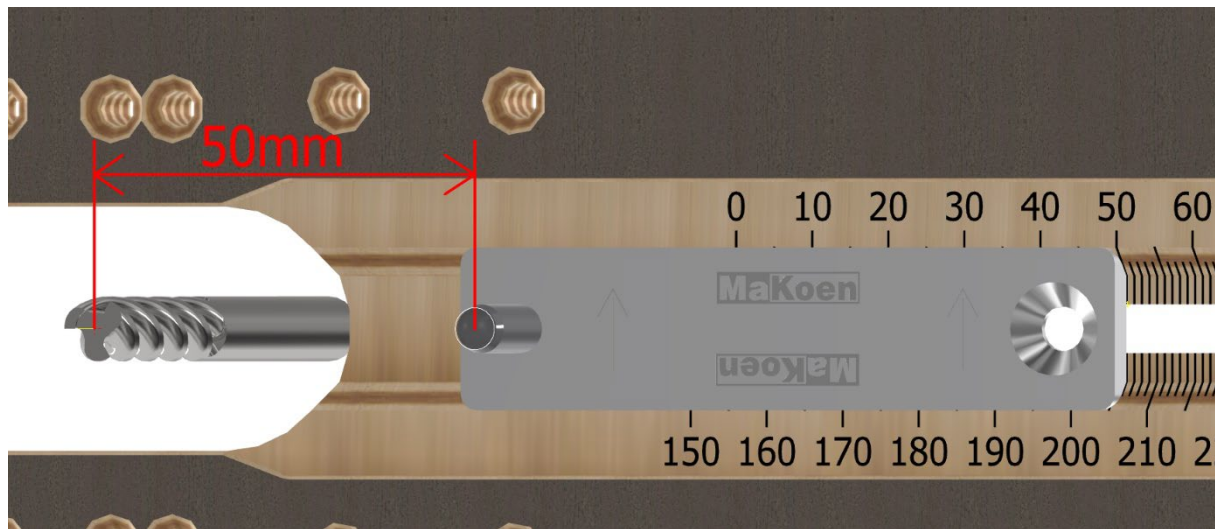


Figure7: Setting example, upper scale

The arrows point to the upper scale and the edge of the sliding carriage is at 50 mm. The distance between the centre of the cutter and the centre of the centring pin is 50 mm.

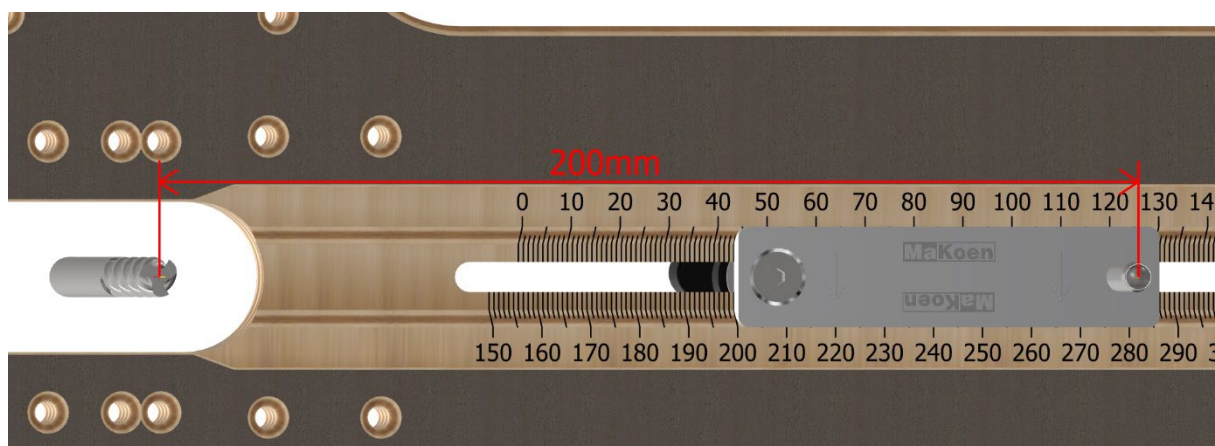


Figure8: Setting example, scale at the bottom

The arrows point to the lower scale and the edge of the slide rests at 200 mm. The distance between the centre of the cutter and the centre of the centring pin is 200 mm.

Setting the correct dimension

Figures 7 and 8 show that the set dimension indicates the distance between the centre of the cutter and the centre of the centring pin. This allows the scale to be used equally for cut-outs and components.

The scales are designed for convenience. Two scales cover both possible uses of the sliding carriage in the milling compass.

- Specify desired dimension
- IK (inner contour) = Circular cut-out → Subtract cutter radius
- AK (outer contour) = Circular component → Add cutter radius

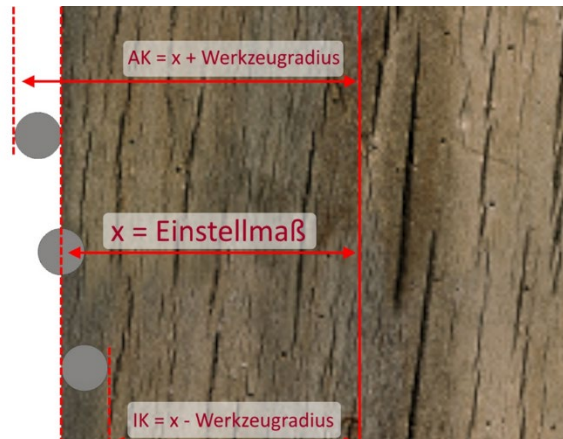
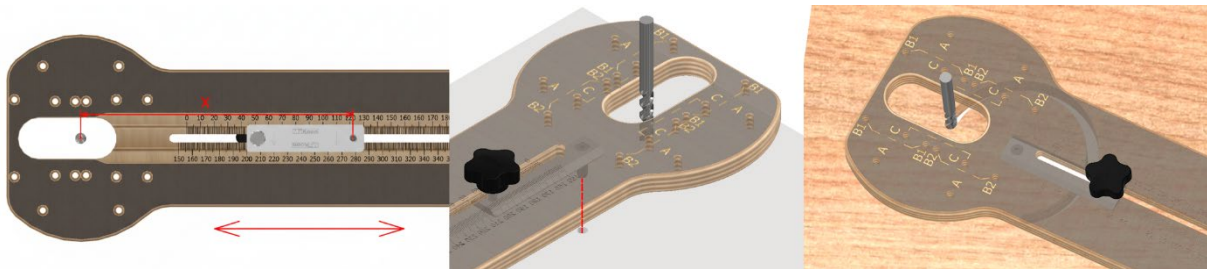


Figure9: Illustration of outer contour to inner contour

Milling process

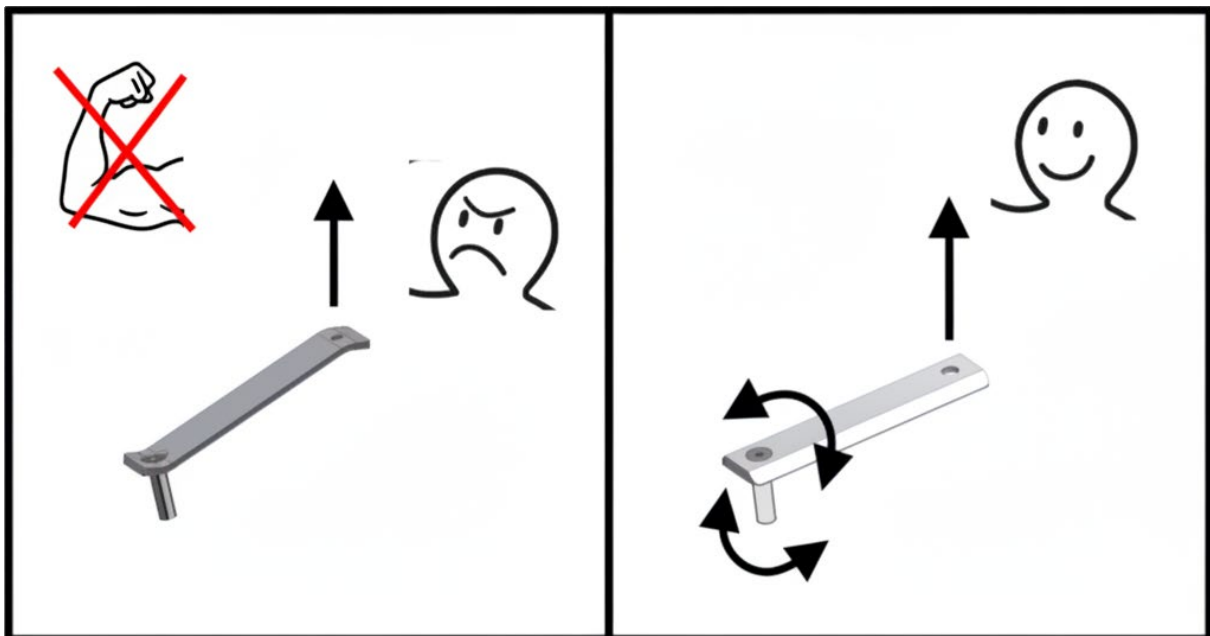
The process is explained using the milling compass. It is assumed that the hole for the centring pin has already been measured and drilled in the workpiece.

1. Mount the desired router on the milling compass.
(The alignment is described in detail in the next chapter, **Mounting the router**.)
2. Mount the sliding carriage in the desired alignment.
3. Determine the dimension to be set, taking into account **Setting the correct dimension**
4. Inserting the centring pin into the centre hole



5. Machining can now begin.

Note: The centring pin is a fitting pin with a tolerance of m6. The fitting pin is slightly larger than $\varnothing 6$ mm. This means that it sits tightly in the hole. When removing it, it may be helpful to turn the slide carriage. Simply pulling it out may damage the slide carriage.



10 : Carefully remove the slide carriage

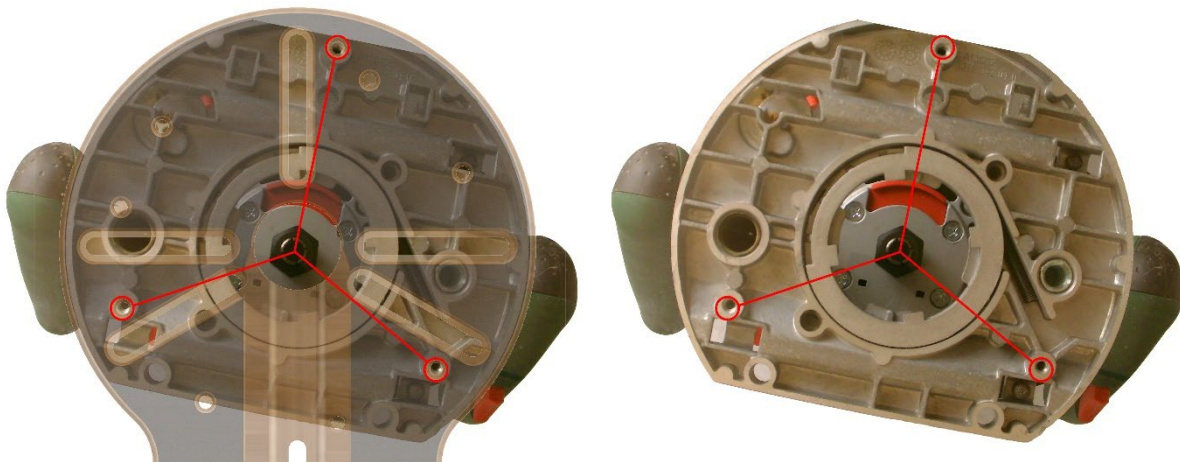
Assembly of the routers

The scope of delivery includes 4 countersunk head screws DIN7991 M4x16 and M4x20.

All routers have a plastic plate (base plate) on the underside. With the M4x20 screws, this can remain on the router, even if this results in a loss of depth adjustment. The base plates of the Festool models are very low-profile, so this is not noticeable here. The base plates of the edge routers from Makita, Bosch Professional and DeWalt are approx. 4-5 mm thicker. If the router is to be mounted with a base plate, the longer screws are required.

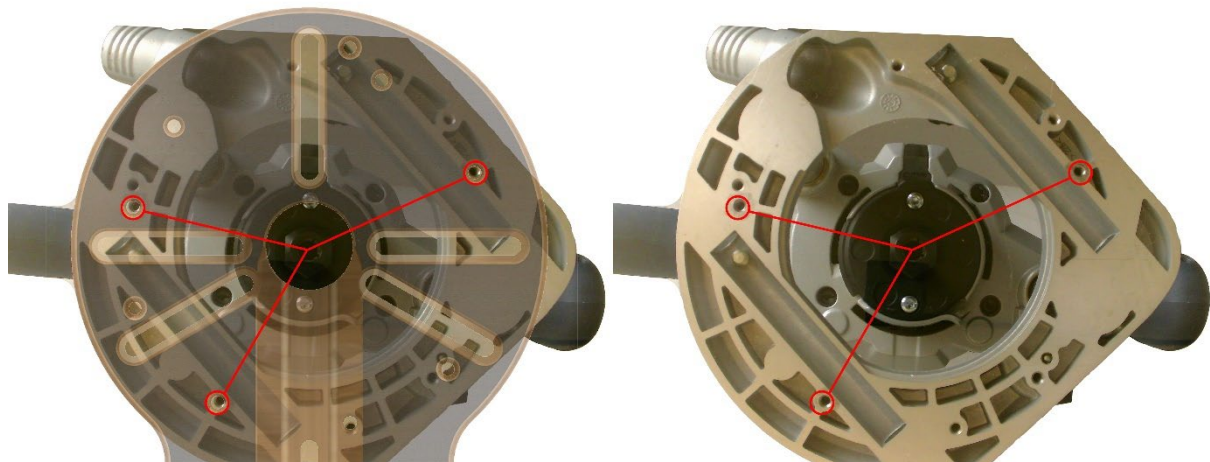
GOF-POF router compass

Mounting for Bosch POF models

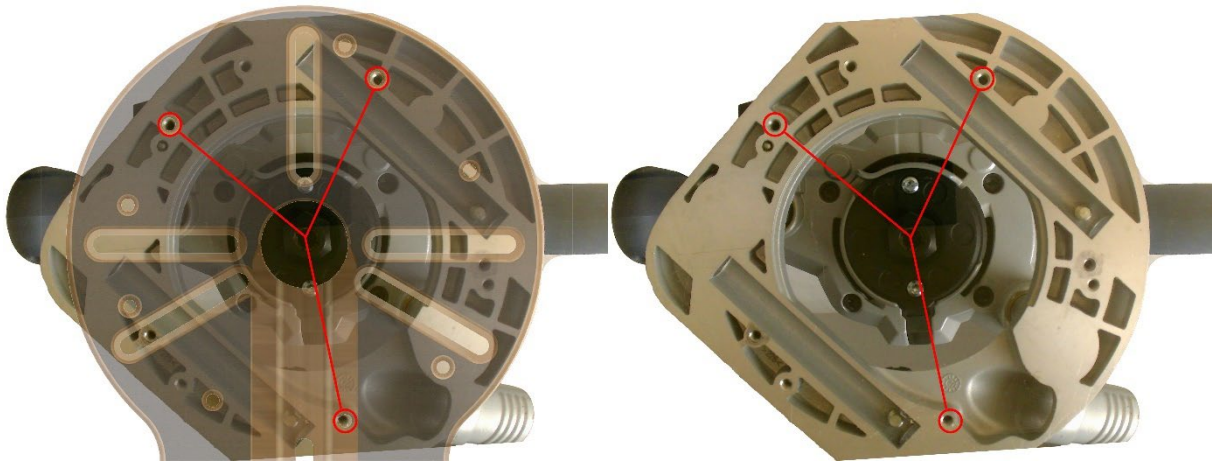


11 : Hole pattern for Bosch POF

Mounting for Bosch GOF1250



12 : Hole pattern for GOF1250-1 – right-handed



13 : Hole pattern for GOF1250-2 – left-handed

DRT-RT milling compass

Router module – holes A

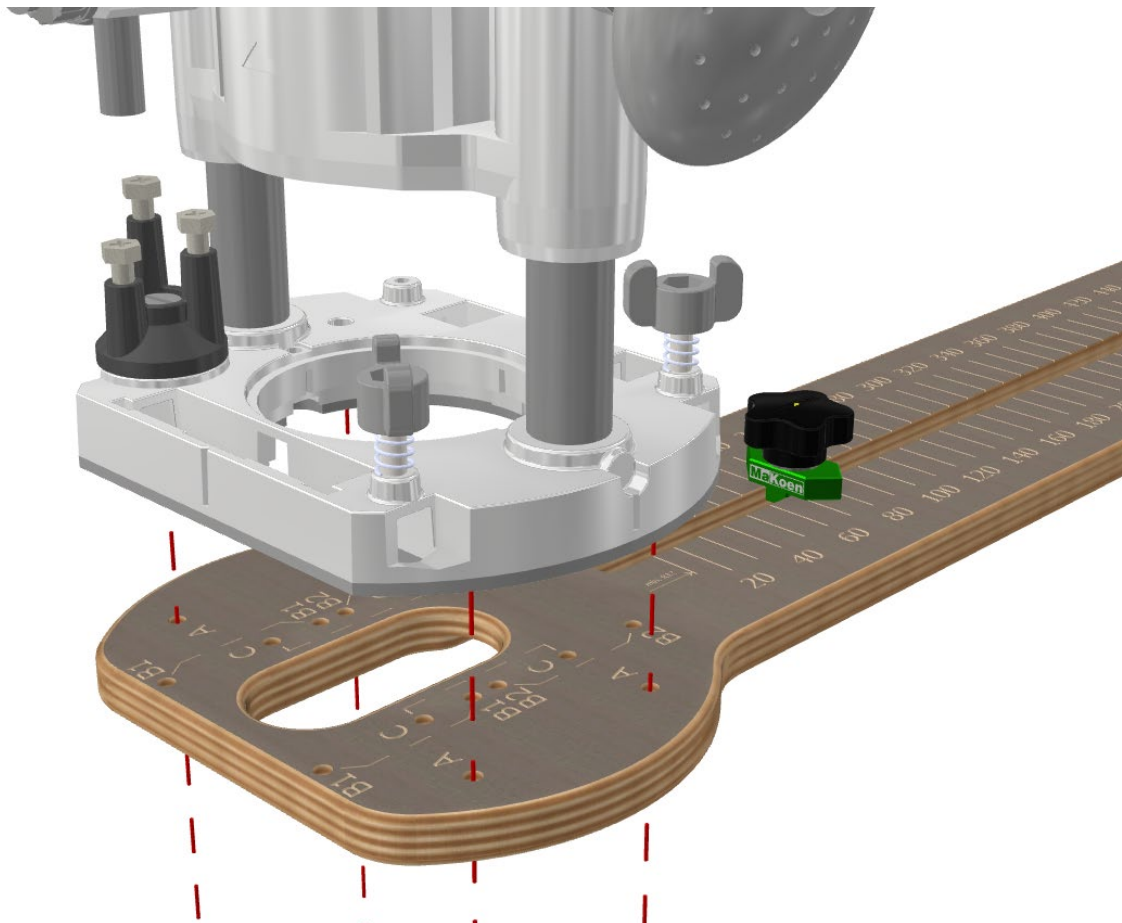


Figure14: Assembly of router module A

To mount the router module on the milling compass, use the holes marked with A.

Alignment: The distances are symmetrical. The module can be rotated by 180°.

Angle milling module – holes B1

The angle milling module can be mounted in 2 directions. This achieves the maximum possible adjustment range of $\pm 45^\circ$.

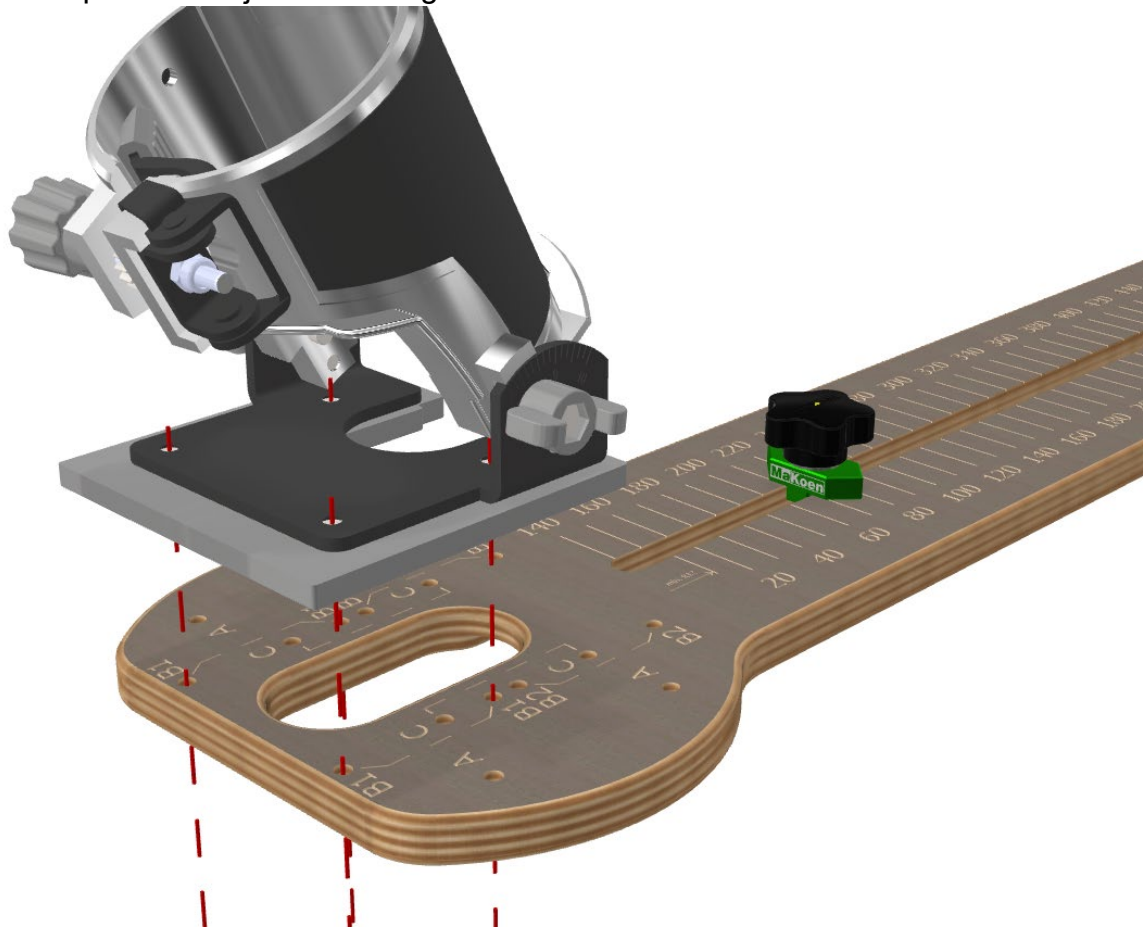


Figure15: Mounting the angle milling module B1

With the angle milling module and mounting via the holes B1, angles from 45 to 90° can be milled.

Alignment: Alignment is only possible in one position, as the holes are arranged asymmetrically.

Caution: When adjusting the angle, the position of the milling cutter relative to the scale changes.

Angle milling module – holes B2

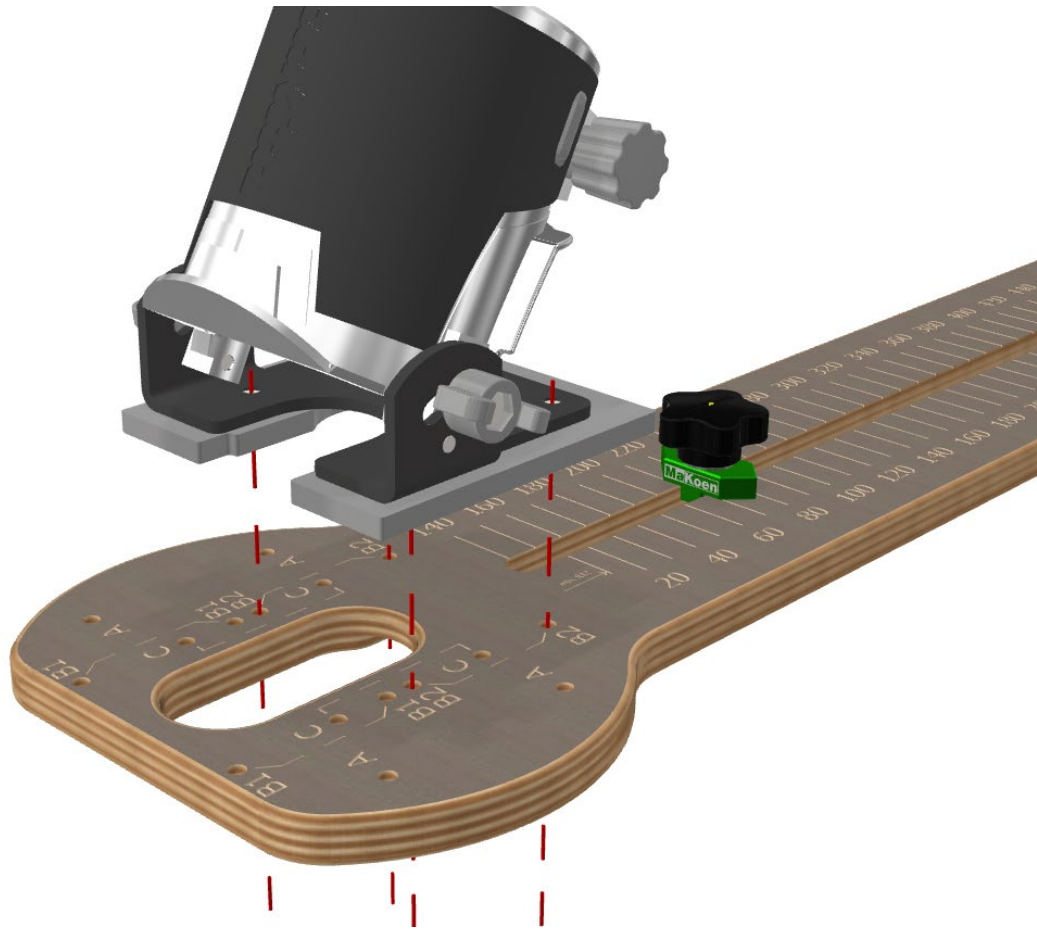


Figure16: Mounting the angle milling module B2

Angles of 90-135° can be milled using the angle milling module and mounting via the B2 holes.

Alignment: Alignment is only possible in one position, as the holes are arranged asymmetrically.

Caution: When adjusting the angle, the position of the cutter relative to the scale changes.

Edge milling module – holes C

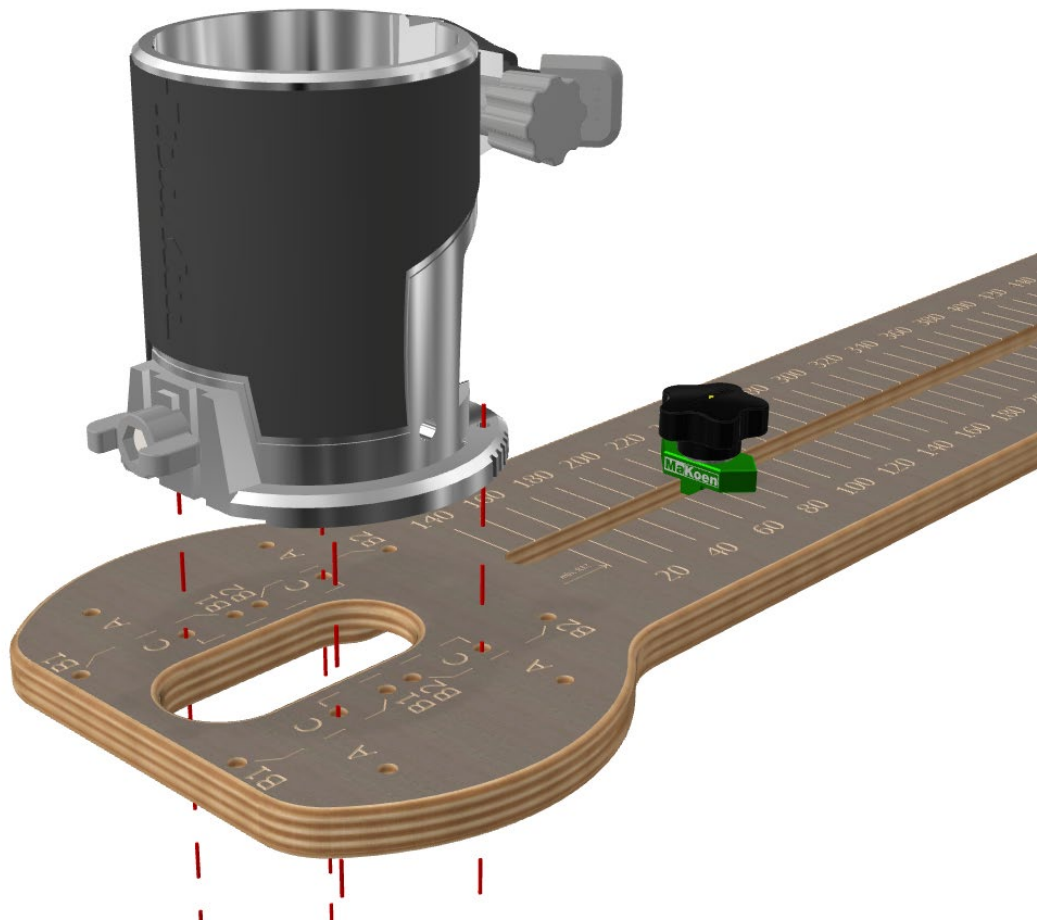


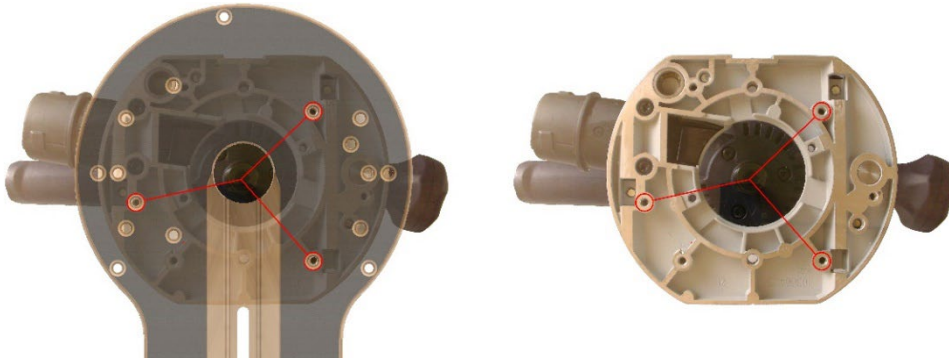
Figure17: Mounting the edge milling module C

The edge milling module is mounted using the holes C.

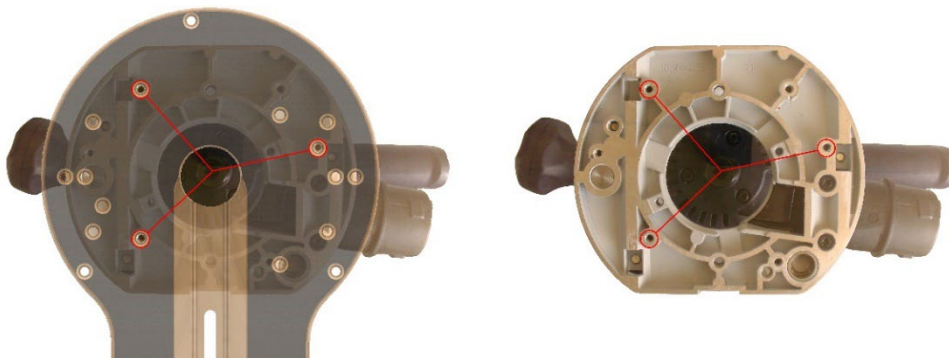
Alignment: The holes are asymmetrical. The edge milling module must face the scale with the clamping mechanism, as shown in the illustration.

Milling compass OF

Assembly for OF1010-EBQ & OF1010-REBQ

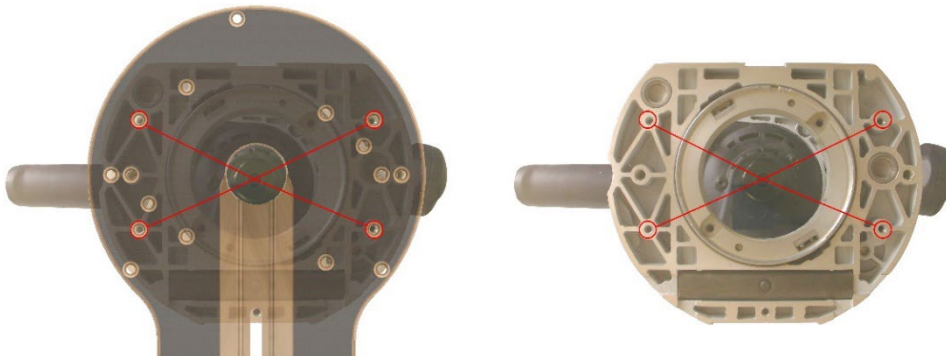


18 : Hole pattern for OF1010 - right-handed

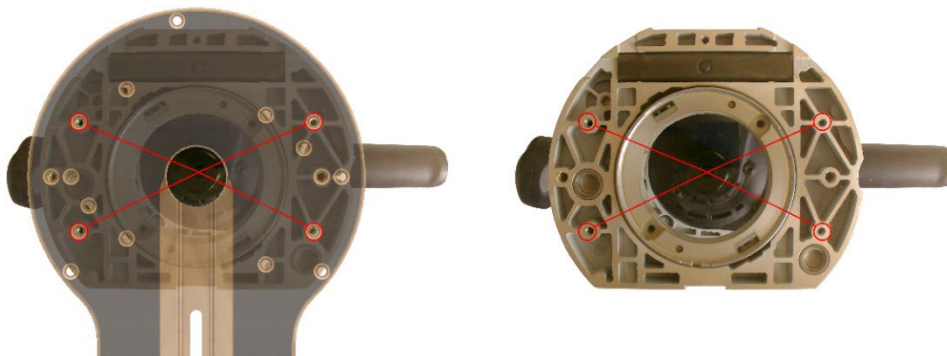


19 : Hole pattern for OF1010 - left-handed

Assembly for OF1400

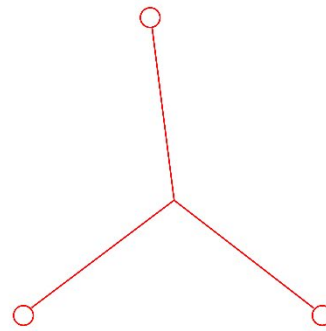
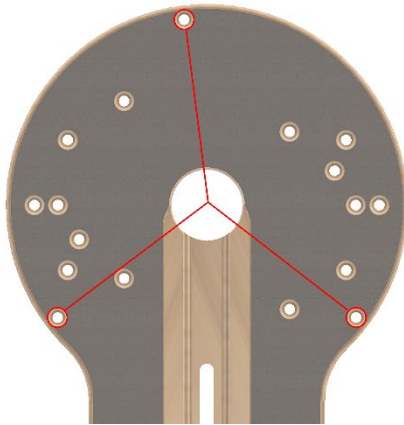


20 : Hole pattern OF1400 – right-handed



21 : Hole pattern for OF1400 – left-handed

Assembly for OF2200

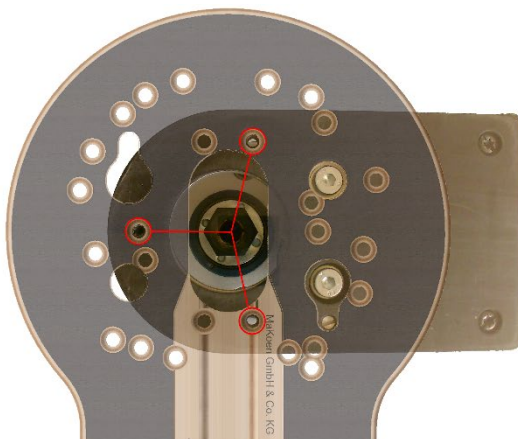


22 : Hole pattern for OF2200

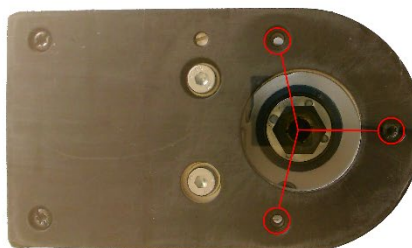
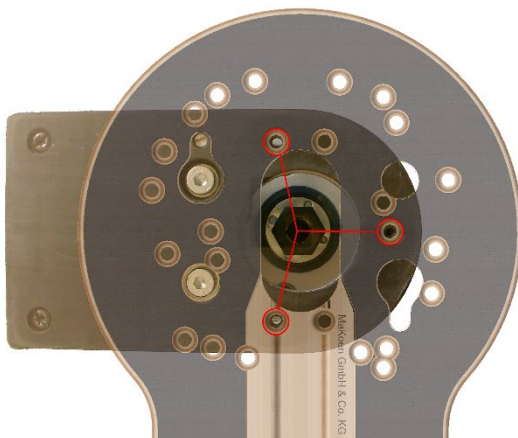
(Illustrations will be added)

GKF milling compass

Assembly for GKF12V-8

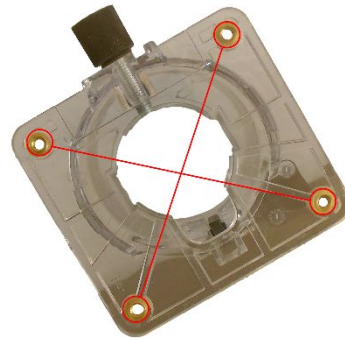
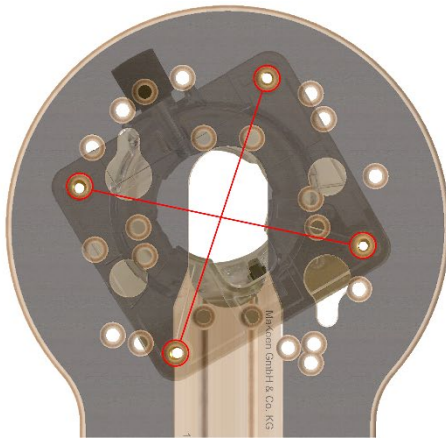


23 : Hole pattern for GKF12V-8 – right-handed



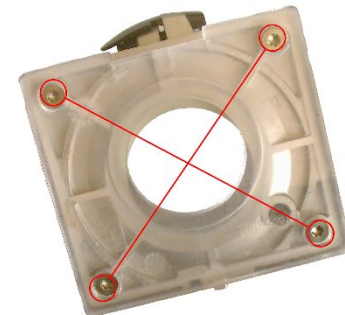
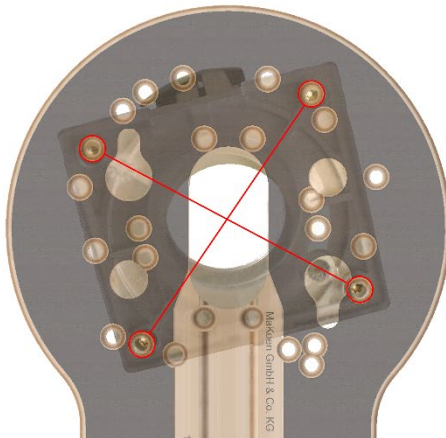
24 : Hole pattern for GKF12V-8 – left-handed

Mounting for GKF550 & GKF18V-8



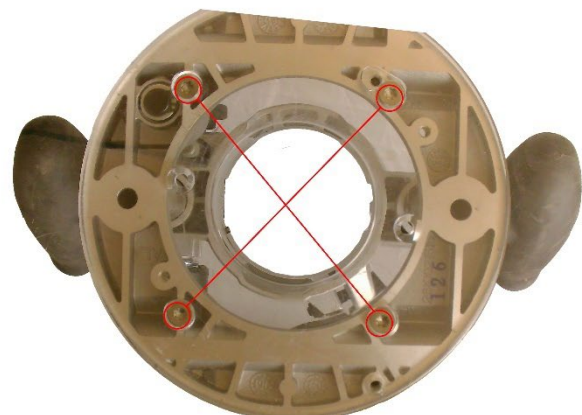
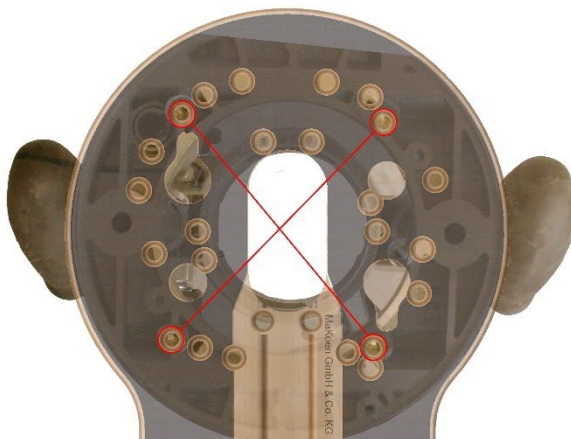
25 : Hole pattern for GKF550 / GKF18V-8

Assembly GKF600 – Edge milling module



26 : Hole pattern for GKF600 edge milling module

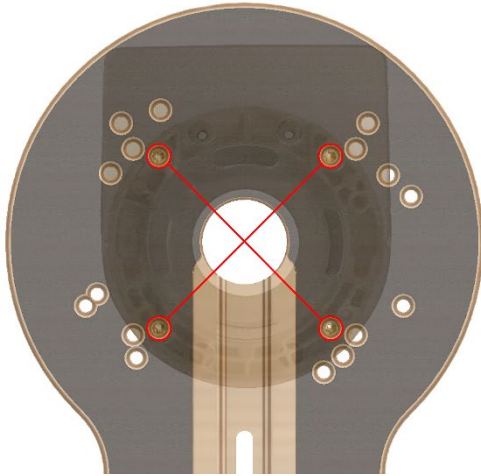
Assembly for GKF600 - Plunge unit



27 : Hole pattern for GKF600 plunge unit

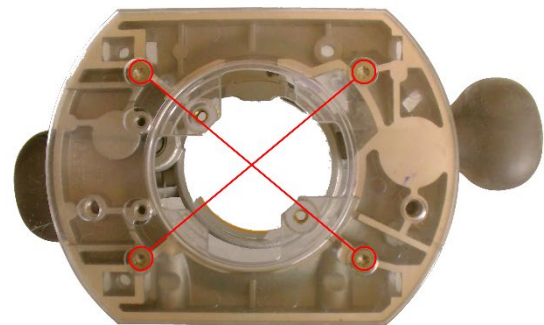
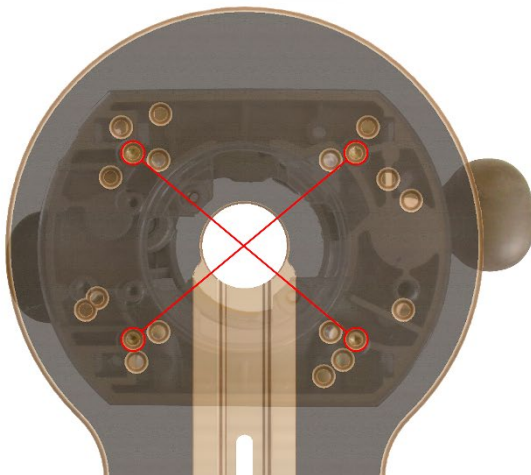
Milling compass DWT

Assembly for D25204K edge milling module



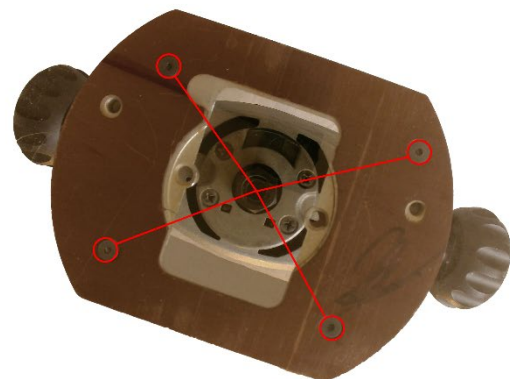
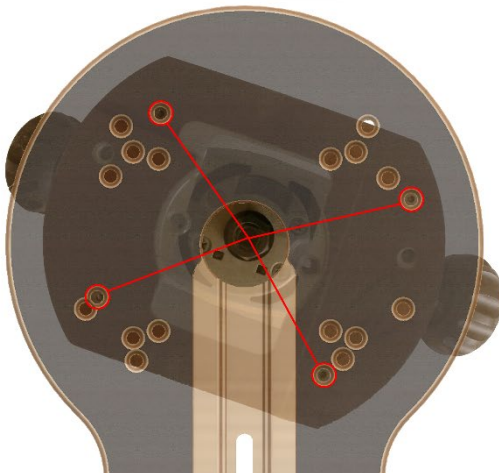
28 : Hole pattern for edge milling module

Assembly for D26204K router module / plunge unit



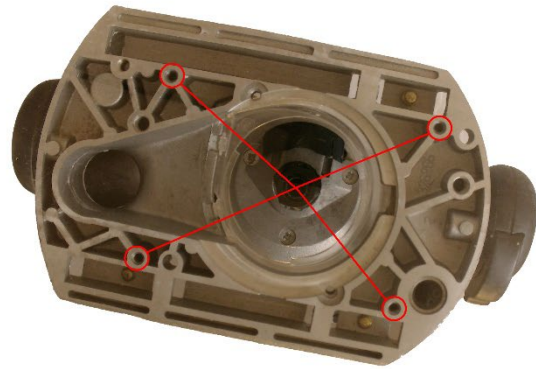
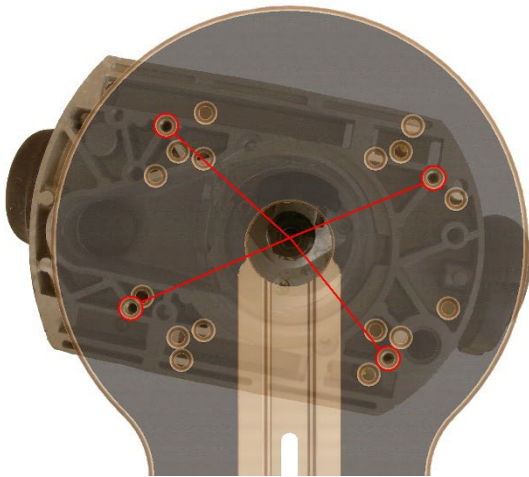
29 : Hole pattern for router module

Mounting for DW615

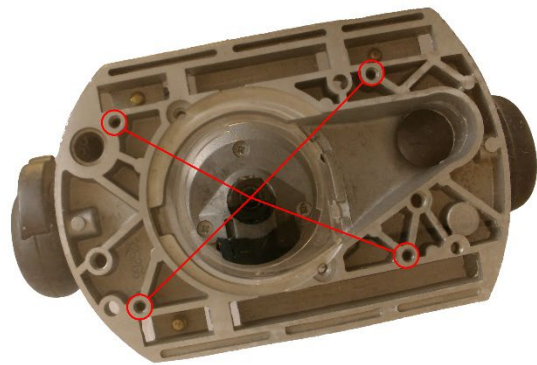
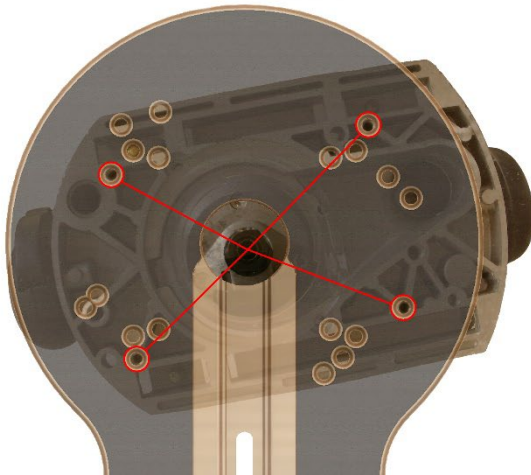


30 : Hole pattern for DW615

Assembly DW625



31 : Hole pattern for DW625 – extraction on the right-hand side



32 : Hole pattern for DW625 – extraction on the left

FAQ

1. Which models fit your milling compasses?

A: We offer suitable milling compasses for the following models:

Makita: RT0700 – DRT50Z

Bosch: POF1400

Bosch Professional: GKF600 – Router module – Edge milling module – Angle milling module – GKF12V-8 – GKF18V-8 – GOF1250

Festool: OF1010REB – OF1010REBQ – OF1400 – OF2200

DeWalt: D26204 – Router module – Edge router module – DW615 – DW625

2. The template is curved, why?

A: The base material is birch plywood with a phenolic resin coating. During the manufacture of the base material, tension builds up in the material, which is already present before processing and causes the board material to warp. Unfortunately, this cannot be prevented.

Router compass: The centring pin is long enough to hold securely in the centre even with slight curvature.

MFT template: It is recommended to clamp the template in place, regardless of any possible curvature. Clamping will compensate for this.

6-fold template: Due to the compact shape of the template, warping is usually not noticeable. However, if this does occur, the template is discarded.

3. The holes in the MFT are too small; my copying sleeve does not fit.

Copying sleeves are stamped sheet metal parts. They are not manufactured to fit. With our measurement protocol, we want to ensure for everyone that our part of the work has been done properly and to avoid "outliers".

Not satisfied?

Do you have any questions or suggestions?

Please contact us using one of the following options:

Tel. 0421 960 15 70

Mobile: 0176 28 54 7300

Email: info@makoen.com

