



Whiteside Machine Company

Shaker Stile & Rail Setup



5990A 5990B

Recommended RPM for Stile & Rail bits: 18,000

Note: All stock should run “face down” when making cuts.

- Stiles are as long as the door is tall plus 1/16” (1/16” trim or sanding allowance)
- Rails are equal to door width minus stile width times 2 plus 3/4”
 Example: If the door is 12” wide and the stiles are 2” wide then: $12” - (2” * 2) + 3/4” = 8-3/4”$ wide rails.
- Rails generally look better a little wider than the stiles. Panels use undersized 1/4” plywood panels (Actual panel thickness of 7/32” or 5.5 mm).
- Material for stiles and rails should be the same thickness, 3/4” works the best
- Whiteside #'s its bits with an “A” for the stile and “B” for the rail ends. Insert the stile bit into the router and align the fence even with the bearing. Without turning the router on, make sure a straight edge can pass by and touches the bearing. Align the center of the stile cutter with the centerline of the material.
- Rout the entire inside edge of the stiles and rails with the stile bit. Make sure all the parts are ran face up or face down. Your preference. The rail ends will have to be ran in the same orientation.
- Now you are ready to rout the rail ends. Put the rail bit into the router and re-align the fence with the bearing. To align the rail cutter correctly after it is inserted into the router, take a stile, which has already been routed and align the bottom side of the top groover with the bottom of the tab above the slot. This will get the cut very close and fine adjustment may be necessary to make sure the boards line up flush.
- For safety, always use a push block that can support the entire rail when routing the ends.
 If you do not use a good push block, the material can turn in the cut or grab the wood and give an unsatisfactory cut.
- Always use an extra piece of wood to get the correct setup and prevent extra waste.



Part #	Pattern	Cutting Length	Large Dia.
1/2” SHANK			
5990	Shaker	13/16”	1-5/8”

These sets are for cabinet door construction with undersized 1/4” plywood panels (Actual panel thickness of 7/32” or 5.5 mm).