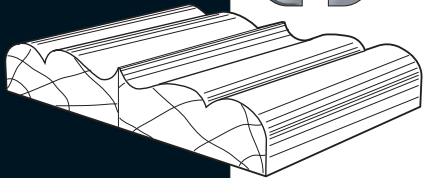
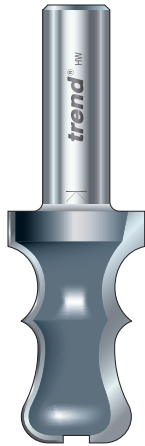




Linen Fold Cutter 18/96X1/2TC

Please read carefully before use



LINEN FOLD CUTTER REF. 18/96

Thank you for purchasing this Trend router cutter, which should give lasting performance if used in accordance with these instructions.

The following symbols are used throughout these instructions.



Denotes risk of personal injury, loss of life or damage to the tool in case of non-observance of the instructions.



Refer to the instruction manual of your power tool.

This product must not be put into service until it has been established that the power tool to be connected to this unit is in compliance with 2006/42/EC (identified by the CE marking on the power tool).

INTENDED USE

The Linen Fold cutter is intended for use on timber and wood-based products.

This cutter should be used in a fixed head routing machine for accurate results (minimum 1500 watts, 1/2 inch shank capacity).

The profile is machined onto the material's face surface, which is made in two halves for each section required. The profile can also be routed onto the ends of the strips.

The full scroll effect can be applied to the ends with a bearing guided channel cutter (Trend Ref. 23/12X1/4TC). A template can be made from the Linen Fold Scroll Template Diagram provided with this cutter. Ref. DIAG/LFSCROLL

Alternatively the scroll effect can be carved out by hand with carving chisels.

SAFETY

Please read and understand the safety points at the end of this instruction as well as the power tool instructions before use.

PLEASE KEEP THESE INSTRUCTIONS IN A SAFE PLACE.

The attention of UK users is drawn to The Provision and Use of Work Equipment Regulations 1998, and any subsequent amendments.

Users should also read the HSE/HSC Safe Use of Woodworking Machinery Approved Code of Practice and Guidance Document and any amendments.

Users must be competent in using woodworking equipment before using our products.

ITEMS REQUIRED

- Router with suitable collet fitted.
- Router table with mitre fence.
- Timber support block.
- Double-sided tape.
- Hand tools.

OPERATION

Carefully remove the protective wax from the cutter and dispose. Insert the cutter shank into the collet all the way to the marked line indicated on the shank. This ensures at least 3/4 of the shank length is held in the collet.

It is advisable to make test cuts to ensure set-up is correct.

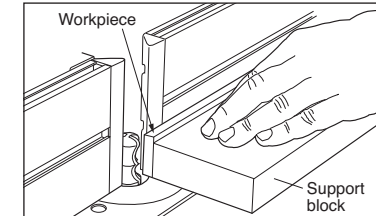
Machining Process Overview

Prepare strips to correct section size.

A support block should be made so that each strip can be mounted on it. This will allow the material to be pushed safely through the router table with fingers away from the cutting head.



Recommended speed is 22,000 rpm



Ensure working position is comfortable when routing. Keep proper footing and balance at all times.

To be most productive, longer strips of the linen fold profile could be made and then cut down into several pieces. This would depend on a long enough support block being available to mount the strip onto.

Machining Process in Detail

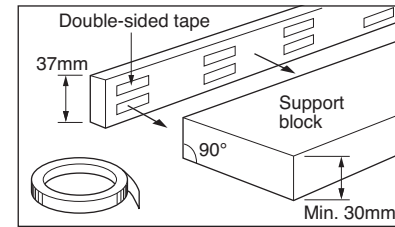
Timber Set-up

Prepare strips to 37mm x 9.5mm section. Ensure edges are square.

Prepare a support block to mount the strips to. The support block should be at least 30mm thick, have a flat base and a square, flat edge on the side where the strips are to be mounted.

Mount a strip onto a support block using several pieces of double-sided tape, ensuring the bottom of the strip is level with the bottom of the support block.

Ensure surfaces are clean and free of grease for sufficient adhesion, and press together with a clamp if necessary.



PTO

ENVIRONMENTAL PROTECTION

Recycle raw materials instead of disposing as waste.

Packaging should be sorted for environmental-friendly recycling.

The product and its accessories at the end of its life should be sorted for environmental-friendly recycling.

GUARANTEE

All Trend products are guaranteed against any defects in either workmanship or material, except products that have been damaged due to improper use or maintenance.

© Trend Machinery & Cutting Tools Ltd. 2011 E&OE
© All trademarks acknowledged

Trend Machinery & Cutting Tools Ltd.

Odhams Trading Estate St Albans Road
Watford WD24 7TR England

Tel: 0044(0)1923 249911
technical@trendm.co.uk

www.trend-uk.com



5 027654 047675 >



RS 28982
Stockholding
& Supply



RECYCLABLE

trend
routing technology

INST/18/96 v2.0

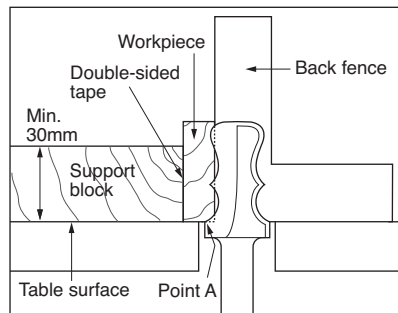
Cutter Set-up and Machining

Insert the cutter into a table-mounted router, ensuring that it is inserted sufficiently into the collet to the K mark on the shank.

Set the height of the cutter so that the bottom of the lower bead (point A) is in line with the table surface. A fine height adjuster is useful for this if a compatible router is used. Lock the height.

The profile should be machined in two cuts.

For the first cut, set the back fence so that the depth of cut is approximately half the amount of the total depth required.



Set-up for first cut

Lock off the back fence.

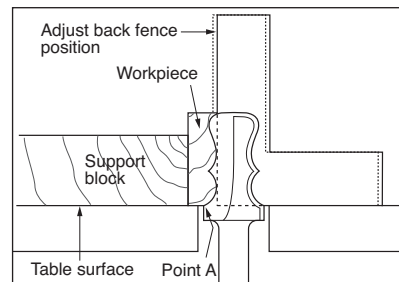
Mount a strip to the support block and machine first cut on to each one. When

pushing the support block through, ensure that hands are away from the cutter. A pushstick can be used to assist if the support block is narrow.

If several lengths of strip need to be profiled, de-mount the routed strip, mount and rout another one. Repeat until all have received first cut.

Adjust the backfence to take the second cut. Set so that the back fence is a small amount beyond the point of the deepest part of the profile, allowing the complete profile to be routed.

Lock off the back fence.



Adjust back fence for second cut

Push material through at a moderate constant rate to achieve a good finish on the workpiece.

De-mount the routed strip, mount and rout another one. Repeat until all have received a second cut.

Scribing the Ends

The height of the cutter should not need to be adjusted for this stage. Cut the strips to slightly over the required finished length, allowing for a light skim cut at each end.

The profile can be applied to the ends with the assistance of a mitre fence on the router table.

If using a mitre fence, ensure that it runs parallel with the back fence.

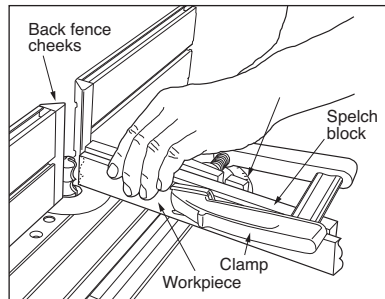
Ensure back fence cheeks are no more than 3mm away from the cutter.

A splch block should be fitted behind the workpiece to minimize break-out.

The workpiece must be clamped to the mitre fence to prevent it from moving.

Alternatively, the Trend pushblock Ref. PUSHBLOCK/4 could be used.

Take light passes until the full depth is reached.



Scribing the ends

Creating the Scroll Effect

The full scroll effect can be made using a bearing guided channel cutter (Ref. 23/12X1/4TC).

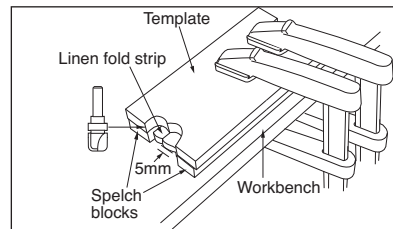
A template can be made for the Ref. 23/12 cutter to guide against enabling a consistent scroll pattern to be achieved. The template can be made using the Linen Fold Scroll Template Diagram.

Splch blocks of the same thickness as the linen fold strip should be attached to the underside of the template, to protect the shoulders of the work-piece from breakout during routing and prevent it from slipping.

The linen fold strip should be positioned 5mm in from the end of the template to allow for the router cutter to lead on to the area to be routed.

Set Ref. 23/12 to rout 3mm deep into the work-piece strip. Clamp the work-piece and template to the workbench and carefully rout the scroll pattern. Increase the depth of the cutter to remove a further 3mm.

Reposition the template correctly for each end of the linen fold strip and repeat.



Finishing

The two halves of the linen fold strips can be fixed to a timber panel using wood glue.

When gluing the linen fold strips to the panel, they should be lightly held in place until the glue has set.

The completed panel can be treated with one or two coats of varnish or linseed oil.

SPARE PARTS

Only use original Trend spare parts.

MAINTENANCE

Continual satisfactory operation depends upon proper tool care and regular cleaning.

Cleaning

- Ensure clamping surfaces are cleaned to remove dirt, grease, oil and water.
- Remove resin build-up regularly.
- Apply a rust protector to shanks.

Lubrication

- Use a PTFE dry lubricant spray on tool to increase cutting edge life.

Storage

- Return cutter to its packaging after use.

Safety Points

1. Disconnect power tool and attachment from power supply when not in use, before servicing, when making adjustments and when changing accessories such as cutters. Ensure switch is in "off" position and cutter has stopped rotating.
2. Read and understand instructions supplied with power tool, attachment and cutter.
3. Current Personal Protective Equipment (PPE) for eye, ear and respiratory protection must be worn. Keep hands, hair and clothes clear of the cutter.
4. Before each use check cutter is sharp and free from damage. Do not use if cutter is dull, broken or cracked or if any damage is noticeable or suspected.
5. The maximum speed (nmax) marked on tool or in instructions or on packaging shall not be exceeded. Where stated, the speed range should be adhered to.
6. Insert the shank into the router collet at least all the way to the marked line indicated on the shank. This ensures at least 3/4 of shank length is held in collet. Ensure clamping surfaces are clean.
7. Check all fixing and fastening nuts, bolts and screws on power tool, attachment and cutting tools are correctly assembled, tight and to correct torque setting before use.
8. Ensure all visors, guards and dust extraction is fitted.
9. The direction of routing must always be opposite to the cutter's direction of rotation.
10. Do not switch power tool on with the cutter touching the workpiece.
11. Trial cuts should be made in waste material before starting any project.
12. Repair of tools is only allowed according to tool manufacturers instructions.
13. Do not take deep cuts in one pass, take shallow passes to reduce the side load applied to the cutter.

Please see www.trend-uk.com/safety for more safety advice.



Our policy of continuous improvements mean that specifications may change without notice. Trend Machinery & Cutting Tools Ltd. cannot be held liable for any material rendered unusable, or for any form of consequential loss.