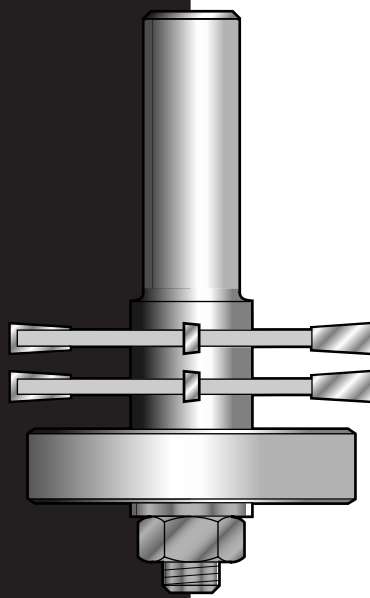


Corian® Tongue  
& Groove Set

91/20

INSTRUCTIONS



Please read carefully before use

### TONGUE & GROOVER SET FOR CORIAN® REF. 91/20

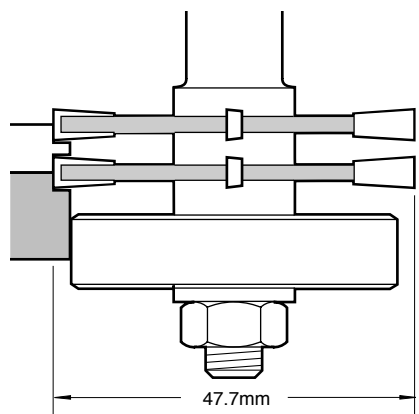
Thank you for purchasing this Trend router cutter, which should give lasting performance if used in accordance with these instructions.

The 91/20 will produce perfectly matched tongue and groove joints in 6mm Corian®.

A heavy duty router should be chosen with a 12.7mm (1/2") collet capacity (or 12mm collet for 12mm shank groover sets).

The set is supplied in tongue mode as shown in assembly A and must be re-assembled into groove mode for the first routing operation as shown in Assembly B.

**⚠ Please note:**  
Before use of cutter, please ensure it is correctly assembled and the locking nut is fully tightened.



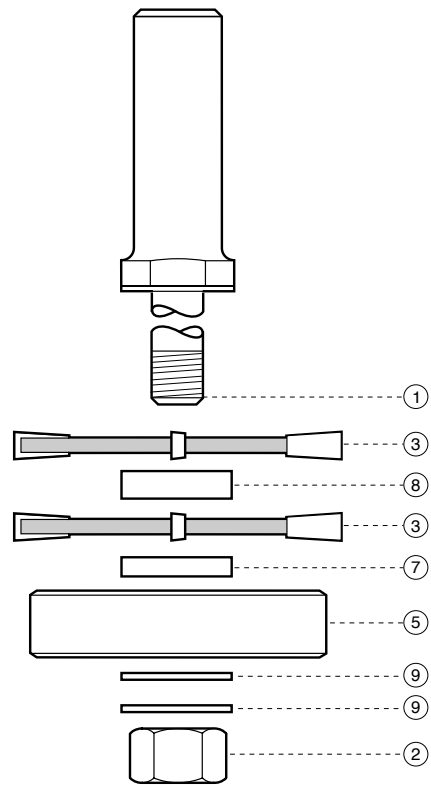
#### Parts Supplied in Set

1. Arbor (x1)
2. Nut 13mm A/F (x1)
3. Groover 4mm Kerf (x2)
4. Groover 2mm Kerf (x1)
5. Delrin® Bearing 43mm Ø (x1)
6. Alloy Bearing 41mm Ø (x1)
7. Spacer 3.14mm (x1)
8. Spacer 4.44mm (x1)
9. Washer 1mm (x2)

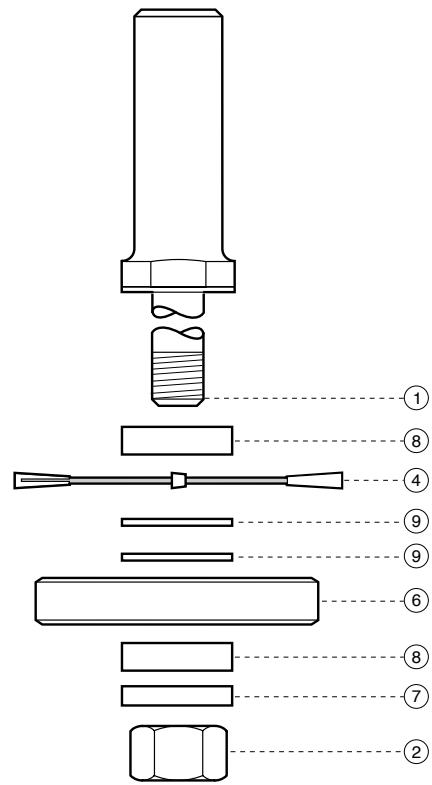


Each set is supplied with spare shims for use with the set for fine adjustment.

#### Set-up for Machining Tongue (Assembly A)



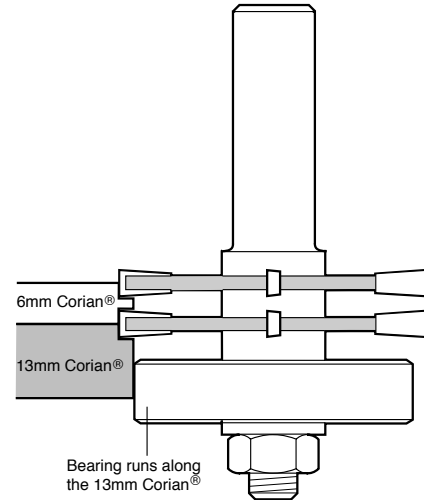
#### Set-up for Machining Groove (Assembly B)



## Procedure for Producing Tongue

Use 13mm (or more) thick Corian® or other straight material as a template. This will allow the bearing to run against it to produce a straight cut and an exact length of tongue.

Before machining the tongue ensure the 6mm Corian® is securely clamped to the template.

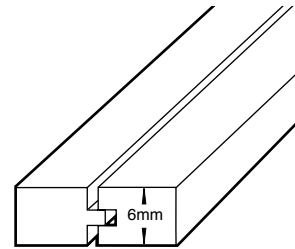


## Procedure for Producing Groove

Leave the arbor in the machine. Undo nut and remove all parts of Assembly A. Some parts are common to both Assembly A and B.

Re-assemble the tooling parts as in Assembly B, making sure the groover is placed on the arbor the correct way round. Tighten the nut. The depth of cut does not need to be adjusted. Template material is not required.

After regrinding, the tool may need shimming up to tighten the joint. Shims are provided in the set for that purpose.



Spare Parts	Order Ref.
Arbor 1/2" shank	<b>33/30X1/2</b>
Arbor 12mm shank	<b>33/30X12MM</b>
Groover 2mm Kerf	<b>SP-91/20A</b>
Groover 4mm Kerf	<b>SP-91/20B</b>
Delrin® Bearing 43mmØ	<b>BB43</b>
Alloy Bearing 41mmØ	<b>BB41</b>
Replacement Arbor Nut	<b>ANUT/33/30</b>
Spacer Set	<b>SPACER/8</b>

## Safety Steps

1. Always wear eye protection such as goggles, ear protection and use effective respiratory protection.
2. Before making adjustments to the router, like changing the cutter, make sure the power is isolated correctly.
3. Before re-connecting to the mains supply, make sure the power switch on the router is in the 'off' position.
4. Do not switch on the router with the cutter in contact with the workpiece.
5. Before making adjustments always allow the cutter to stop rotating.
6. When routing keep your hands, hair and clothing clear of the cutter.
7. Make sure you follow the instructions which came with your router.
8. Ensure all visors, guards and dust extraction are fitted.
9. Trial cuts should be made in waste material before starting any project.

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

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.

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### Trend Machinery & Cutting Tools Ltd

Odhams Trading Estate St Albans Road  
Watford WD24 7TR

Technical Support: 01923 224681

Fax: 01923 236879

Email: [mailserver@trendm.co.uk](mailto:mailserver@trendm.co.uk)

WWW: [www.trendm.co.uk](http://www.trendm.co.uk)



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