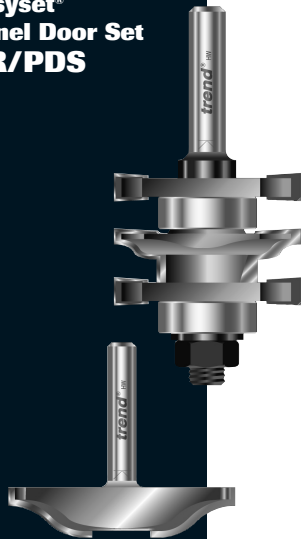




Craft Range Easyset® Panel Door Set CR/PDS



trend
routing technology

INST/CR/PDS v3.0

Please
read carefully
before use

PANEL DOOR SET REF. CR/PDS

Thank you for purchasing this Trend router cutter set, 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 cutter 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 98/37/EC (identified by the CE marking on the power tool).

INTENDED USE

This cutter set is intended to be used in a fixed head routing machine to produce a cabinet frame and panel door in wood and MDF.

Material thickness: min. 18mm
 max. 22mm

An ideal timber thickness is 20mm.

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.

Attention should be made to the HSE's Safe Use of Vertical Spindle Moulding machines Information Sheet No. 18 and any revisions.

ITEMS REQUIRED

- Router with suitable collet fitted.
- Router table or overhead router stand.
- 13mm A/F spanner.
- Hand tools.
- Jig making equipment & materials.
- Workholder.

ITEMS ENCLOSED & DESCRIPTION OF PARTS

- A. Arbor **x1**
- B. Nut 13mm A/F **x1**
- C. Profile block **x1**
- D. Groover **x2**
- E. Ball Bearing 22mm Dia. **x2**
- F. Washer 1.0mm **x1**
- G. Shims 0.1mm **x3**
- H. Shims 0.05mm **x3**
- I. Instructions **x1**

ASSEMBLY

Changes in tightness can be achieved by adding or removing shims G & H. This is most important after resharpening.

The cutter height is simply lowered or raised to cut the scribe or profile on the wood.

The ball bearings will automatically give the correct depth of cut.

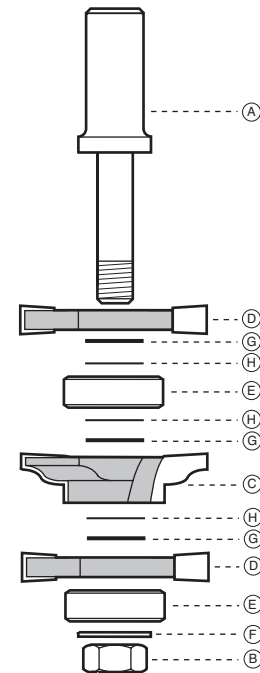
The cutter is supplied when purchased with all the cutting edges in line, the parts D, C, R and D should be assembled square to each other (turn one through 90°) to reduce cutting impact.



When using stacked tooling (multi-blade, block, groover etc.) on a spindle arbor, ensure that the cutting edges are staggered to each other to reduce the cutting impact.

NOTE: Diagrams show cutting edge not staggered for clarity.

Cutter Set-up as supplied



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.

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PTO

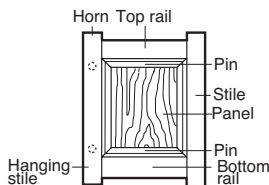
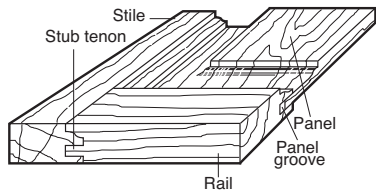


RS 2882
Stockholding
& Supply

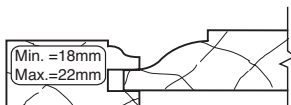
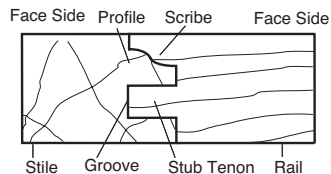


RECYCLABLE

Parts of a Panelled Door



The Joint



OPERATION



Carefully remove the protective wax from the cutter and dispose.

Insert the cutter shank into the collet at least 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.

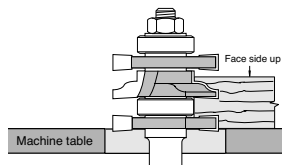
Cutting the Scribe

Material should be squared all round to ensure perfect joints are achieved. Always unplug the router from the power supply before making any adjustments and ensure that the cutter is guarded so that operator's fingers cannot contact the cutter.

On particularly hard timbers it is advisable to take shallow passes. This can be achieved by using the back fence. The final cut using the ball bearing as a guide.

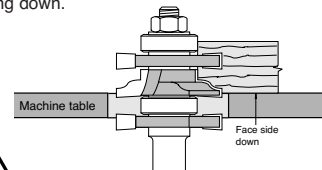
The groover, ball bearing and cutter block nearest the shank of the arbor are used for cutting the scribe across the ends of the rail. When routing inverted in a table the scribe is cut with the face side of the wood facing up. A workholder should be used as the rails will be too narrow to run against a fence. This also has the advantage of making the operation safer and more accurate.

The height of the cutter should be adjusted according to the thickness of the timber between 18mm to 22mm.



Cutting the Profile

When the scribes on the ends of the rails have been cut, raise the height of the cutter so that the groover, ball bearing and cutter which is nearest the arbor shank can be used to cut the profile. The profile is cut along the wood. When routing inverted in a table the face side of the wood is facing down.



Before using cutter, please ensure it is correctly assembled and locking nut is fully tightened.



Recommended speed for profile/scribe is 18,000rpm. Recommended speed for panel cutter is 18,000rpm.

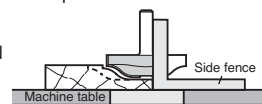


When using the sets at minimum timber thickness the height of the top quirk may be reduced.

Producing the Panel

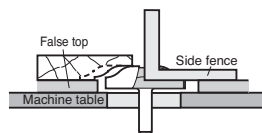
The Panel cutter supplied in CR/PDS set is not fitted with a guide bearing. A side fence will therefore be required to guide the workpiece. For shaped panelling a copy pin in the table and a template should be used.

C173 mounted over the table



The length of the tongue can be increased by altering the side-fence position prior to a second pass.

C173 mounted under the table.



If the cutter will not fit through your table, a false top will be required to achieve the correct depth. This should ideally be made from plywood or MDF. Always take a number of passes to improve finish and to ensure longer cutter life. Always feed timber against the direction of cutter rotation. Diagrams show guards removed for clarity.

SPARE PARTS

Please use Trend original spare parts only.

Item	Qty	Description	Order Ref. (1 off)
A	1	Replacement arbor 8mm shank	33/31X8MM
B	1	Replacement arbor nut	ANUT/33/30
C	1	Profile block	SP-C149A
D	2	Groover	SP-C149C
E	2	Bearing 22mm dia.	BB22
		Spacer set	SPACER/8
I	1	Instructions	INST/CR/PDS

MAINTENANCE

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

Cleaning

- Remove resin build-up regularly.
- Apply a rust protector to shanks. Do not use rust protector on ball bearing guides.

Lubrication

- Use a PTFE dry lubricant spray on tool.
- Apply a rust protector to shanks. Do not use rust protector on ball bearing guides.

Storage

- Return cutter to its packaging after use.

Safety Points

- 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.
- Read and understand instructions supplied with power tool, attachment and cutter.
- Current Personal Protective Equipment (PPE) for eye, ear and respiratory protection must be worn. Keep hands, hair and clothes clear of the cutter.
- 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.
- The maximum speed (rmax) marked on tool or in instructions or on packaging shall not be exceeded. Where stated, the speed range should be adhered to.
- 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.
- 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.
- Ensure all visors, guards and dust extraction is fitted.
- The direction of routing must always be opposite to the cutter's direction of rotation.
- Do not switch power tool on with the cutter touching the workpiece.
- Trial cuts should be made in waste material before starting any project.
- Repair of tools is only allowed according to tool manufacturers instructions.

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



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