



**CNC  
MACHINING**

**trend**  
Industrial tooling

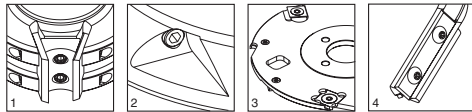
INST/IT/CNC v1.0



Please  
read carefully  
before use

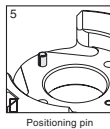
### General Instructions

1. Thank you for purchasing this brand new CNC router cutter from Trend. This tool was designed and manufactured according to the European standard EN 847-1/2.
2. This cutter is only suitable for machining wood, wood derived materials, plastics and non-ferrous metals.
3. Before first use, please check that the screws (see fig. 1 – 4) are tightened correctly and the cutting edges are not damaged. If any of the screws are missing, or the cutting edges are damaged, do not use the router cutter and return it to the distributor from where it was purchased.
4. Before putting the router cutter on the machine, please ensure that the recommended RPM etched on the cutter shank matches the RPM of your machine and the cutter is rotating in the correct direction.



Example for tightening screws

5. If the router cutter is a set, please check every part of the set individually and only assemble according to the supplied instructions. Only assemble the parts in a way that is allowed by the positioning pins (see fig. 5).



Positioning pin

6. Don't remove, reassemble, or replace parts that will change the characteristics of the original cutter. Removing, reassembling or replacing parts of the cutter could invalidate the guarantee.
7. Handle the tool carefully. Cutting edges can be damaged if the tool is not handled properly.

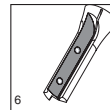
8. Try to avoid touching the cutting edges. The edges are sharp and may cause injury.

### Installing the cutter on the machine

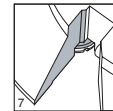
1. Make sure that the shank diameter of the router cutter matches the collet of your machine. Don't force the cutter into the machine collet and don't make any changes to the shank of the cutter.
2. Ensure that the rotation direction of your machine corresponds to the rotation of the cutter.
3. Make sure the collet nut is sufficiently tight before you start using the cutter.
4. Before starting the machine, make sure the cutter is able to rotate freely and does not come into contact with any part of the machine.

### Working with the cutter

1. Please make sure you read and fully understand the machine instructions before working with this cutter.
2. Do not exceed the maximum RPM etched onto the cutter.
3. We recommend that suitable eye, mouth and ear protection is worn whenever working with woodworking machinery.
4. Ensure machine is connected to suitable dust extraction equipment, as specified by the machine manufacturer. Failure to use adequate dust extraction equipment can result in harmful dust being released into the work place and poor cutter performance.
5. When using a new cutter, or after replacing the cutter knives, we recommend that the screws are checked and re-tightened if necessary, after a few minutes use.
6. Check the knives regularly for sharpness. Dull knives can damage the cutter, machine and work piece. Replace the knives before they get dull.



7. Try to keep the cutter as clean as possible. A clean cutter will improve chip flow and cut quality.



Knife seat area

8. If the cutter comes into contact with a foreign object during use, immediately switch the machine off and check the cutter for damage. It is important to check the knife seating area (see fig. 6 and 7) for damage before replacing the new cutter knife. Damaged seating areas will decrease the holding force on the knife and could cause the cutter to be dangerous.

9. Trial cuts should be made in waste material before starting any project.

### Maintenance

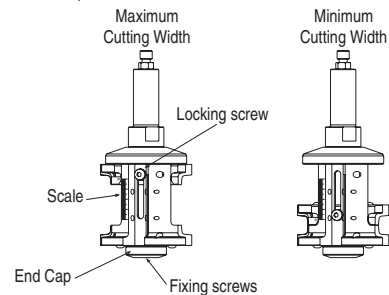
1. When replacing the knife, try to work in a clean environment. Remove any dust or chips with Trend Resin Cleaner.
2. Use only the original keys and gauges supplied with the cutter. The replacing of knives does not require any undue force. Exaggerated force will damage the screws and clamping parts.
3. After removing the dull knife, ensure that the knife seat is clean.
4. Make sure that the knife is positioned in the correct direction. When tightening the screws, push the knife against the seating area.
5. Use only original Trend spare parts.
6. The coating used on the cutters is sensitive to acid. Do not clean the tools with any products containing acid.

### Storage

1. We recommend that the cutter is kept inside its' box when not in use. This will protect it and keep it clean and oiled against corrosion.
2. Always return spare knives and blades to their protective storage packaging when not in use.

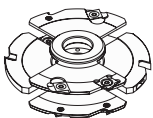
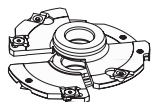
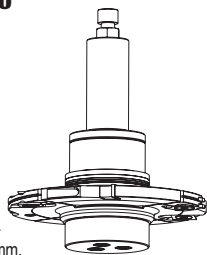
### Disposable Insert Rounding and Chamfering Router Cutter Sets Ref. IT/8524100 – IT/8524210

1. This CNC rounding and chamfering cutter can be adjusted to suit different wood widths.
2. To adjust the cutter to the required width (see picture):
  - a. Open the two locking screws.
  - b. Move the unlocked part of the cutter along the tool shaft until the required wood width is reached.
  - c. Tighten the locking screws.
3. There is an incremental scale on the tool body, for easy adjustment.
4. This tool can be used to cut in a right hand or left hand direction. To change the direction of cut:
  - a. Open the three cup screws at the bottom of the tool and remove the end cap.
  - b. Hold the rest of the parts together and pull the arbor out.
  - c. Insert the arbor back through the parts from the other end and tighten the cup screws.



**Disposable Insert Adjustable Grooving cutter 4 –15.5mm Ref. IT/8220500**

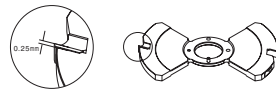
1. It is possible to adjust this CNC grooving cutter to different cutting widths.
2. To adjust the width, first remove the three fixing screws at the bottom of the cutter.
3. Remove the end cap and the cutters from the arbor.
4. The three cutters can be assembled in two separate ways:
  - a. 2 part assembly – cutting width 4 – 7.7mm.
  - b. 3 part assembly – cutting width 7.8 – 15.5mm.
5. You can adjust the cutting width by adding or removing the supplied spacer rings to the arbor.
6. When using the three-part groover, for thicker widths, it is important that you spread the spacer rings equally above and below the middle cutter.



**For example:** To get a cutting width of 10mm with the three-part groover, you need to add spacer rings to a total width of 2.2mm – 2 x 1mm and 2 x 0.1mm = 2.2mm. Place 1 x 1mm + 1 x 0.1mm spacer on top of the middle cutter and 1 x 1mm + 1 x 0.1mm spacer below the middle cutter.

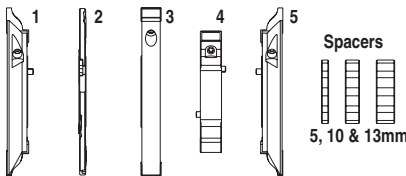
7. Reassemble the cutters on the arbor, replace the end cap and tighten the three fixing screws.
8. The tool can be assembled for both right hand and left hand cutting directions.

9. It is important that the knives in the middle cutter are kept with 0.25mm protruding above the top of the cutter body (see drawing below). To achieve this, use the supplied 0.25mm gauges, when replacing dull knives.

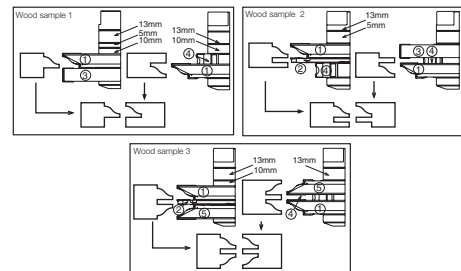


**Disposable Insert Profile – Counter/Profile Router Cutter Set Ref. IT/8420210 and IT/8420220**

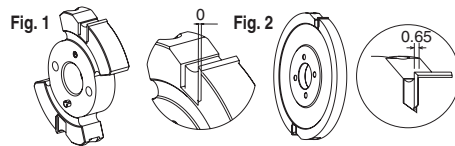
1. This CNC profile/counter profile cutter comes as two separate sets, depending on which one you've purchased.
  - a. The mini set (Order Ref. IT/8420210) contains cutters 1, 2, 3, and 4 and is designed for profiling cabinet doors (wood samples 1 and 2).
  - b. The complete set (Order Ref. IT/8420220) contains cutters 1, 2, 3, 4, and 5 and can also be used for producing internal doors (wood samples 1, 2 and 3).



2. To disassemble the tool release the three fixing screws at the bottom of the cutter.
3. Assemble the cutters on the arbor as shown in the wood sample pictures. Each wood sample has its' own combination of cutters and spacers, please ensure that they are assembled in the correct order, according to the examples.

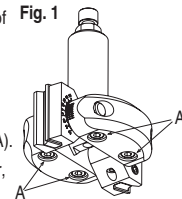


4. This tool can be used to cut in a right hand or left hand direction. To change the direction of cut:
  - a. Open the three fixing screws at the bottom of the tool and remove the end cap.
  - b. Hold the rest of the parts together, including the spacers, and pull the arbor out.
  - c. Insert the arbor back through the parts from the other end, replace the end cap and tighten the cup screws.
5. Ensure you use the 0.65mm gauge when replacing the knives on cutter No.3.
6. Use the straight gauge when replacing the knives on cutter No.4.



**Disposable Insert Adjustable Chamfer Router Cutter Ref. IT/8540011**

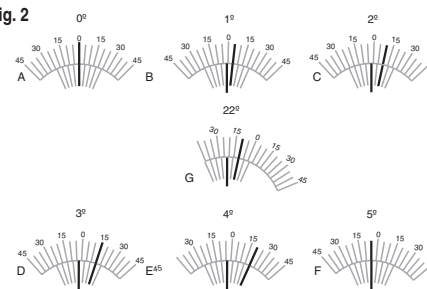
1. This cutter can be adjusted to an accuracy of 1°. For convenience, you can also use the built in notched scale, which enables fast adjustment in steps of 7.5°.
2. To adjust the cutter to the desired angle:
  - a. Release the safety screws (see fig. 1, item A).
  - b. Use the vernier scale, etched onto the cutter, to adjust to the required angle.



**For example:** To get a 22° angle put the longer zero line (etched onto the cutter body) between the 20° and 25° angle (see fig. 2G), adjust the second notch on the lower scale to the second notch after the zero line on the top scale.

3. Re-tighten the safety screws before using the cutter.

**Fig. 2**



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