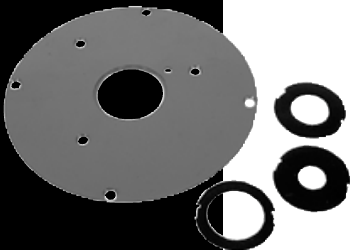




Steel Insert Plate SRT/PLATE



IMPORTANT!

It is advisable that this plate is used in conjunction with a plate levelling kit Ref. CPL/KIT.

trend
routing technology

INST/SRT/PLATE v2.0

Please read carefully before use

Router Compatibility

See machine screw illustrations

The following routers will fit plate directly:

Make	Router Model	Screw x Qty
TREND	T3, T5	F X 2
TREND	T9	F X 3
BOSCH	GOF1600A, 1700ACE	F X 3
CMT	CMT1E	F X 3
DEWALT	DW613, 614, 615, 620, 621	F X 2
DEWALT	DW624, 625E, 629	F X 3
DRAPER	PT1200V	F X 2
ELU	MOF96(E) MK2, OF97(E)	F X 2
ELU	MOF131, 177(E)	F X 3
FELISATTI	R346EC	F X 3
MAKITA	RP0910, 1110C	F X 2
PERLES	OF808(E) >1999	F X 2

The following routers will require modification of the router base: and/or insert plate (see key)

Make	Router Model	Screw x Qty	Csk / Hole Ø
AEG	OF450S , 500S , OFSE850 , OFS50	G X 2	13mm/6mm
ATLAS COPCO	OF5720 , OFSE850 , 1000 , OFS50 , OFE710	G X 2	13mm/6mm
ATLAS COPCO	OFSE2000	G X 3	13mm/6mm
B&D	KW779 , 780(E) , BD780(E) , 800(E)	A X 3	9.5mm/4mm
B&D	SR100 , DN67 , BD66	G X 2	13mm/6mm
BOSCH	POF400 +, 500A +, 600ACE +, 800 A	F X 2	13mm/6mm
BOSCH	GOF900ACE , 1300A	H X 3	13mm/6mm
CASALS	FT750 , 1000E	F X 3	13mm/6mm
CASALS	FT2000E	G X 3	13mm/6mm
CHAMPION	CPR850	G X 2	13mm/6mm
CK LEKTRO	LRT700 +	F X 2	13mm/6mm
DRAPER	R850V	G X 2	13mm/6mm
DRAPER	R1900V	G X 3	13mm/6mm
EINHELL	EOF850SP	G X 2	13mm/6mm
ELU	MOF96(E) MK1	G X 2	13mm/6mm
FAITHFUL	FPPR2000E	G X 3	13mm/6mm
FELISATTI	TP246(E)	G X 3	13mm/6mm
FERM	FBF-6E , FBF-8E	G X 2	13mm/6mm



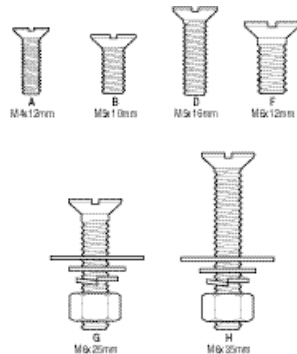
Make	Router Model	Screw x Qty	Csk / Hole Ø
FESTO	OF900(E) , 1000(E) , 1010EB ,	G X 2	13mm/6mm
FESTO	OF2000(E)	H X 3	13mm/6mm
FREUD	FT1000E	F X 3	13mm/6mm
FREUD	FT2000(E)	G X 3	13mm/6mm
HITACHI	FM8 , ZK2008	G X 2	13mm/6mm
HITACHI	M8(V)	B X 4	10mm/5mm
HITACHI	TR12 , M12V , 125A	B X 4	10mm/4mm
HOLZHER	2335 , 2355 , 2356	G X 2	13mm/6mm
JCBP	P R	G X 2	13mm/6mm
KANGO	R8550S	G X 2	13mm/6mm
KRESS	FM6955	G X 2	13mm/6mm
LYNX	RT-800-A +	G X 2	13mm/6mm
MAFELL	LO50E , LO65E	G X 2	13mm/6mm
MAKITA	3620	D X 2	10mm/5mm
MAKITA	3612BR, 3612(C)	A X 4	9.5mm/4mm
METABO	OF528 , 1028 , OFE1229	G X 2	13mm/6mm
METABO	OF612, OFE1812	G X 3	13mm/6mm
MILWAUKEE	OFSE1000	G X 2	13mm/6mm
NUTOOL	NPT850	G X 2	13mm/6mm
NUTOOL	XP12	H X 3	13mm/6mm
PERLES	OF808(E) <1998	G X 2	13mm/6mm
PEUGEOT	DF55E , DEF570E	B X 2	10mm/5mm
POWER DEVIL	PDW5026 , 5027	G X 2	13mm/6mm
PERFORMANCE POWER	1020W	G X 2	13mm/6mm
PERFORMANCE PRO	CLM1250R	H X 3	13mm/6mm
POWERBASE	1020W	G X 2	13mm/6mm
RYOBI	RE120 , R150 , R15 , RE155K	D X 2	10mm/5mm
RYOBI	R600(N) , RE600(N) , 601 , R500	H X 3	13mm/6mm
SKIL	1835	G X 3	10mm/5mm
SKIL	1875U	G X 3	13mm/6mm
SPARKY	X52E	G X 2	13mm/6mm
STAYER	PR50V	G X 2	13mm/6mm
TRITON	TRB001	H X 3	13mm/6mm
VIRUTEX	FR77C , 78C , 66F	H X 2	13mm/6mm
WADKIN	R500	H X 3	13mm/6mm
WICKES	900W	G X 2	13mm/6mm

Re-drilling of router base by user required.
Re-drilling of insert plate by user required.
+ Packing piece 3mm thick required.



Do not mount any power tools not specified in this list.

Screw Selection



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Mounting the Router to the Insert Plate

The plate is pre-drilled for TBC routers, see previous chart. For other makes of router, re-drilling of the router base or insert plate will be required.

IMPORTANT:
Isolate the machine from the power supply before making any modifications.

Re-drilling Router Base only

Invert and stand your router onto a suitable surface.

Place the fixing plate, facing upwards, onto the base of your router.

Centralise the position of the fixing plate to the router.

Ensure that the holes you are about to drill in the base do not interfere with any of the features on the router or any webs or flanges in the casting of the router base. A slight turning of the plate may be required in order to avoid such obstructions.

Using a pencil, mark the centre of the hole positions onto the base.

Remove the plate and mark the centre of the holes with a centre punch.

Using a 6mm diameter drill bit, drill a hole at these marked points, ensuring that you do not drill into any features of the router.

If required, clean up the edges of the holes.

Re-drilling the Fixing Plate only

Remove the plastic base of the router. Alternatively, use a photocopy or an outline of the base.

Align the centre of the fixing plate to the router base and secure them together.

Using a centre punch, mark the centres of the holes.

Drill the required hole size with a suitable metal cutting drill bit. Best results will be obtained if your power drill is mounted in a drill stand.

Countersink the hole with a countersink bit to a depth so that the heads of the screws are slightly below the top surface. Clean off any burrs created.

Re-drilling both Fixing Plate and Router Base

Invert the router and lay the fixing plate onto the upturned base.

Clamp the fixing plate and router base together with two cramps.

With a 6mm diameter drill bit, depending on screw selection, drill two or three holes into the fixing plate and through the router base, spreading them to ensure that the weight will be evenly distributed. Also ensure that the drill bit will not foul any webs, flanges or fixtures on the router base.

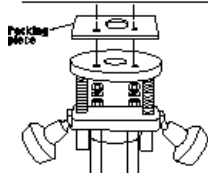
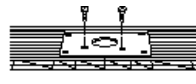
Unclamp the router base and fixing plate.

Countersink the fixing plate holes, with a countersink bit ensuring the screw heads are slightly below the top surface. Clean off any burrs created on both the fixing plate and router base.

For Bosch Routers

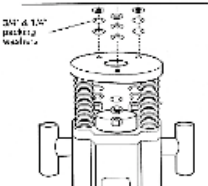
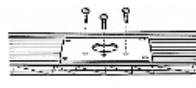
POF52, 400A, 500A and 600ACE require a 3mm thick plywood or MDF gasket to be made. This is then placed between the plate and the router base.

Bosch POF52, 400A, 500A & 600ACE



GOF900A and 1300ACE require nine 3/4"x1/4" packing washers (not supplied) to pack out the base of the router from the underside of the insert plate.

Bosch GOF900A & 1300ACE



User Made Work Top

The worktop can be made from 30mm thick Medium Density Fibreboard (MDF) or other similar material. The minimum thickness of board should be 18mm. The suggested dimensions of the worktop can be seen on the drawing opposite.

Marking out of Board

Mark centre lines onto the underside of the board and offset it to one edge. The cross lines will denote the centre of the cutter. Lay the insert plate onto the board and centralise the hole in the plate with the centre line drawn on the board. Using the plate as a template draw around it with a pencil. Mark the centre of the circle. Set a pair of compasses (or measure) a radius of 93mm and draw a second circle on the worktop.

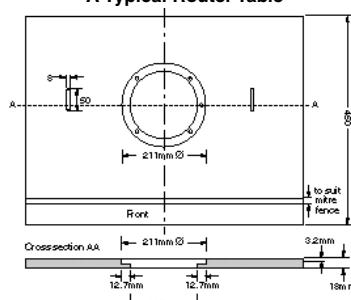
Routing the Plate Recess

Fit the router with a straight cutter, with a diameter of approximately 9.5mm and a cut length longer than the worktop thickness. Secure the worktop onto the workbench. This should also be fitted with a sacrificial work surface. Use double-sided sticky tape Ref. DS/TAPE below the middle portion of the worktop to hold the disk which is being routed. Fit a circle/beam trammel attachment to the router and set the radius so that the cutter edge lines up with the smaller circle drawn on the worktop (to cut a circle radius 93mm). Rout the circle in a series of passes until the inner disk can be removed.

Fit a bearing guided rebate cutter fitted with a ball bearing to allow a 12.7mm (1/2") rebate width. Set the depth of cut to 3.0mm and rout out the rebate. Test fit the round insert plate into the stepped hole. The plate will be slightly proud of the top surface, set the depth to 3.2mm and rout again. The plate should now be flush. Adjust if necessary, using a shim or by routing slightly deeper.

The plate should be positioned with the lead-on-pin, threaded hole at the right hand side (3 o'clock position). Mark the positions of the four fixing holes and drill a pilot hole. Secure the plate with four No. 8 x 1/2" countersink particle board screws.

A Typical Router Table



A plate levelling kit is available (Ref. CPL/KIT), which will make the levelling of the plate to the worktop easier.

Technical Data

Plate size:	210mmØ x 3.2mm
Insert ring dia.	20mmØ, 30mmØ, 40mmØ
Aperture size:	54mmØ
Cutter dia. max.	50mm

IMPORTANT:
The plate must be used in conjunction with a back fence, safety guard, finger pressures, dust extraction and No-Volt Release Switch. A pushstick is also strongly recommended.

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.
10. A No-Volt Release Switch should also be fitted to router tables.
11. A Lead-on-pin Ref. SPL/02 should be used when using bearing guided cutters on curved work.

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