



6.35mm (QUARTER INCH)
550W ROUTER
TT/R635



trend[®]
routing technology

WARNING

Read the instructions
before operating the tool.



TT/R635

Dear Customer

Thank you for purchasing this T-TECH™ product, we hope you enjoy many years of creative and productive use.

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TECHNICAL DATA

Voltage:	UK & Eire	240V
Power input		550W
No load speed		8000-32000 min-1
Router carriage		2 columns
Router carriage stroke		35mm
Revolver depth stop		3-step turret stop adjustment with graduation
Collet size		6.35mm (1/4") 6mm & 8mm
Cutter diameter max.		30mm
Weight		2.4kg
Fuse:	UK & Eire	240V 13A in plug

The following symbols are used throughout this manual:



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



Denotes risk of electric shock.



If you require further technical information, please call our Technical Hotline 01923 224681.

SAFETY INSTRUCTIONS



WARNING!

When using electric tools, basic safety precautions should always be followed to reduce the risk of fire, electric shock, and personal injury, including the following.

Read all these instructions before attempting to operate this product and save these instructions for future use.

For safe operation please keep these instructions safe.

- **Keep work area clean**
Cluttered areas and benches invite injuries.
- **Consider work area environment**
Don't expose power tools to rain. Don't use power tools in damp or wet locations. Keep work area well lit. Do not use tool in presence of flammable liquids or gases.
- **Guard against electric shock**
Prevent body contact with grounded surfaces. For example: pipes, radiators, ranges and refrigerator enclosures. When using the machine outdoors or when moisture or dust could enter the machine, we recommend adding a residual current operated device (FI, RCD, PRCD), with a release current of max. 30mA.
- **Keep children and visitors away**
Do not let visitors contact tool or extension cord. All visitors should be kept away from work area.
- **Store idle tools**
When not in use, tools should be stored in a dry and high or locked-up place - out of reach of children.
- **Do not force tool**
It will do the job better and safer at the rate for which it was intended.
- **Use right tool**
Do not force small tool or attachment, to do the job of a heavy-duty tool. Don't use tool for purposes not intended. For example, don't use circular saw for cutting tree limbs or logs.
- **Dress properly**
Do not wear loose clothing or jewellery. They can be caught in moving parts. Rubber gloves and non-skid footwear is recommended when working outdoors. Wear protective hair covering to contain long hair.
- **Use safety glasses**
Also use face or dust mask if cutting operation is dusty.

- **Do not abuse cable**
Never carry tool by cord or yank it to disconnect from the socket. Keep cord from heat, oil and sharp edges.
- **Secure work**
Use clamps or a vice to hold work. It is safer than using your hand and it frees both hands to operate tool.
- **Do not over-reach**
Keep proper footing and balance at all times.
- **Use both handles**
If the tool is provided with two handles, use both hands for best control and safety.
- **Maintain tools with care**
Keep tools sharp and clean for better and safer performance. Follow instructions for lubricating and changing accessories. Inspect tool cords periodically and if damaged, have repaired by an authorised service facility. Inspect extension cords periodically and replace if damaged. Keep handles dry, clean and free from oil and grease.
- **Disconnect tools**
When not in use, before servicing, and when changing accessories, such as blades, bits and cutters etc.
- **Remove adjusting keys and spanners**
Form the habit of checking to see that keys and adjusting spanners are removed from tool before turning it on.
- **Avoid unintentional starting**
Don't carry plugged-in tool with your finger on switch. Be sure switch is off when plugging in.
- **Outdoor use extension cords**
When tool is used outdoors, use only extension cords intended for use outdoors and so marked.
- **Stay alert**
Watch what you are doing. Use common sense. Do not operate tool when you are tired.
- **Check damaged parts**
Before further use of the tool, a guard or other part that is damaged should be carefully checked to determine that it will operate properly and perform its intended function. Check for alignment of moving parts, binding or moving parts, breakage of parts, mounting and any other conditions that may affect its operation. A guard or other part that is damaged should be properly repaired or replaced by an Authorised Service Agent,

unless otherwise indicated elsewhere in this instruction manual. Have defective switches replaced by an Authorised Service Agent. Do not use tool if it cannot be turned on and off by the switch. If the tool has been dropped or otherwise subjected to high impact, damage may have occurred which is not always visible. For optimum safety, have the tool checked by an Authorised Service Agent before re-use.

- **Connect dust extraction equipment**
If devices are provided for the connection of dust extraction and collection facilities ensure these are connected and properly used.
- **Warning**
Use the tool accessories and tool bits etc, in accordance with these instructions and in the manner intended for the particular type of tool, taking into account the working conditions and the work to be performed. Use of the tool for operations different from that normally expected to be performed for the particular tool, could result in a hazardous situation.
- **Tool repairing by expert only**
This electric tool is in accordance with the relevant safety rules. Repairing of electric tools may be carried out only by experts, otherwise it may cause considerable danger for the user.

Routing Safety

- Personal Protective Equipment (PPE). All PPE must meet current UK and EU legislation.
- Do not leave tools running unattended. Do not leave tool until it comes to a complete stop.
- Always clamp workpiece being machined securely.
- Only use cutting tools for woodworking that meet EN847-1/2 safety standards, and any subsequent amendments.
- Disconnect router power tool. When not in use, before servicing and when changing accessories such as cutters, disconnect router and attachment from power supply.
- Ensure router cutter has stopped rotating before changing it. Never use the spindle lock as a brake.
- Remove adjusting keys and spanners. Form the habit of checking to see that keys and adjusting spanners are removed from the router tool, cutter and attachment before turning router on. Make sure cutter can rotate freely.



SAFETY INSTRUCTIONS

- Check all ball bearing and blade fixing screws before use to ensure they are tight and secure. Periodically check when machining over long periods.
 - When using a template guide bush ensure it cannot come into contact with collet and nut.
 - Noise. Take appropriate measures for the protection of hearing if the sound pressure of 85dB(A) is exceeded. Routing sound pressure may exceed 85dB(A), so ear protection must be worn.
 - Eye protection. Wear safety goggles, spectacles or visors to protect the eyes from ejected waste particles.
 - Respiratory protection. Wear a face or dust mask, or powered respirator. Dust masks/filters should be changed regularly.
 - Do not switch router on with the cutter touching the workpiece.
 - The direction of routing must always be opposite to the cutter's direction of rotation.
 - After work, release the router plunge and allow spindle to stop rotating before putting machine down.
 - Check before cutting that there are no obstructions in the path of the router. When cutting through the full thickness of the workpiece, ensure there are no obstacles beneath workpiece, and that a sacrificial work surface is used.
- Never use cutters with a diameter exceeding the maximum diameter indicated in the technical data of the power tool or attachment used.
 - Do not drop cutters or knock them against hard objects. Do not use cutters that are damaged.
 - Cutters should be kept clean. Resin build up should be removed at regular intervals. The use of a dry lubricant will act as a preventative. Do not use PTFE spray on plastic parts.
 - Cutter shanks should be inserted into the collet to the mark line on the shank. This ensures that at least $\frac{2}{3}$ of the shank length is held in the collet. Do not over-tighten the collet nut as this will score the shank and create a weakness and fracture point.
 - Observe the correct assembly instructions in the router instruction manual for fitting the collet and nut. Observe the router power tool manual instructions on fitting cutters correctly.
 - It is advisable to periodically check the collet and collet nut. A worn, distorted or damaged collet can cause vibration and damage the shank, and should be replaced. Worn collet nuts should be replaced.
 - Do not take deep cuts in one pass; take several shallow or light passes to reduce the side load applied to the cutter. Too deep a cut in one pass can stall the router.
 - Very small diameter cutters must be handled and used with care.
- Ensure attachment is securely fitted to the workbench, with table surface at approximately hip height.
 - Ensure a No-Volt Release Switch is fixed to or adjacent to the attachment and that it is used correctly.
 - Check the direction of the workpiece is always opposite to the cutter's direction of rotation.
 - Do not use awkward or uncomfortable hand positions.
 - Do not reach underneath table or put your hands or fingers at any time in the cutting path while tool is connected to a power supply.

Useful Advice When Routing

- Judge your feed rate by the sound of the motor. Feed the router at a constant feed rate. Too slow a feed rate will result in burning.
- Take many light passes rather than one deep cut to reduce the side load applied to both router and router cutter.
- Trial cuts should be made on waste material before starting any project.
- When using some attachments including a router table or dovetail jig, the use of a fine height adjuster is highly recommended.
- When using a template guide bush, ensure there is sufficient clearance between cutter tip and inside edge of bush. Ensure cutter and guide bush are concentric.

Additional Safety Rules For Router Cutters

- Cutting tools are sharp. Care should be taken when handling them.
- Always use cutters with a shank diameter corresponding to the size of the collet installed in your tool.
- Always run router cutters at the spindle speed recommended and marked accordingly. Ensure cutter has reached correct speed before entering workpiece. Recommended speeds can be found on the packaging or cutter instructions.
- Always use router cutters in a router. Router cutters must not be used in a drill. Drill and boring bits must not be used in a router. Router cutters must only be used for the material cutting application for which they are designed. Do not use on metal or masonry.

- Always return cutter to its packaging after use.
- Should you experience excessive vibration during use stop immediately. Have the eccentricity of the router, router cutter and clamping system checked.
- All fastening screws and nuts should be tightened using the appropriate spanner or key in accordance with the manufacturers instructions.

Using Routers In A Fixed Position

- After work, release the router plunge to protect the cutter.
- Always use a push-stick or push-block for last 300mm of the cut.
- Whenever possible use a work holding device or jig to secure component being machined.

Router Cutter Maintenance

- Composite cutting tools (brazed tip) must be maintained by a competent person i.e. a person of training and experience, who has knowledge of the design requirements and understands the levels of safety to be achieved.
- The design of composite tools must not be changed in the process of maintenance.
- Replacement parts must meet manufacturer's specification.
- Tolerances which ensure correct clamping by the collet shall be maintained.
- When re-grinding the tool, care must be taken not to cause weakening of the body or the connection between the cutting edge and the body.

ELECTRICAL SAFETY



Power Supply

The electric motor has been designed for one voltage only. Always check that the power supply corresponds to the voltage on the rating plate. Machines marked for 230 volt can also be operated from a 220 volt supply.



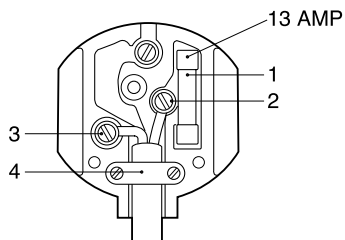
The router is double insulated in accordance with EN 50144; therefore no earth wire is required.

Mains Plug Replacement (UK & Ireland only)

Always check the condition of the cable and plug before starting with your work.

Should your mains plug need replacing and you are competent to do this, proceed as instructed below. If you are in doubt, contact an authorised service agent or a qualified electrician.

- Disconnect the plug from the supply.
- Cut off the plug and dispose of it safely; a plug with bared copper conductors is dangerous if engaged in a live socket outlet.
- Only fit 13 Amperes BS 1363A approved plugs fitted with a 13 Amp BS 1362 fuse (1).
- The cable wire colours, or a letter, will be marked at the connection points of most good quality plugs. Attach the wires to their respective points in the plug (see below). Brown is for Live (L) (2) and Blue is for Neutral (N) (3).
- Before replacing the top cover of the mains plug ensure that the cable restraint (4) is holding the outer sheath of the cable firmly and that the two leads are correctly fixed at the terminal screws.



Never use a light socket. Never connect the live (L) or neutral (N) wires to the earth pin marked E or ⚡.

Using an Extension Cable

- If an extension cable is required, use an approved triple core extension cable suitable for the power input of this tool (see technical data).
- When using a cable reel, always unwind the cable completely.
- Also refer to the table below.

Cable Rating (Amperes)

Cable Length (M)	Voltage 240V	
	7.5	6A
15	6A	
25	6A	
30	6A	
45	10A	
60	15A	

Conductor size (mm ²)	Cable rating (Amperes)
0.75	6
1.00	10
1.50	15
2.50	20
4.00	25

**MANUFACTURERS
DECLARATION**


We declare under our sole responsibility that this product is in conformity with the following standards of standardised documents:

EN 50144.1, EN 50144.2.17, EN 55014.1, EN 55014.2, EN 61000.3.2, EN 61000.3.3 in accordance with the directives 98/37/EC, 73/23/EEC, 93/68/EEC, 89/336/EEC.

Level of sound pressure according to 86/188/EEC & 98/37/EC, measured according to EN 50144:

Lpa (sound pressure) 81.3 dB(A)₁
 Lwa (acoustic power) 94.3 dB(A)₂


**INFORMATION ON
NOISE/VIBRATION**

The noise level when working can exceed 85 dB(A).

Wear ear protection!

Weighted root mean square acceleration value according to EN 50144:

>4.0 m/s²

ITEMS ENCLOSED

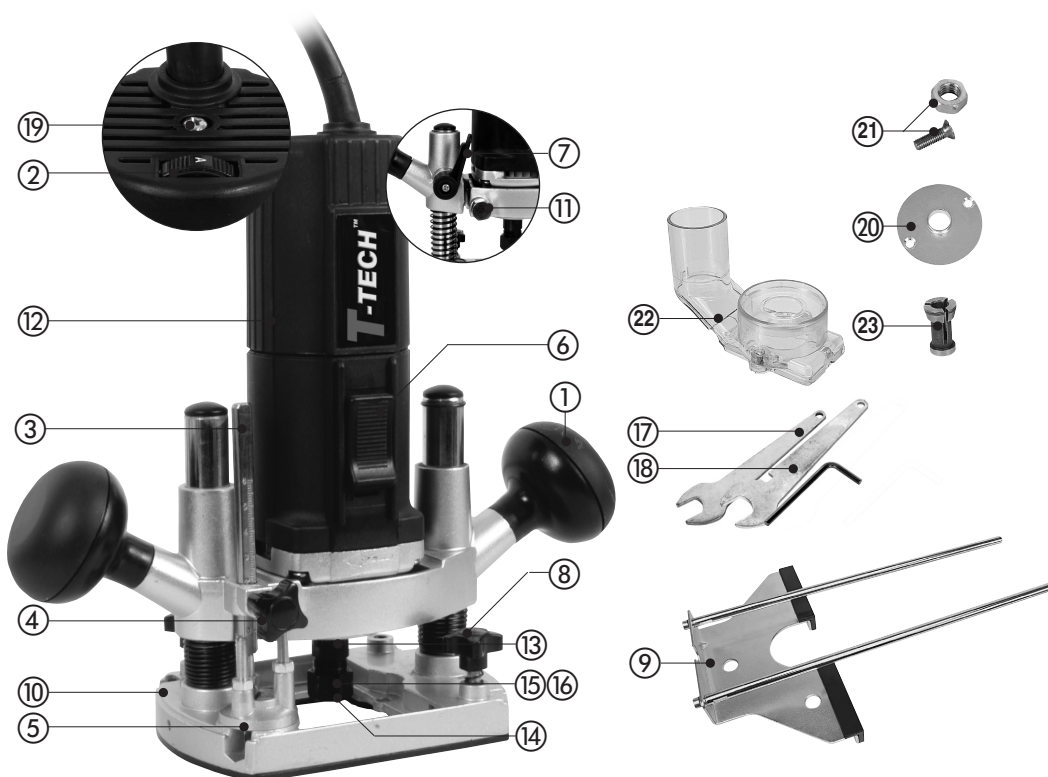
- 1 x Parallel side-fence
- 2 x Side-fence rods
- 1 x Collet 6mm
- 1 x Collet 6.35mm (1/4") fitted to machine
- 1 x Collet 8mm
- 1 x Guide bush 16mm and screws
- 1 x Spanner (17mm A/F) for collet nut
- 1 x Spanner (15mm A/F) for spindle
- 1 x Hex key (4mm A/F) for side-fence
- 1 x Dust extractor spout
- 1 x Instructions

SJ Phillips Managing Director
 Stephen Phillips

Trend Machinery & Cutting Tools Ltd.

DESCRIPTION OF PARTS

- | | |
|-------------------------------------|--|
| ① Handle (x2) | ⑫ Motor housing |
| ② Speed control | ⑬ Spindle |
| ③ Depth stop | ⑭ Collet |
| ④ Depth stop locking knob | ⑮ Collet nut |
| ⑤ Depth limiting 3-way turret stop | ⑯ Collet spring (fitted behind collet) |
| ⑥ On/Off switch | ⑰ Spanner (15mm A/F) for spindle |
| ⑦ Plunge lock lever | ⑱ Spanner (17mm A/F) for collet nut |
| ⑧ Parallel side fence knobs | ⑲ Brush cover fixing screw |
| ⑨ Parallel side fence | ⑳ Template guide bush |
| ⑩ Router base | ㉑ Template guide bush fixing screw & nut |
| ⑪ Motor to base housing locking nut | ㉒ Dust extraction spout |
| | ㉓ Additional collets (6mm & 8mm) |



OPERATION



1. Handle

Always use both handles (1) and make sure that you have a firm grip on the router before proceeding with any work.

2. Speed Control

Adjust the speed control (2) to suit different working materials. The tool cuts quicker and smoother at different speeds when working in different woods or in plastic or aluminium.

Determine the optimum speed by making a trial cut in a scrap piece of material.



Using the correct speed for the job increases the life of the cutter.

Dial No.	Router Speed
A	8,000 rpm
B	12,000 rpm
C	16,000 rpm
D	20,500 rpm
E	24,000 rpm
F	28,000 rpm
G	32,000 rpm



These speeds are approximate values (within 20%) and are for reference purpose only.

3. Depth Stop

The depth stop (3) is used when setting the depth of cut. It has a scale with graduations in millimetres.



4. Depth Stop Locking Knob

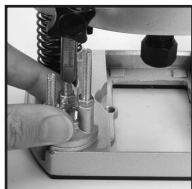
The knob (4) secures the depth stop (3) in position.



5. Depth Limiting 3-way Turret Stop

There are three screws on the depth limiting turret stop (5). By rotating the turret so that a different screw is directly under the depth stop (3), it is possible to quickly and easily set the depth of cut at three different values.

- Place the router on a flat surface, release plunge lock lever (7) and push the router body down until the cutter just touches the flat surface.
- Release the plunge lock lever.
- You can rotate the depth limiting 3-way turret stop (5) to set the depth of cut at a different value. This procedure is particularly useful when you wish to make a deep cut in a number of stages.



6. On/Off Switch

The on/off switch (6) is located on the motor housing (12).



- To switch on, press down on switch and slide down to lock.
- To switch off, depress top of switch and release.

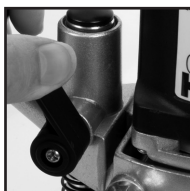


7. Plunge Lock Lever

The plunge lock lever (7) in its normal position allows the router to plunge.



- To lock plunge, depress lever.
- To release plunge, lift up lever.



8. Parallel Side Fence Knob

The parallel side fence

locking knobs (8) located on the router base (10) hold the parallel side fence (9) in position.

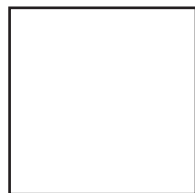


9. Parallel Side Fence

The parallel side fence (9) is an effective aid to cutting in a straight line when chamfering or grooving.



- Feed the guide rods through the holes in the router base on the right side of the router in the feed direction. This will help you to keep the guide flush with the side of the work piece.
- Adjust the distance between the cutter and the parallel side fence (9) by moving the guide.
- Tighten the knobs (8) to hold the guide in the correct position.



If the distance between the side of the workpiece and the cutting position is too wide, or the side of the work piece is not straight, firmly clamp a straight board to the work piece and use this as a guide against the router base.

10. Router Base

The router base plate (10) has additional drilled

Sequence of plunging

Step One

Plunge down and lock the motor carriage, with the plunge locking lever.

Step Two

Carry out the routing operation.

Step Three

Release the plunge locking lever and the motor carriage returns to the normal position.

and tapped holes to allow the attachment of various templates and accessories.

11. Motor to Base Housing Nut

Never separate the motor housing from the base while a cutter is fitted in the collet. Always disconnect the router from the power supply before separating the motor housing from the base.

- Use the 15mm A/F spanner (17) to release the base locking nut (11) on the base (10). Slacken the nut off until the motor housing slides out of the base (10).
- When re-fitting the motor housing ensure that the switch (6) is facing the front of the router so that it is accessible when plunge routing.
- Ensure that the base locking nut (11) is re-tightened before using the router for normal plunge cutting operations.

12. Motor Housing

The motor housing (12) when removed from the router base (10) allows the router to be used for carving and grinding.

Never use high speed router cutters for carving operations.

Always unplug the machine from the power supply before separating the router from its plunge base.

13. Spindle

The spindle (13) has an external thread which accepts the collet (14), collet spring (16) and collet nut (15).

14. Collet

The collet (14) is fitted into the spindle (13) by

the collet nut (15).

15. Collet Nut

The collet nut (15) attaches the collet (14) to the spindle. The router cutter is held secure by tightening the collet nut (15).

16. Collet Spring

This spring (16) enables the router cutter to be removed more easily.

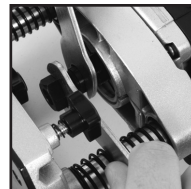
17 & 18. Spanners

Always ensure that the tool is switched off and the plug is removed from the power point before making any adjustments or maintenance procedures. Always wear sturdy gloves when handling or changing cutters as they can be very sharp.

To change cutters both the spanners are used:

Ensure that the correct collet (14) is installed for the cutter you are about to fit. Cutters with a 6.35mm shank fit into the 6.35mm collet, cutters with a 6mm shank fit into the 6mm collet & cutters with a 8mm shank fit into the 8mm collet.

- To remove a collet, first release the plunge lock lever (7) and ensure that the router body is in its highest position.
- Insert at least $\frac{3}{4}$ of the shank length of the cutter into the collet assembly (14 & 15).
- Place the 15mm A/F spanner (17) onto the flats on the spindle (13) to lock while tightening the collet nut (15) with the 17mm A/F spanner (18). Do not use excessive force.



⚠ Do not fully tighten the collet nut with the spanner unless there is a cutter in place or you may damage the collet.

⚠ Make sure that the cutter is firmly secured before commencing operation.

19. Brush Cover Fixing Screw

To gain access to the carbon brush and spring sets, unscrew the brush cover fixing screw (19). **⚠**

20. Template Guide Bush

The template guide (20) can be used in various ways:

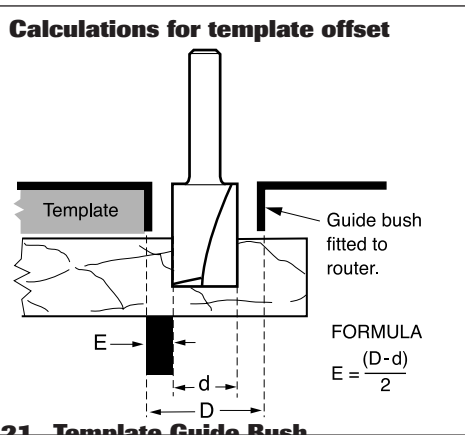
- Producing duplicates of a particular design of an original shape.
- In conjunction with a template, producing decorative features.
- Repetitive cutting shapes.

If you wish to make your own templates it is best to use a hardwood such as plywood. Use a piece that is just thicker than the depth of the template guide. Allow for the thickness of the guide in your template to ensure that the work piece is cut to the correct size.

A cutter is chosen with a diameter which will pass through the centre of the bush leaving

enough clearance. The cutter can be straight or shaped. The router can then be guided around the template so that the shape of the template will be replicated.

The guide bush offset needs to be allowed for when calculating the shape of the template. The template must be smaller by an amount equal to the difference between the 'outer edge of the guide ring' and the 'outer edge of the cutter'. See below for the offset calculation. The edge of the template must be free of imperfections as these will be replicated in the final workpiece.

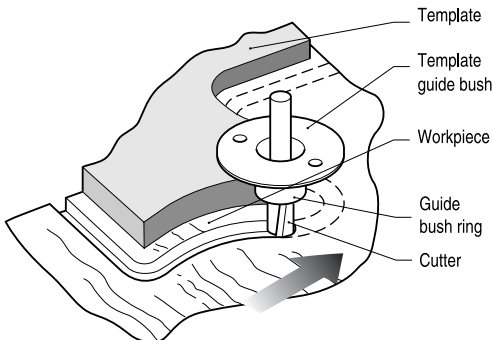


21. Template Guide Bush Fixing Screw & Nut

The template guide bush fixing screws and nuts (21) are used to secure the template guide bush (20) to the router base (10). **⚠**

22. Dust Extraction Spout

The dust extraction spout (22) allows a dust extraction system to be fitted to the router permitting the efficient removal of dust whilst the router is in use. The dust extraction spout (22) is fitted to the router base (10) using the two screws from the template guide bush fixing screw and nut set **⚠**



(21).



Do not use a dust extraction system or a vacuum cleaner when working on metal surfaces. Sparks may ignite residual wood dust.

23. Additional Collet

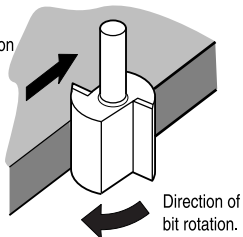
Three collets are provided with the router: a 6.35mm ($\frac{1}{4}$ "), a 6mm and an 8mm. At purchase, the 6.35mm collet is fitted to the router.



Do not fully tighten the collet nut with the spanner unless there is a cutter in place or you may damage the collet.

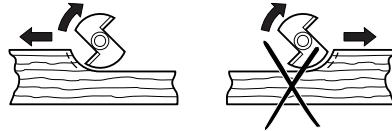
Cutting Direction

Feed direction of router.



The direction of routing must always be opposite to the cutter's direction of rotation, otherwise there is a risk of kick-back.

Feed Direction



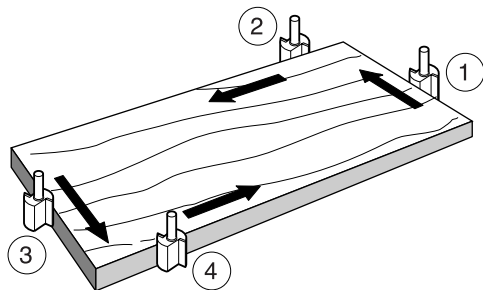
When routing along an edge, the direction of the router travel should be against that of the rotation of the cutter. This will create the correct cutting action and prevent the cutter 'snatching'. It will also pull the router towards the workpiece and hence the side-fence or guide bearing will be less likely to wander from the edge of the workpiece.

Feed Speed

The speed at which the cutter is fed into the wood must not be too fast that the motor slows down, or too slow that the cutter leaves burn marks on the face of the wood. Practice judging the speed by listening to the sound of the motor when routing.

Moulding Natural Timbers

When edge moulding natural timbers, always mould the end grain first, followed by the long grain. This ensures that if there is 'breakout', this will be removed when the long grain is routed.



MAINTENANCE AND CARE

Cleaning

- Keep the machine clean at all times. Wipe the outside clean with a dry cloth. Some maintenance products and solvents may damage the plastic parts, these include products containing Benzene, Trichloroethylene Chloride and Ammonia.
- Never use water to clean your power tool.
- Never use any caustic agents to clean the plastic parts.

Changing Brushes



Ensure machine is isolated from power supply.

Regularly check that the carbon brushes are not over worn and replace if necessary.

Proceed as follows:

- Unscrew the brush cover fixing screw (19) located at the end of the body of the motor housing. Slide vent housing off.
- Pull back the spring retaining clip. Take care not to bend or distort the coil spring.
- Disconnect the wire and remove the carbon brush.
- Insert the new brush and press the connector firmly on to the tag. Refit the vent.

Lubrication

- The bearings of the machine need no lubrication, as they are sealed. The two plunge columns on the routing base should be slightly oiled from time to time.
- Keep the cooling vents on the motor housing clean and unobstructed at all times. Use a soft brush or blow out any dust and dirt at regular intervals. Wear safety glasses to protect eyes whilst cleaning.
- Visually check the carbon brushes. In the event of excessive sparking, they may need changing.

RECYCLING

Machine, accessories and packaging should be sorted for environmentally friendly recycling.

GUARANTEE

This product has been made to demanding, high quality standards and is guaranteed for domestic use against manufacturing faults for a period of 12 months from the date of purchase.

This guarantee does not affect your statutory rights. If your product fails due to a defect in material or workmanship during this period, please return it to your nearest B&Q store.

Normal wear and tear, including accessory wear, is not covered under guarantee. The product is guaranteed for 12 months if used for normal trade purposes. Any guarantee is invalid if the product has been overloaded or subject to neglect, improper use or an attempted repair other than by an authorised agent. Heavy duty, daily professional or hire usage are not guaranteed. Due to continuous product improvement, we reserve the right to change the product specification without prior notice.





MANU/TT/R635 v1.0



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