



## Tongue & Groove Set C158



INST/C158 v6.1

**trend**<sup>®</sup>  
routing technology

Please read carefully before use

### TONGUE & GROOVE CUTTER SET REF. C158

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

In this box you will find one Tongue & Groove assembly and an adjustable shim set.

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 2006/42/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 tongue and groove joint in wood and MDF.

Material thickness: min. 15mm  
max. 18mm

#### 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.

Ensure working position is comfortable and component is clamped securely. Please keep children and visitors away from tools and work area. All tools have a residual risk, so must therefore be handled with caution.

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.
- Hand tools.
- 13mm A/F spanner.

#### ITEM ENCLOSED & DESCRIPTION OF PARTS

- A. Arbor **x1**
- B. Nut 13mm A/F **x1**
- C. Groover 41mm diameter, 6.3mm Kerf **x2**
- D. Bearing 22mm diameter **x1**
- E. Shim 0.5mm **x2**
- F. Washer 1.5mm **x3**
- G. Spacer 6mm **x1**
- H. Instructions **x1**

#### ASSEMBLY

The set is supplied in Tongue set up. However, remember to machine the groove first.

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

The ball bearing on each set up will automatically give the correct depth of cut.

When re-assembling follow the sequence of the two diagrams.

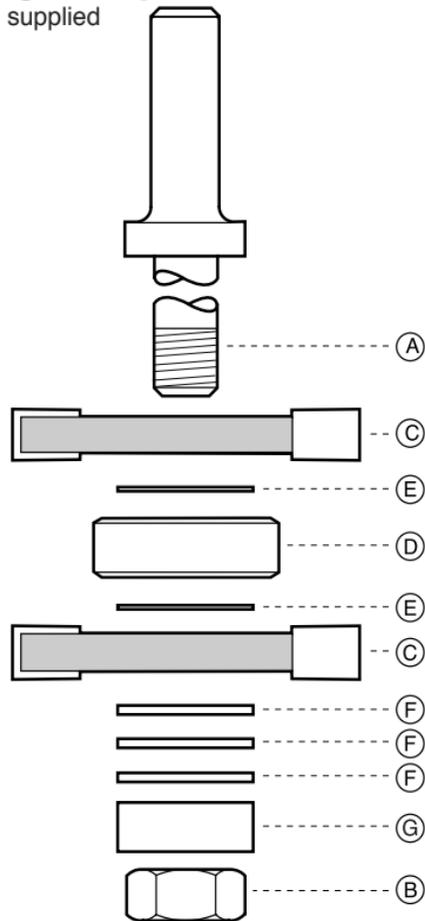
Ensure groovers are assembled the correct way round, i.e. to match the spindle rotation.



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.**

#### Tongue Set Up as supplied



P.T.O

#### 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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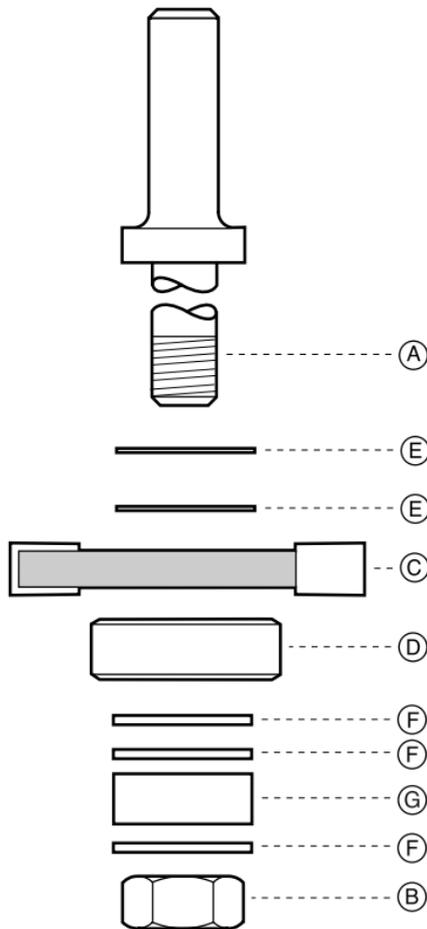


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RECYCLABLE

## Groove Set Up



## 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.



**Recommended speed is 18,000 rpm.**

## Cutting the Groove



Undo nut with a 13mm A/F spanner, remove all parts and reassemble as per the groove set up diagram. Set the cutter to the desired height against the timber (this will be dependant on the thickness of the timber).

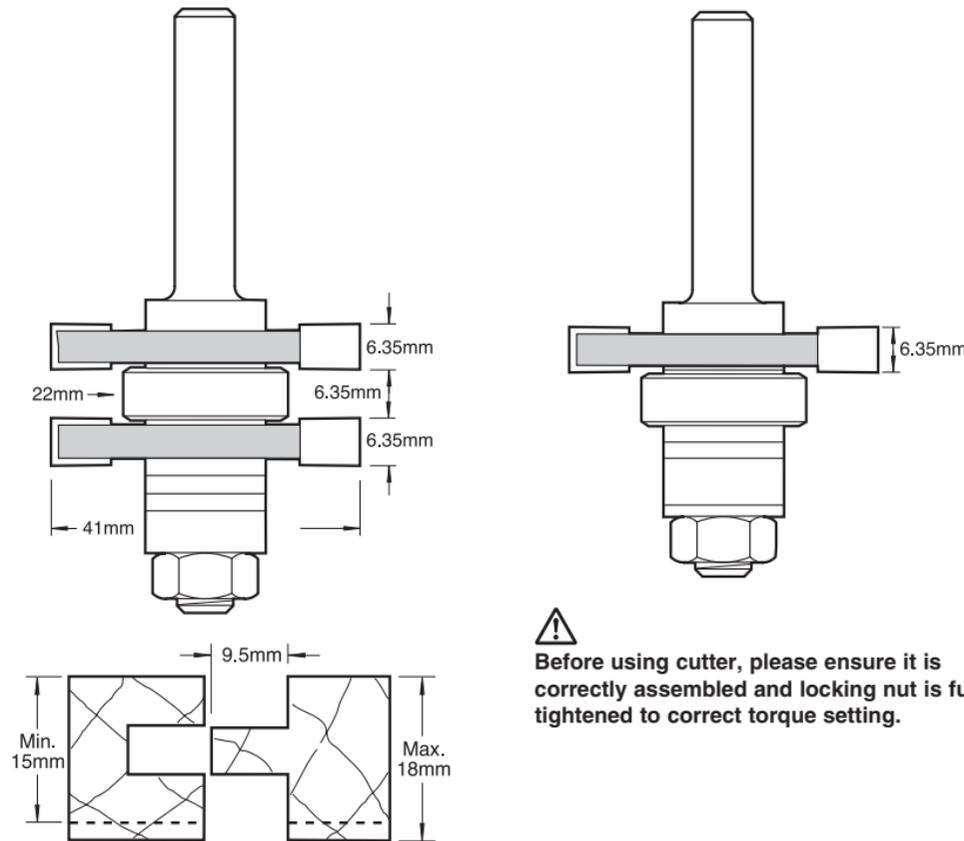
The bearing will automatically give the correct depth of cut. If a side fence is not used, a lead on piece will be required.

## Cutting the Tongue



Undo the nut with a 13mm A/F spanner, remove all parts and reassemble as per the tongue set up diagram. Groovers C should be at 90° to each other to reduce the cutting impact. The height of the cutter will need to be adjusted to match the groove.

The joint produced will be slightly loose to allow for ease of assembly of the finished joint. For a tight joint extra shims E should be added either side of the bearing in the tongue set up.



Tongue & groove joint showing minimum and maximum possible timber thickness.



**Before using cutter, please ensure it is correctly assembled and locking nut is fully tightened to correct torque setting.**

## SPARE PARTS

Please use only Trend original spare parts and accessories.

Item	Qty.	Desc.	Ref. (1 off)
A	1	Arbor 1/4" shank	33/30X1/4"
		Arbor 8mm shank	33/30X8MM
B	1	Replacement arbor nut	ANUT/33/30
C	2	Groover 6.3mm Kerf	SP-C149C
D	2	Bearing 22mm dia.	SP-C149C
F	1	Spacer set	SPACER/8
G	1	Instructions	INST/C158

## 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

Always 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 (n<sub>max</sub>) 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.
- Do not take deep cuts in one pass, take shallow passes to reduce the side load applied to the cutter.

Please see [www.trend-uk.com/safety](http://www.trend-uk.com/safety) for more safety advice.



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