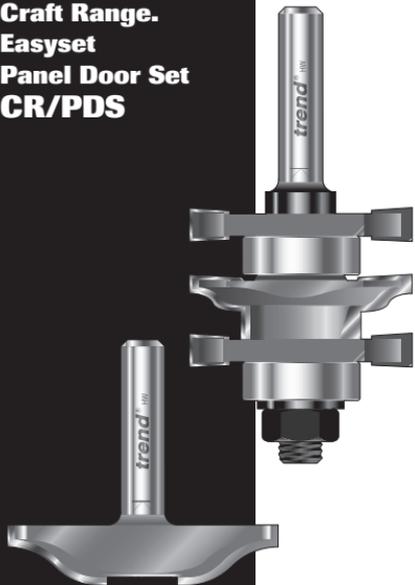




**Craft Range.  
Easyset  
Panel Door Set  
CR/PDS**



INST/CR/PDS v3.1

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

Please read carefully before use

**PANEL DOOR SET  
REF. CR/PDS**

Thank you for purchasing this Trend router cutter, 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.

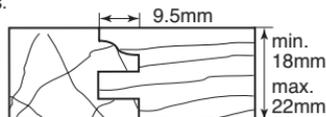


Refer to the instruction manual of your power tool.

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 2006/42/EC (identified by the CE marking on the power tool).

**INTENDED USE**

This cutter set is intended to be used in a router with suitable collet fitted to cut natural timbers to create a panelled door. The router should be in a fixed head position, either in an overhead or in a table routing machine, or in a portable router mounted in a fixed mode. The router should have a minimum power rating of 750 watts.



When using the minimum material thickness, the height of the top guide may be reduced.

**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 therefore must be handled with caution.

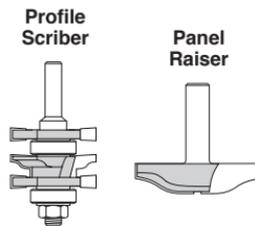
Attention should be made to the HSE's Safe Use of Vertical Spindle Moulding machines Information Sheet No. 18 and any revisions.

**ITEMS REQUIRED**

- Router with suitable collet fitted.
- Router table.
- Hand tools.
- Jig making equipment & materials.
- Workholder.

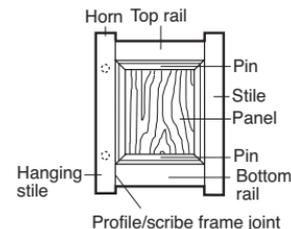
**Before use of cutter, please ensure it is correctly assembled and locking nut or screw is fully tightened.**

**ITEMS ENCLOSED**

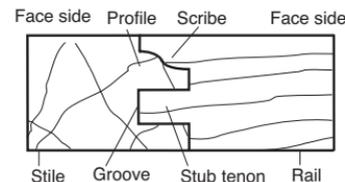


**FRAME & PANEL DOOR**

**Parts of a Panelled Door**



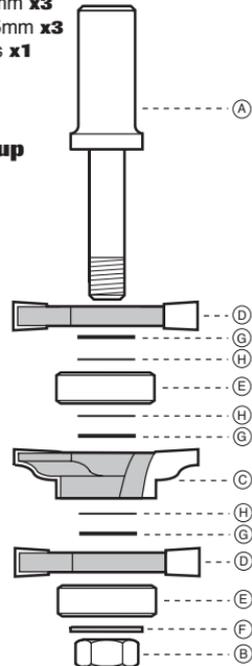
**Profile/Scribe Frame Joint**



**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**

**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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RECYCLABLE

PTO

## 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. Ensure at least 3/4 of the shank length is held in the collet.

When using these sets, shallow passes must be taken at all times. This can be achieved by adjusting the back fence on the table. The final cut using the ball bearing as a guide.

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

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 Profile Scriber cutter is supplied when purchased with all the cutting edges in line, the parts C & D should be assembled 90° to each other to reduce cutting impact.



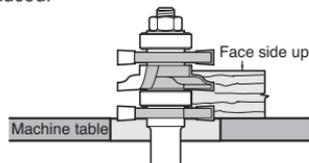
When using stacked tooling (multi-blade, block, groover etc) on a spindle arbor, ensure that the cutting edges are staggered to each other to reduce the cutting impacts. NOTE: Diagrams show cutting edge not staggered for clarity.

## Cutting the Scribe

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.

When using at the minimum material thickness, the height of the top quirk may be reduced.



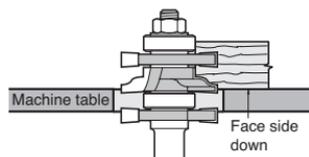
A workholder device should be used when cutting the scribe cut on the rail ends.



Recommended speeds are as follows:  
Profile Scriber - 18,000 rpm  
Panel Raiser 50mmØ - 18,000 rpm  
Panel Raiser 86mmØ - 12,000 rpm

## Cutting the Profile

When the scribes on the ends of the rails have been cut, lower the height of the cutter so that the groover, ball bearing and cutter which is nearest the nut 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.



Diagrams show guards removed for clarity.



Always take a number of passes to improve finish and to ensure longer cutter life.

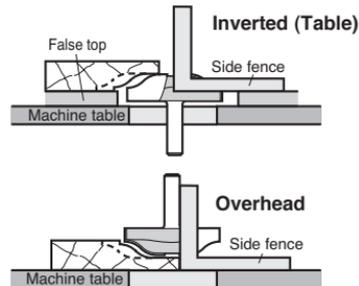


Always feed timber against the direction of cutter rotation.

## Producing the Panel

### CR/PDS1

The panel raiser cutter supplied in CR/PDS1 is not fitted with a guide bearing. A back 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.



The length of the tongue on the CR/PDS1 can be increased by altering the side-fence position prior to a second pass.

### CR/PDS2 & CR/PDS3

For sets CR/PDS2 & CR/PDS3 the panel raiser cutter has a bearing guide which will automatically give the current depth of cut. Take a number of shallow passes to reduce cutter load.



If the panel cutter will not fit through your table, a false top made from MDF will be required to achieve the correct depth.

## SPARE PARTS

Please use only Trend original spare parts and accessories.

Item	Qty.	Desc.	Ref. (1 off)
C	1	Profile Block	SP-C149A
D	1	Groover	SP-C149C
E	2	Bearing 22mmØ	BB22
A	1	Replacement Arbor	33/31X8MM 33/31X1/2
B	1	Replacement Arbor Nut	ANUT/33/30
	1	Spacer Set	SPACER/8
I	1	Instructions	INST/CR/PDS

## MAINTENANCE

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

### Cleaning

- Ensure clamping surfaces are cleaned to remove dirt, grease, oil and water.
- 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 to increase cutting edge life.

### Storage

- Always return cutter to its packaging after use.

## Safety Points

1. 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.
  2. Read and understand instructions supplied with power tool, attachment and cutter.
  3. Current Personal Protective Equipment (PPE) for eye, ear and respiratory protection must be worn. Keep hands, hair and clothes clear of the cutter.
  4. 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.
  5. The maximum speed (nmax) marked on tool or in instructions or on packaging shall not be exceeded. Where stated, the speed range should be adhered to.
  6. 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.
  7. 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.
  8. Ensure all visors, guards and dust extraction is fitted.
  9. The direction of routing must always be opposite to the cutter's direction of rotation.
  10. Do not switch power tool on with the cutter touching the workpiece.
  11. Trial cuts should be made in waste material before starting any project.
  12. Repair of tools is only allowed according to tool manufacturers instructions.
  13. 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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