



## Replaceable Tip Rotatip



INST/ROTA v6

# trend<sup>®</sup>

routing technology

Please read carefully before use

### REPLACEABLE TIP ROUTER CUTTERS

#### REF. 46/01, 46/02 & RT

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

The router cutter is intended to be used in a routing machine to rout wood and wood based material.

Replaceable tip cutters are very economical for use in production applications. The tungsten blades are rotated to expose a new cutting edge ensuring the diameter of the tool remains constant.

#### 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.

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

Please keep children away from tools and work area. All power tools will have a residual risk, so must therefore be operated with caution.

#### ITEMS REQUIRED

- Router with suitable collet fitted.
- Router table or overhead router stand.
- Hand tools.

#### 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.

To obtain the best possible performance from this tool, please follow the instructions:

1. Blades are fitted directly onto the tool body without removing the cutter from the router,

reducing downtime to a minimum.

2. Torx<sup>®</sup> screws are used to hold the blades onto the tool body, except for 46/01 which uses a grub screw.
3. The tool shank should be inserted at least 3/4 of its length into the collet of the routing machine to prevent distortion or stress. Ensure the web between the shank and the head of the cutter is not in contact with the collet.
4. Careful setting up and trial cuts with the tool on waste pieces of material should be made first for familiarity with its cutting characteristics before any production run is attempted.
5. Ensure the correct spindle speed (RPM) and feed rate of the machine is set for the particular size and design of tool being used. This will extend tool life and give a better quality of finish on the material.
6. Do not over-tighten the collet nut as this may score the shank preventing the collet from holding the cutter correctly.
7. Check the routing machine collet and collet nut regularly for signs of wear and replace if necessary. A distorted collet should be discarded as it can damage the tool shank.
8. The tool will periodically need cleaning to remove build up of resin etc. Tooling should only be cleaned with a cellulose thinner or other solvent cleaners e.g. Trend Resin Buster. The use of dry lubricant will prevent resin build up. We recommend Trendcote PTFE spray for this purpose.

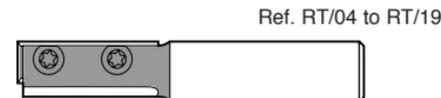
9. Cover the steel bed of the machine when removing the tool so that if the tool is dropped the possibility of damage is minimised.
10. When replacing blades, please ensure they are placed into the correct seating of the tool body.
11. Ensure the body or slot is free of debris and/or burrs, as this may cause fracture of the blade.
12. Ensure fixing screw is tight. Do not over-tighten.



**Before use of cutter, please ensure it is correctly assembled. Check the locking screws are fully tightened. Recommended speed 24,000 rpm.**

#### Single Blade

- The single blade can be rotated 180° to give double the life of a converted tool.
- Ref. RT/11M with a shorter shank is designed for use with Makita, Ryobi and Hitachi routers.
- Ref. RT/15, 16 and 17 are suitable for fixed head machines only.
- Suitable for plunge cutting.



PTO

### 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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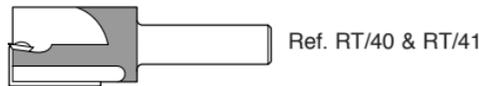
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RECYCLABLE

## Single Blade with Extra Replaceable Plunge Blade

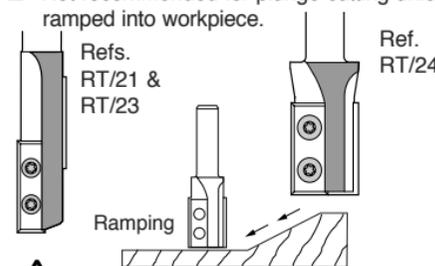
- Features one replaceable Solid Carbide blade and one Solid Carbide plunge blade.
- Suitable for fixed head machines only.
- Suitable for plunge cutting.



Ref. RT/40 & RT/41

## Two Blades

- RT/21 & RT/23 are used for rough cutting only and have staggered blades.
- RT/24 should be used in fixed head machines only.
- Not recommended for plunge cutting unless ramped into workpiece.



Refs. RT/21 & RT/23

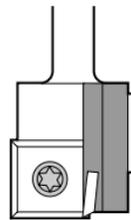
Ref. RT/24

Ensure working position is comfortable and component is clamped securely.

Consider working environment before using tools.

## Two Blades (Staggered with Plunge Tip)

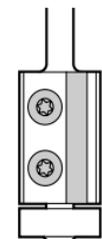
- Plunge tool with a TC tip brazed into nose.



Ref. RT/50

## Trimmers and Engravers

- Trimming of laminates and veneered materials.



Ref. 46/03



Ref. RT/60  
Flush trimmer of hardwood lipping



Ref. RT/31  
Bevel trimmer



Ref. RT/70  
Guided profile



Ref. RT/80  
Unguided V groover engraver

## SPARE PARTS

Please use only Trend original spare parts.

Please see the website for full range of spare blades.

				RT/04, 05, 06, 10 - 11(M) & 21	RT/12(M) & 14	RT/13	RT/07, 08, 15 - 19	RT/23 & 24	46/01	46/02	46/03	RT/30, 31 & 32	RT/33	RT/39	RT/40 & 41	RT/50, 51 & 60	RT/70	RT/80	
Order Ref.	Description																		
<b>Key</b> Gives positive & quick action to help prevent overtightening & to allow quick tightening of screw.																			
RT/KEY	Torx® T15																		
RT/KEY/15	Hex 1.5mm A/F																		
<b>Screw</b> Always use our replacement screws if those supplied with the tool are lost or need replacement.																			
RT/3.5	M3.5 x 5mm, 6.0mm head dia. Torx®																		
RT/3.5A	M3.5 x 5mm, 6.0mm dome head dia. Torx®																		
SP-46/02D	M4 x 5.5mm, 8.0mm head dia. Torx®																		
SP-46/01D	M3 x 5mm set screw hex																		
<b>Ball Bearing</b> Precision ball bearings to replace those worn or damaged.																			
B19H	OD 19.0mm	ID 6.0mm																	
B19C	19.1mm	12.7mm																	
B16	15.9mm	6.35mm																	
B127	12.7mm	6.35mm																	
B127A	4.96mm	12.7mm																	
<b>Replaceable Blades</b> *Please note blades RB/A, RB/B, RB/C, RB/G & RB/H have bevelled ends for clearance and will therefore be approximately 0.5mm shorter on length.																			
RB/A*	L 30.0mm	W 9.0mm	T 1.5mm																
RB/B*	50.0mm	12.0mm	1.5mm																
RB/C*	30.0mm	12.0mm	1.5mm																
RB/D	7.5mm	12.0mm	1.5mm																
RB/E	12.0mm	12.0mm	1.5mm																
RB/F	30.0mm	12.0mm	1.5mm																
RB/G*	8.4mm	5.6mm	1.1mm																
RB/H*	50.0mm	9.0mm	1.5mm																



When replacing blades, please ensure they are placed into the correct seating of the tool body.

Ensure no burrs are enclosed in the tool body or slot as this can cause fracture to the blades.

Ensure the fixing screw is tight. Do not over-tighten.

## MAINTENANCE

Please use only Trend original spare parts and accessories.

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

- 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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