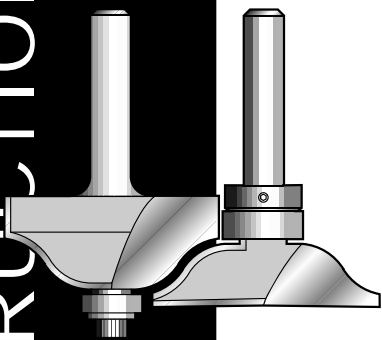


Please
read carefully
before use



Not all cutter sets are shown
INST/SSP v4.0

SHOULDER SCRIBE & PROFILE SET REF. SSP/1 to SSP/9

Thank you for purchasing this Trend router cutter set, which when used in accordance with these instructions, will produce all manner of scribed mortise and tenon joints for frames, doors and panels.

Both cutters can be used freehand in portable routers but preferably should be used in routers which are mounted in an overhead mode or are inverted in a table. It is beneficial for you to use the router in a stationary position because of the accuracy achieved, the ease of machining and to adhere to safe working practice.

The cutters can be used in any router which has a 1/4" collet and minimum output of 750 watts. The efficient cutting speed is between 20,000 and 24,000 rpm.

The cutter sets have been designed for use on 35mm and 44mm door and frame thicknesses:

Sets SSP/3, 4, 6 & 8 are for 35mm thickness.
Sets SSP/1, 2, 5, 7 & 9 are for 44mm thickness.

All cutter sets can be used for doors and windows.

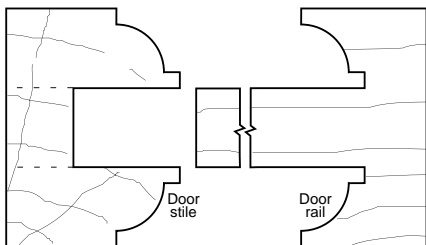
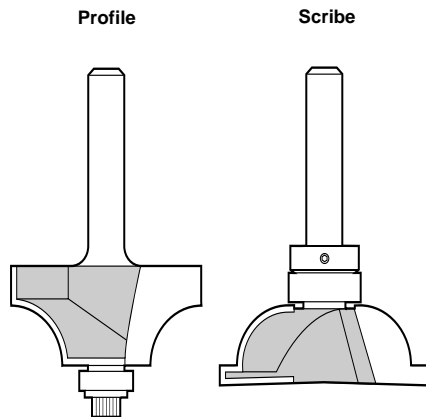
The sets are supplied assembled.

Please Note:
Before use of cutter please ensure it is correctly assembled and the locking screw is fully tightened.

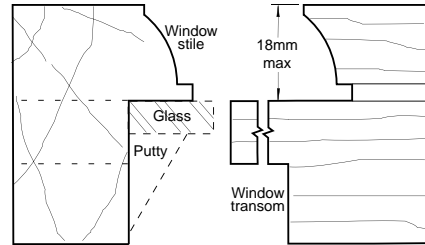
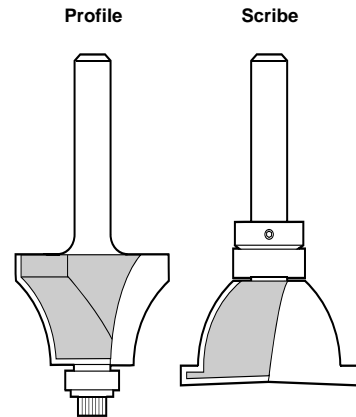
Supplied in set

1. Profile Cutter (x1)
2. Scribe Cutter (x1)

For doors



For windows



Joints possible to produce

The SSP Set has been designed for a number of mortise and tenon applications e.g. through tenon, haunched tenon, slip tenon, stub tenon and double tenon. To achieve the best results the tenon shoulder should not be less than 11mm or 15mm thick depending on whether a 35mm or 44mm thick frame is required.

These joints can be found in all manner of door and window construction, decorative panelling and a host of other joinery applications. Please read these instructions carefully before any marking out or machining.

Machining method

As with all good working practice, certain procedures should be followed to achieve safe and practical machining. The ideal machining method is as follows:

1. Prepare timber with a square face and edge, then plane remaining surfaces.
2. Mark out fully from the original drawing.
3. Machine all mortises.
4. Cut the shoulders on the tenons and remove the waste. Cut in any haunches where necessary.
5. When making solid doors or panels, machine the groove to take the fielded panels. When making window sashes and glazing panels, a rebate will be required for the glass.

In addition to the above you may have to prepare various jigs and templates to help construct the finished article, this maybe a Bull's Eye window, cathedral arch etc.

With 1 - 5 complete, you are now ready to use the shoulder scribe set, remember to use the scribe cutter first and the profile cutter second.

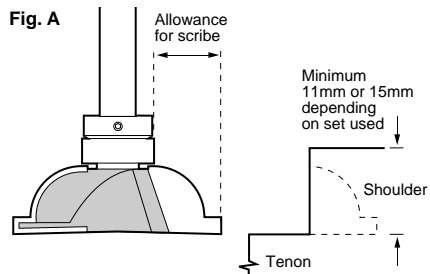
Please see the current Trend Routing Catalogue for alternative moulds and current list prices.

The Scriber

The profile and the scriber have been produced with 1/4" shanks to keep the outside cutting diameter to a minimum, therefore making them available for all makes of router.

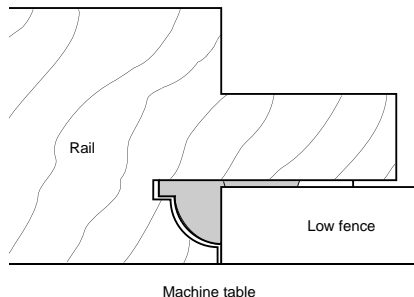
Due to the nature of the scriber it has to machine through the toughest part of the timber, the end grain, which unfortunately leaves the cutter susceptible to breakage if not used in accordance with these instructions. At least three passes are required in soft wood (e.g. pine) and four to five in hard wood (e.g. oak). Taking shallower passes will increase the life of a cutter and gives a better finish. The scriber is designed to scribe the square shoulder (of the tenon) over the given profile that has been produced on the rails, stiles and mullions etc. Please follow these instructions:

1. The shoulder should be cut so as to leave enough material for the cutter to produce the scribe. This distance is governed from the edge of the ball bearing to the cutter tip. See Fig. A.



2. The recommended machining method is to use the router inverted in a table. Set the cutter to the relevant height and then adjust the back fence to cut the appropriate depth. The back fence should also be aligned parallel to any sliding fence that may be used. By looking at Fig. B you will notice that a low false fence will have to be made or the original adapted to allow the tenon to pass over it.

Fig. B



3. The scribe is cut first so that if any breakout occurs the profile operation will remove the splinters. In some instances the scribe will break-out on the bottom of the rail where the profile will not be used. In this case a splinch block will be needed for the cutter to prevent the break-out. This can be made out of any waste material and should be exactly square. By making a splinch block, the material you are cutting can be supported 90° to the back fence. The splinch block can incorporate toggle clamps, dust extraction and protection guards.

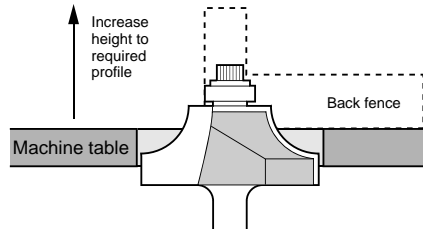
The Profile

The profile cutters of the shoulder scribe and profile sets have a larger quirk to give greater definition and to match closer to original doors and frames that may already be in use.

The profile cutter is used along the grain. It is still advisable to take shallow passes on harder timbers. Please follow this setting-up procedure and see Fig. C.

1. Depending on the number of passes required, the height of the cutter needs to be set at various depths resulting in the final pass lining up with the scribe cut.
2. Before the first pass is taken the back fence should be set level with the profile's ball bearing giving the material support along its length.
3. Each item to be profiled can now be machined.

Fig. C



These instructions cover the basic idea on how to use the cutters. A booklet Ref. BOOK/PD - 'How to Make a Frame & Panel Cabinet Door', illustrates in detail the aspects of splinch block making and cutting circle work. Available on request.

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.

All Trend tooling is guaranteed against any defects in either workmanship or material, except tools that have been damaged due to improper use or maintenance.

Our policy of continuous improvements mean that specifications may change without notice. Trend Machinery & Cutting Tools Ltd cannot be held liable for any material rendered unusable, or for any form of consequential loss.

© Trend Machinery & Cutting Tools Ltd 2001 E & OE

Trend Machinery & Cutting Tools Ltd
Odhams Trading Estate St Albans Road
Watford WD24 7TR
Technical Support: 01923 224681
Fax: 01923 236879
Email: mailserver@trendm.co.uk
WWW: www.trendm.co.uk

RS 28982
Stockholding
& Supply



RECYCLABLE



5 027654 319413 >