

APPLICATION DETAILS

The T4000 series panelled door cutter set is designed to enable the rapid production of moulded frames for panelled doors and panelling. They should be used in table mounted routing machines with a power output of at least 750 watts.

PREPARATION OF TIMBER

This cutter can be used for frames with a thickness of 18–23mm. Prepare all the stock to the required size in one batch. Ensure there is no twist in the timber. It is preferable to cut the stiles about 25mm longer than the finished size: this will allow for run-off at the ends, which may be trimmed off before or after the frame is assembled. The rails will need to be cut 19mm longer than the required inside width of the frame to allow for the scribed joint at each end.

USE OF CUTTERS

The cutter set is supplied assembled ready for use and should not be dis-assembled. These cutters need to be used in a table mounted or overhead router or similar, they are not suitable for freehand use. The table will need a back fence and mitre slide to locate and hold the rails while they are being scribed. The face of the back fence should be aligned with the guide bearing on the cutter which will ensure the correct depth of cut. The mitre slide should be fitted with a timber face to act as a support to prevent breakout while the rail is being scribed. A backstop or other method of clamping should be arranged to prevent the rail being pushed back during the scribe operation.

MACHINING SEQUENCE

1. SCRIBE RAILS

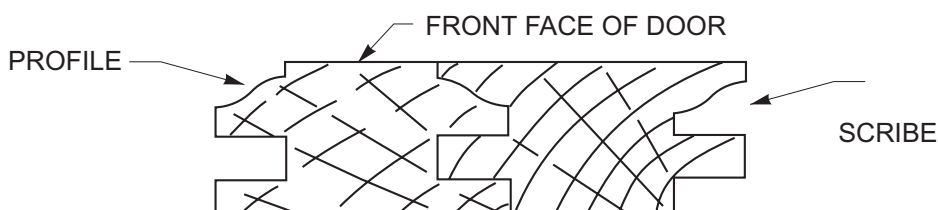
Place the rails with their front face up on the router table. Set the height of the cutter to give the required quirk dimension from the face of the rails. Scribe the ends of all rails in the same operation.

2. RE-ALIGN CUTTER

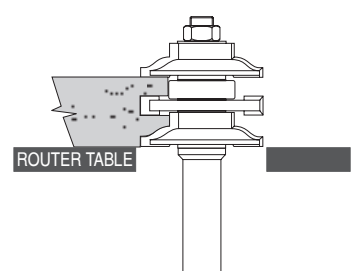
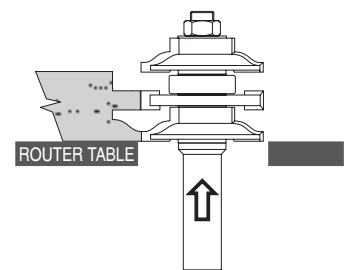
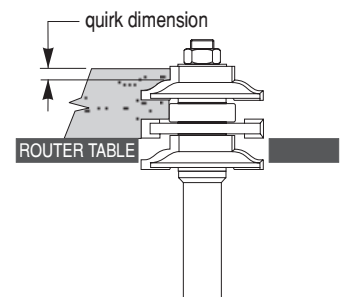
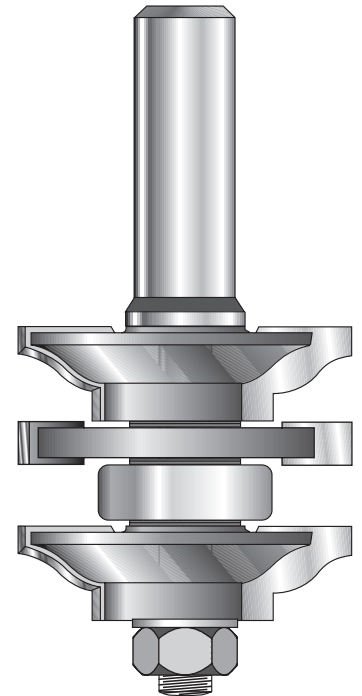
Place the scribed rail with the front face down on the router table and raise the cutter until the groove cutter aligns with the tongue on the scribe.

3. MOULD PROFILES

Using the new height setting from step 2, profile both the rails and stiles with their front faces down on the router table.



COMBINATION PANELLED DOOR BIT



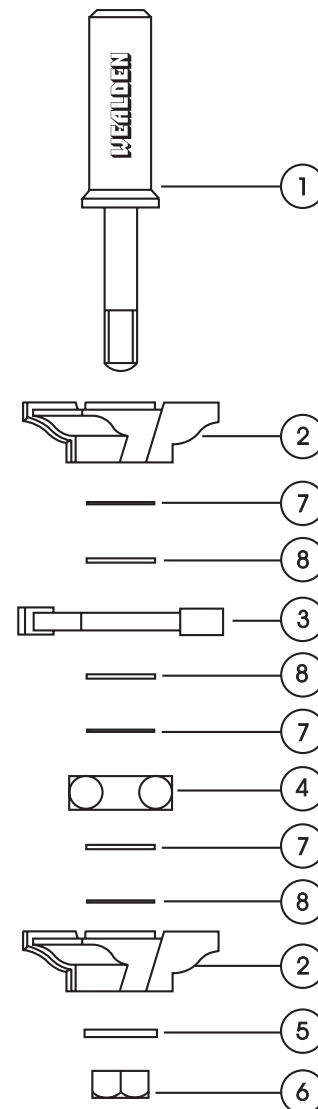
CUTTER ASSEMBLY DETAILS

COMBINATION PANELLED DOOR BIT

If it becomes necessary to dis-assemble the cutter for cleaning, sharpening, replacing parts etc. use the illustration on the right for the correct assembly sequence.

PARTS LIST

1. Arbor	T4359 (long version)
2. Profile cutter	T4200S or T4220S
3. Grooving cutter	T4201
4. Bearing	TB910
5. Washer	M8
6. Nut	M8
7. Thin shim	0.05mm
8. Thick shim	0.10mm



ASSEMBLY OF CUTTER