

## APPLICATION DETAILS

The T4300 panelled door cutter set is designed to enable the rapid production of moulded frames for panelled doors and panelling. They should be used in 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 19–25mm, although the ideal thickness is 22mm. 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, and 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 loss in width due to the scribed joint at each end.

## CUTTER ASSEMBLY

The cutters are supplied ready assembled and will only need to be dismantled to fit spare parts. The parts list below shows the breakdown of components and the items with part numbers are available as spares. When replacing the groover ensure that it is mounted to cut in a clockwise direction when viewed from the shank end of the cutter. Note positioning of the packing shims, items 6 and 7, there are thick and thin shim washers, which may be removed or positioned differently to adjust the fit of the joint. This is particularly useful after the cutters have been resharpened.

## USE OF CUTTERS

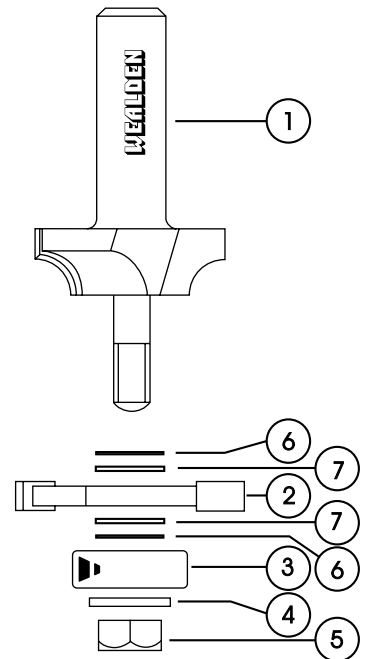
These cutters may be used freehand, however more accurate results will be obtained when using a router table. When machining with either the profile or scribing cutters the base of the router should be against the face of the frame. The use of a sliding mitre gauge will ensure accurate scribes on the ends of the rails. This should preferably be fitted with a false timber face to back up the timber being scribed, thus helping to prevent breakout. The best sequence for machining is to scribe the ends of the rails first. If using a table, the timber will be placed frame face down for both scribe and profile cuts. When all the rails have been scribed on both ends, the profiles may then be cut with the profile cutter.

## PARTS LIST

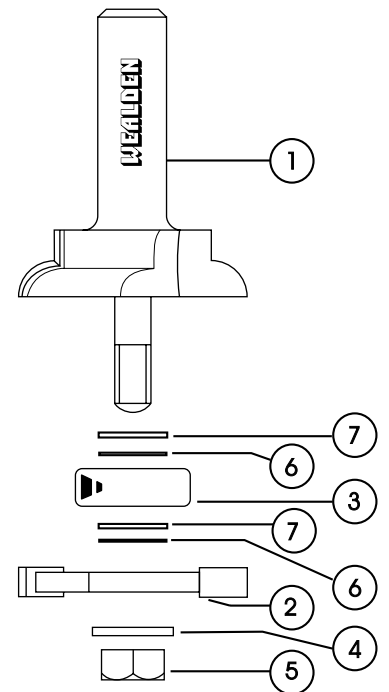
- |                |                         |                    |
|----------------|-------------------------|--------------------|
| 1. Cutter body | 2. Groover (T4201)      | 3. Bearing (TB901) |
| 4. Washer      | 5. Nut                  | 6. Thin shim       |
| 7. Thick shim  | set of 4 shims (TS4200) |                    |

N.B. The number and thickness of shims may vary depending upon manufacturing tolerances. You should make a note of the number of shims in each set and replace them in the same sequence when re-assembling the cutters.

## PANELLED DOOR SETS



PROFILE CUTTER



SCRIBE CUTTER

