APPLICATION DETAILS

REVERSIBLE PANELLED DOOR SETS

The T4200 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 18–22mm. 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 runoff 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 of each end.

CUTTER ASSEMBLY

The complete cutter assembly comprises ten items detailed at the bottom of sheet. These may be assembled in two ways to produce the profile cutter or scribe cutter. The top righthand drawing on this sheet shows the assembly sequence for the profile cutter. Note positioning of the packing shims, items 7 and 8. Also ensure that the cutters are mounted to cut in a clockwise direction when viewed from the shank end of the cutter. The bottom right hand drawing shows assembly sequence for the scribe cutter. 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 received several resharpenings.

USE OF CUTTERS

These cutters may be used freehand, however more accurate results will be obtained when using a router table. When machining the profile section the base of the router should be against the face of the frame, and when machining the scribes the base of the router should be against the back 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 backup 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 up for this operation. When all the rails have been scribed on both ends, the profiles may be cut, frame face down, rearranging the parts on the arbor as per the assembly details above, and then machining the profile as required.
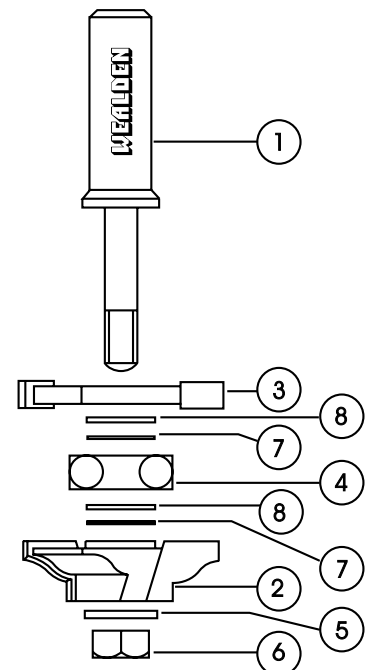
PARTS LIST

1. Arbor	2. Profile cutter	3. Grooving cutter
4. Bearing	5. Washer	6. Nut
7. Thin shim	8. Thick shim	

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 changing the cutter assembly.
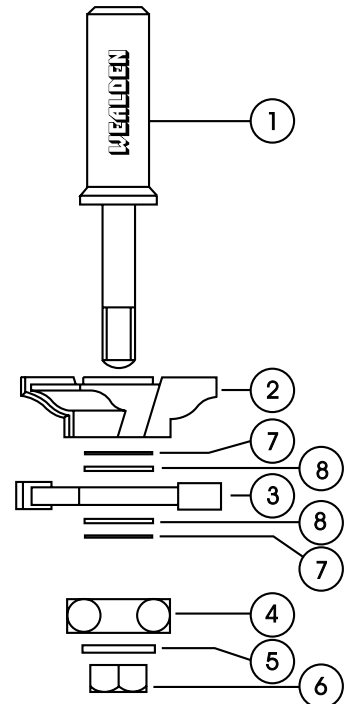
ASSEMBLY FOR PROFILE

ASSEMBLY FOR SCRIBE

PROFILE   SCRIBE

XA42