



## Shoulder Scribe & Profile

# SSP/1- SSP/9



Not all cutter sets are shown

INST/SSP v8.0

# trend<sup>®</sup>

tool technology

Please read carefully before use

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

Thank you for purchasing this Trend router cutter set, 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) or UK Statutory Instruments 2008 No. 1597 – The Supply of Machinery (Safety) Regulation (identified by UKCA marking on the power tool).

### INTENDED USE

This cutter set is intended to be used in an inverted routing machine to produce the shoulder scribe for a mortise and tenon joint for wooden doors, windows and panels.

The cutters can be used in any router which has a 1/4" collet and minimum output of 750 watts.

The cutter sets have been designed for use on frame thicknesses:

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

### 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.

Ensure working position is comfortable and component is clamped securely. Please keep children and visitors away from tools and work area. All tools have a residual risk, so must therefore be handled with caution.

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

### ITEMS REQUIRED

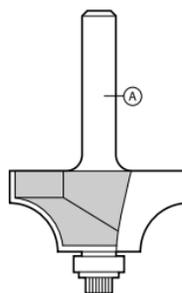
- Router with suitable collet fitted.
- Router table.
- Hand tools.
- Spelch block workholder.
- Jig making equipment and materials.

## ITEMS ENCLOSED & DESCRIPTION OF PARTS

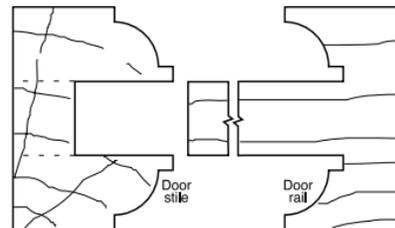
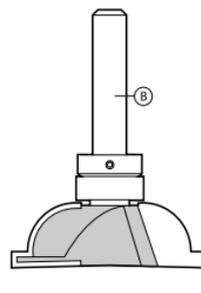
- A. Profile cutter x1
- B. Scribe cutter x1

### For Doors

Profile



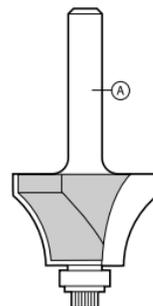
Scribe



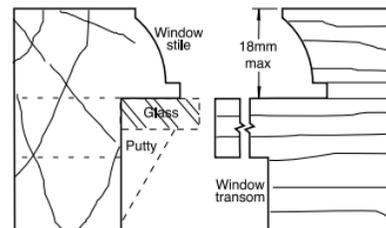
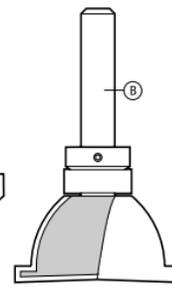
Before using cutter, please ensure it is correctly assembled and locking nut is fully tightened to correct torque setting.

### For Windows

Profile



Scribe



Recommended speed is 24,000 rpm.

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.

### WARRANTY

The cutter carries a manufacturer's warranty in accordance with the conditions on our website [www.trend-uk.com](http://www.trend-uk.com)

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## 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. Ensure at least 3/4 of the shank length is held in the collet.

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.

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

- Prepare timber with a square face and edge, then plane remaining surfaces.
- Mark out fully from the original drawing.
- Machine all mortises.
- Cut the shoulders on the tenons and remove the waste. Cut in any haunches where necessary.
- 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 above complete, you are now ready to use the shoulder scribe set, remember to use the scribe cutter first and the profile cutter second.

## Cutting the Scribe

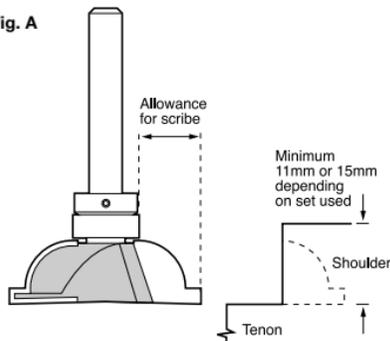


The profile and the scribe have been produced with 1/4" shanks to keep the outside cutting diameter to a minimum, therefore making them available for all makes of router.

Due to the nature of the scribe 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 scribe 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:

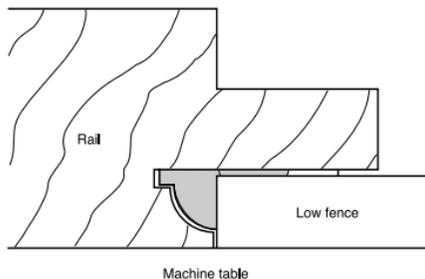
- The shoulder should be cut so as to leave enough material for the cutter to produce the scribe. This distance is governed from the edge of the ball bearing to the cutter tip. See Fig. A.

Fig. A



- 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



- 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.

## Cutting the Profile

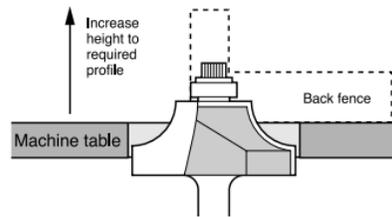


The profile cutters of the shoulder scribe and profile sets have a larger quirk to give greater definition and to match closer to original doors and frames that may already be in use.

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.

- 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.
- Before the first pass is taken the back fence should be set level with the profile's ballbearing giving the material support along it's length.
- Each item to be profiled can now be machined.

Fig. C



## MAINTENANCE



Please use only Trend original spare parts and accessories.

Continual satisfactory operation depends upon proper tool care and regular cleaning.

## Cleaning

- Ensure clamping surfaces are cleaned to remove dirt, grease, oil and water.
- Remove resin build-up regularly.
- Apply a rust protector to shanks.

## Lubrication

- Use a PTFE dry lubricant spray on tool to increase cutting edge life.

## Storage

- Always return cutter to its packaging after use.

## Safety Points

1. Disconnect power tool 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.
  2. Read and understand instructions supplied with power tool, attachment and cutter.
  3. Current Personal Protective Equipment (PPE) for eye, ear and respiratory protection must be worn. Keep hands, hair and clothes clear of the cutter.
  4. 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. Only use tools for woodworking to EN647 safety standard. Ensure cutting tool is suitable for application.
  5. The maximum speed (nmax) marked on tool or in instructions or on packaging shall not be exceeded. Where stated, the speed range should be adhered to.
  6. 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 the shank length is held in collet. Ensure clamping surfaces are clean.
  7. 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.
  8. Ensure all visors, guards and dust extraction is fitted.
  9. The direction of routing must always be opposite to the cutter's direction of rotation.
  10. Do not switch power tool on with the cutter touching the workpiece.
  11. Trial cuts should be made in waste material before starting any project.
  12. Repair of tools is only allowed according to tool manufacturers instructions.
  13. Do not take deep cuts in one pass, take shallow passes to reduce the side load applied to the cutter.
  14. User must be competent in using woodworking equipment before using our products. Dress properly, no loose clothing/jewellery, wear protective hair covering for long hair.
  15. Consider working environment before using tools. Ensure working position is comfortable and component is clamped securely. Keep proper footing and balance at all times. Check work area for obstructions. Keep control of power tool at all times.
  16. Please keep children and visitors away from tools and work area.
  17. All tools have a residual risk so must therefore be handled with caution.
  18. Only use Trend original spare parts and accessories.
- If you require further safety advice, technical information, or spare parts, please call Trend Technical Support or visit [www.trend-uk.com](http://www.trend-uk.com)

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