



**Lambs Tongue  
Sash Bar Set  
20/50**



Please read carefully before use

**LAMBS TONGUE SASH BAR SET  
REF. 20/50**

Thank you for purchasing this Trend router cutter, 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).

**INTENDED USE**

The set is intended to be used in a fixed head routing machine to produce a lambs tongue sash bar and scribe in wood for glazing.

The set will not create a tenon, so separate reinforcement is required. If full length tenons are required the accessory lambs tongue scribe cutter ref. 20/51 should be used.

**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.

**ITEMS REQUIRED**

- Router with suitable collet fitted.
- Router table or overhead router stand.
- 13mm A/F spanner.
- Hand tools.
- Jig making equipment & materials.
- Workholder.



When using stacked tooling (multi-blade, block, groover etc.) on a spindle arbor, ensure that the cutting edges are staggered to each other to reduce the cutting impact.

**NOTE:** Diagrams show cutting edge not staggered for clarity.

**ITEMS ENCLOSED & DESCRIPTION OF PARTS**

- A. Arbor **x1**
- B. Nut 13mm A/F **x1**
- C. Profile block, 35mm dia. **x1**
- D. Rebate block, 35mm dia. **x1**
- E. Bearing 22mm dia. **x1**
- F. Shim 0.1mm **x3**
- G. Shim 0.05mm **x3**
- H. Spacer 6mm **x3**
- I. Spacer 3mm **x3**
- J. Washer 1mm **x1**
- K. Instructions **x1**

**ASSEMBLY**

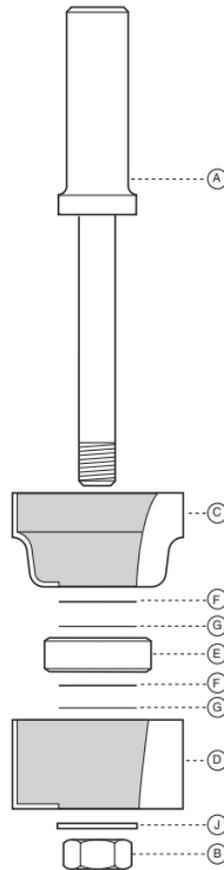
This set is supplied in profiling assembly, however when machining a sash bar frame the scribe should be machined first. A workholder or mitre fence will be required for safety and accuracy. Re-assemble the tooling for profiling as per the diagram. Add or remove shims to vary the tightness of the joint, this is most important after resharpening.

The cutter height is simply lowered or raised to cut the scribe or sash bar on the wood.

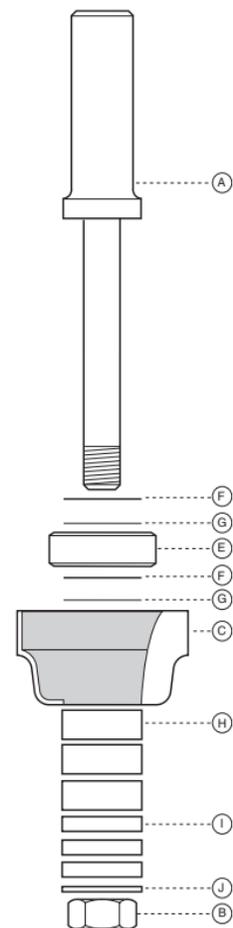
The ball bearing will automatically give the correct depth of cut.

The cutter is supplied when purchased with all the cutting edges in line, the parts C and D should be assembled square to each other (turn one through 90°) to reduce cutting impact.

**Set-up for Profiling as supplied**



**Set-up for Scribing**



**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.

**GUARANTEE**

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

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**Trend Machinery & Cutting Tools Ltd.**  
Odhams Trading Estate St Albans Road  
Watford WD24 7TR England  
Tel: 0044(0)1923 249911  
technical@trendm.co.uk  
www.trend-uk.com



RS 2882  
Stockholding & Supply



RECYCLABLE



PTO

## OPERATION



Carefully remove the protective wax from the cutter and dispose.

Ensure the two pieces of timber to be used for each knuckle joint are accurately planed to thickness and cut off square at the ends. Their length and width will obviously depend on the project in hand but in theory a joint of any width could be made providing an accurate hole can be drilled through the completed joint.

Allow for glueing and for corner beading.

Whatever type of machine is used, ensure that the timber is totally square. Due to the design of the tooling, only one face side will be used against the table.

The spacers used in the scribe mode can either be arranged above the profile block and bearing, or below the profile block and bearing.

A test joint should be made on scrap material before performing either the profile or scribe operation.

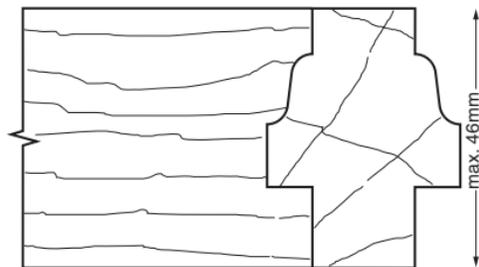
The profile and rebate block have opposing shear angles to achieve a smooth finish of cut.



Recommended speed is 24,000rpm.



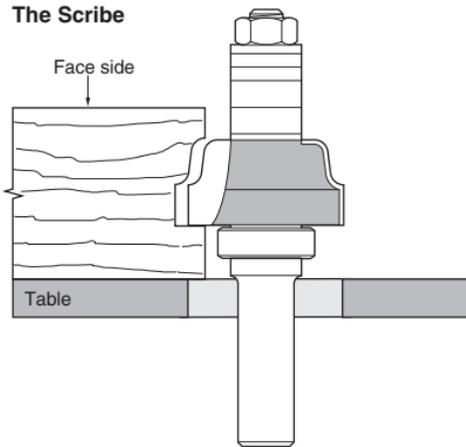
Maximum material thickness is 46mm.



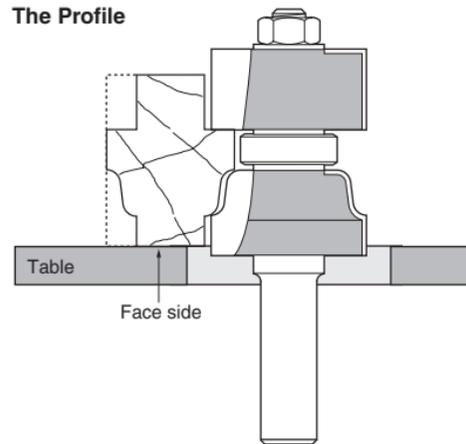
Before using cutter, please ensure it is correctly assembled and locking nut is fully tightened to correct torque setting.

## In a Table Routing Machine

### The Scribe

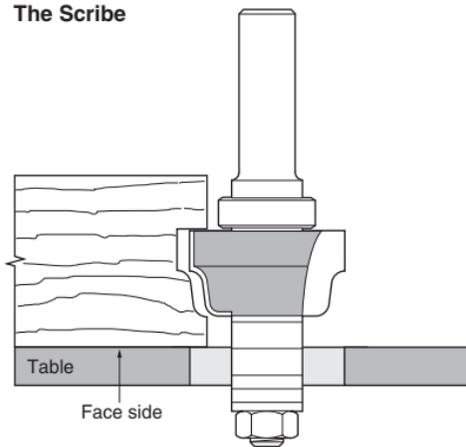


### The Profile

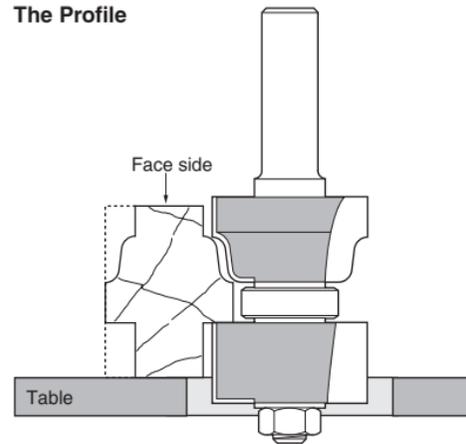


## In an Overhead Routing Machine

### The Scribe



### The Profile



## SPARE PARTS

Please use only Trend original parts.

Item	Qty.	Desc.	Ref.(1 off)
C	1	Profile block	SP-20/50A
D	1	Rebate block	SP-20/50B
A	1	Arbor with spacers	SP-20/50C
E	1	Bearing 22mm dia.	BB22
B	1	Replacement arbor nut	ANUT/33/30
	1	Spacer set	SPACER/8
K	1	Instructions	INST/20/50

## MAINTENANCE

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. Do not use rust protector on ball bearing guides.

### 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 and 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.
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 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.

Please see [www.trend-uk.com/safety](http://www.trend-uk.com/safety) for more safety advice.



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