



CraftPro  
Easyset  
**C155**  
**C204**



INST/C155 v9.1

Please  
read carefully  
before use

## CRAFTPRO EASYSET PROFILE SCRIBER REF. C155 & C204

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

This cutter set is intended to be used in a fixed head routing machine to produce a cabinet frame and panel door in wood and MDF.

Material thickness:   min. 18mm  
                                  max. 22mm

An ideal timber thickness is 20mm.

**trend**<sup>®</sup>  
routing technology

### 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.

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

Please keep children and visitors away from tools and work area. All power tools will have a residual risk, so must therefore be operated with caution.

### ITEMS REQUIRED

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

### ITEM ENCLOSED & DESCRIPTION OF PARTS

- A. Arbor **x1**
- B. Nut 13mm A/F **x1**
- C. Profile block **x1**
- D. Groover **x2**
- E. Ball bearing 22mm dia. **x2**
- F. Washer 1.0mm **x1**
- G. Shims 0.1mm **x3**
- H. Shims 0.05mm **x3**
- I. Instructions **x1**

### ASSEMBLY

Changes in tightness can be achieved by adding or removing shims G & H. This is most important after resharpenering.

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

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

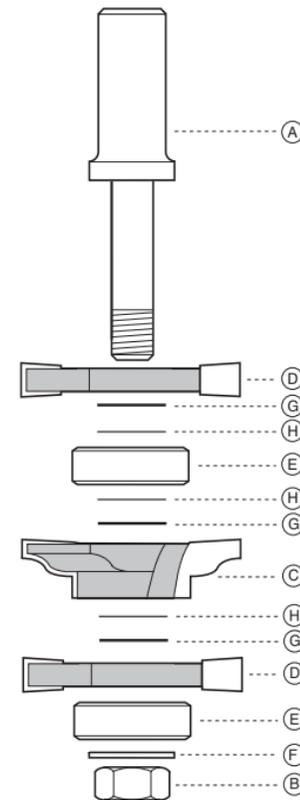
The cutter is supplied when purchased with all the cutting edges in line, the parts D, C & D should be assembled square to each other (turn one through 90°) to reduce cutting impact.



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.

### Cutter Set-up as supplied



### 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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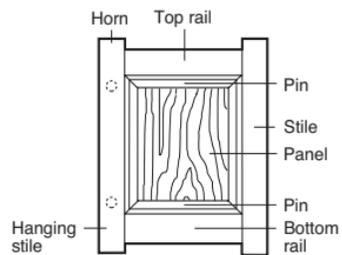
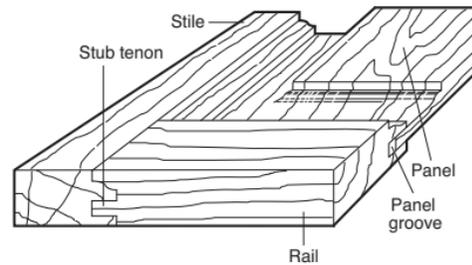


PTO

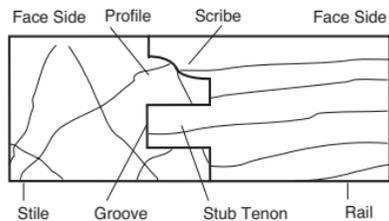


RECYCLABLE

## Parts of a Panelled Door



## The Joint



## OPERATION



Carefully remove the protective wax from the cutter and dispose of correctly. Insert the cutter shank into the 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 the collet.



**Recommended speed is 18,000 rpm.**

## Cutting the Scribe

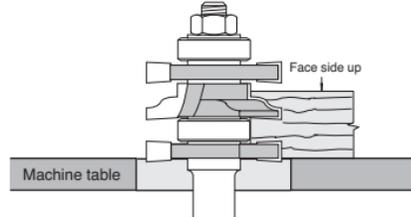


The groover, ball bearing and cutter block nearest the shank of the arbor are used for cutting the scribe across the ends of the rail. When routing inverted in a table the scribe is cut with the face side of the wood facing up. A workholder should be used as the rails will be too narrow to run against a fence. This also has the advantage of making the operation safer and more accurate.

The height of the cutter should be adjusted according to the thickness of the timber between 18mm to 22mm.

Material thickness should be between 18mm and 22mm, with 20mm thickness preferable. Material should be squared all round to ensure perfect joints are achieved. Always unplug the router from the power supply before making any adjustments and ensure that the cutter is guarded so that the operator's fingers cannot contact the cutter. This cutter is fitted with an 8mm shank, so extra care should be taken to avoid overloading the cutter and causing shank deflection.

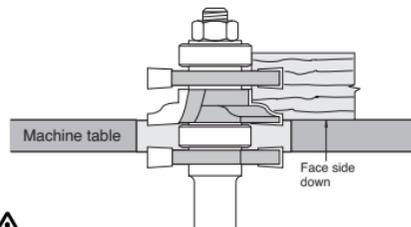
When using these sets, shallow passes must be taken at all times. This can be achieved by adjusting the back fence. The final cut using the ball bearing as a guide.



## Cutting the Profile



When the scribes on the ends of the rails have been cut, lower the height of the cutter so that the groover, ball bearing and cutter which is nearest the nut can be used to cut the profile. The profile is cut along the wood. When routing inverted in a table the face side of the wood is facing down.



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



**Ensure working position is comfortable and component is clamped securely.**



**Consider working environment before using tools.**



**Regularly check knobs, handles and locking nuts are tight using tools.**

## SPARE PARTS

Please use only Trend original spare parts and accessories.

Item	Qty.	Desc.	Ref. (1 off)
A	1	Replacement arbor 8mm shank	33/31X8MM
B	1	Replacement arbor nut	ANUT/33/30
C	1	Profile block	SP-C149A
D	2	Groover	SP-C149C
E	1	Bearing 22mm dia.	BB22
	1	Spacer set	SPACER/8
I	1	Instructions	INST/C155

## 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. 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 (n<sub>max</sub>) 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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