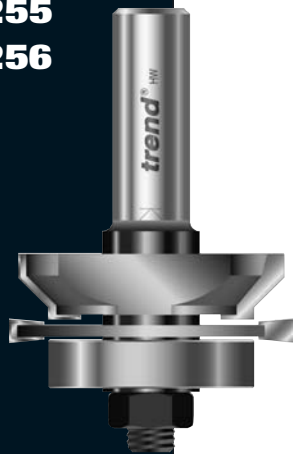




**CraftPro  
Matchlining  
Cutter  
C255  
C256**



**trend**  
routing technology

INST/C255 v1.0

Please read  
read carefully  
before use

**CRAFTPRO MATCHLINING CUTTER  
REF. C255 & C256**

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.



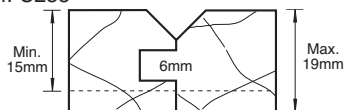
Refer to the instruction manual of your power tool.

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).

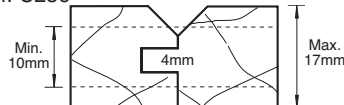
**INTENDED USE**

This cutter is intended to be used in an inverted fixed head router with suitable size collet to create a matchlining joint in natural timbers.

Ref. C255



Ref. C256



**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.

**ITEMS REQUIRED**

- Router with suitable collet.
- Router table.
- 13mm A/F spanner.
- Handtools.



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

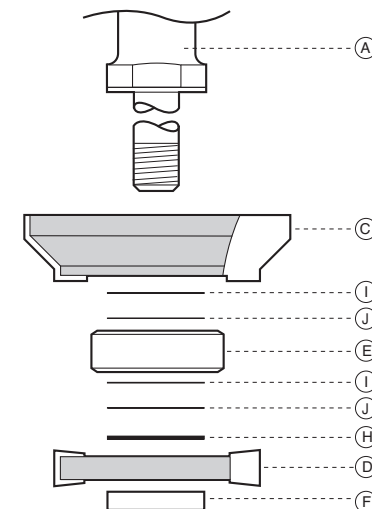
**ITEMS ENCLOSED & DESCRIPTION OF PARTS**

- A. Arbor **x1**
- B. Nut 13mm A/F **x1**
- C. Chamfer profile block **x1**
- D. Groover 34mm diameter **x1**
- E. Bearing 22mm diameter **x1**
- F. Washer 1.0mm **x4**
- G. Washer 0.5mm **x2**
- H. Groover 47mm diameter **x1**
- I. Bearing 34mm diameter **x1**
- J. Instructions **x1**



**When using stacked tooling (multi-blade, block and 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 edges not staggered for clarity.**

**TONGUE SET-UP**  
as supplied



When the set is factory assembled, the chamfer profile block and groovers are fitted so the blades are directly above each other. One needs to be moved 90° to reduce cutter impact on material (see underside view).

The set is supplied in tongue mode and must be reassembled into groove mode for the first routing operation.

**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



PTO

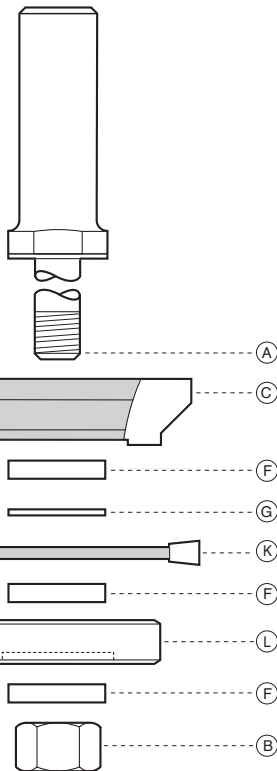


RS 28982  
Stockholding  
& Supply



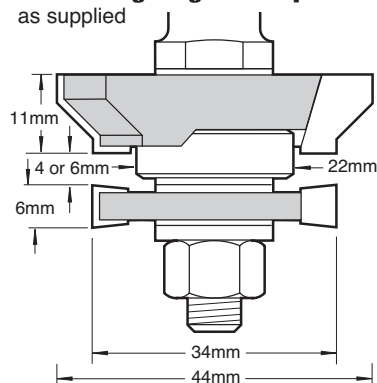
RECYCLABLE

## Groove Set-up

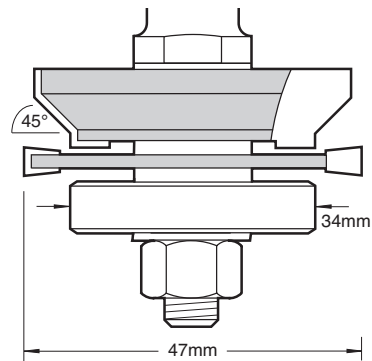


## Matchlining Tongue Set-up

as supplied



## Matchlining Groove Set-up



## OPERATION



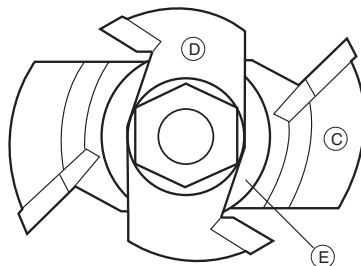
Carefully remove protective wax from cutter and dispose. Insert cutter into the router collet at least all the way to the marked line indicated on the shank. This ensures at least 3/4 of the shank is held in collet.

Set the cutter to give desired chamfer on timber. Machine all items requiring the tongue

To machine groove, first remove plug from socket. Without adjusting the height, undo 13mm nut. Remove all parts except arbor and chamfer profile. Following groove set-up reassemble, placing cutters at 90° to each other as shown in Underside View.

Recommended speed 18,000rpm.

## Underside View



## SPARE PARTS

Please use only Trend original spare parts

Item	Qty.	Desc.	Ref. (1 off)
C	1	Chamfer profile cutter	SP-C255A
E	1	Bearing 22mm	BB22
I	1	Bearing 34mm	BB34
D	1	Groover 34mm	SP-C255B
H	1	Groover 47mm x 6.0mm	SP-C255C
H	1	Groover 47mm x 4.0mm	SP-C256C
A	1	Arbor with spacers	SP-C255D
	1	Spacer set	SPACER/8
J	1	Instructions	INST/C255

## 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

- 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.



Our policy of continuous improvements mean that specifications may change without notice. Trend Machinery & Cutting Tools Ltd. cannot be held liable for any material rendered unusable, or for any form of consequential loss.