



## Panel Door Set PDS/1-12



**trend**  
routing technology

INST/PDS v4.0

Please  
read carefully  
before use

### PANEL DOOR SET REF. PDS/1 - PDS/5 & PDS/10 - PDS/12

Thank you for purchasing this Trend router cutter set, which should give lasting performance if used in accordance with these instructions.

The following symbol is 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.

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 98/37/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.

The PDS sets PDS/10 - PDS/12 are supplied with 8mm shanks and can be used in smaller portable routers (with minimum 750 watts). The router should be fitted with an 8mm collet. The correct collet can be supplied through your local Trend stockist.



Please take many light passes with 8mm shank tooling.



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

### 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 fitted.
- 13mm A/F spanner.
- Router table or overhead router stand.
- 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 INCLUDED & DESCRIPTION OF PARTS

- A. Arbor **x1**
- B. Nut 13mm A/F **x1**
- C. Profile Block **x1**
- D. Groover **x1**
- E. Ball Bearing 22mm diameter **x1**
- F. Washer 1.0mm **x1**
- G. Shims 0.1mm **x3**
- H. Shims 0.05mm **x3**
- J. Spacers 1.0mm for PSC/20 & PSC/40 only **x2**
- K. Shim 0.5mm for PSC/20 & PSC/40 only **x1**
- L. Instructions **x1**



Panel cutters in sets PDS/1, 2 and 3 should be used at maximum speed 16,000 RPM.

Panel cutters in sets PDS/4 and 5 should be used at maximum speed 12,000 RPM.

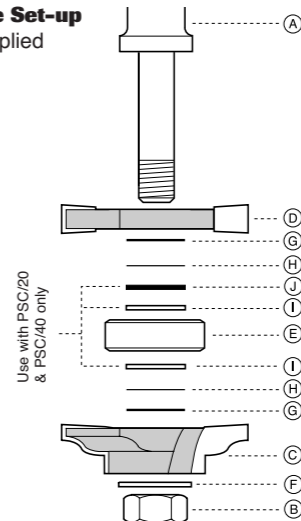
Panel cutters in sets PDS/10, 11 and 12 should be used at maximum speed 22,000 RPM.

### ASSEMBLY

The profile scriber is supplied in scribing mode. Changes in tightness can be achieved by adding or removing shims G & H. This is most important after resharpening. Cutters are rearranged on the arbor to either cut the profile or the scribe. The ball bearing will automatically give the correct depth of cut. When reassembling follow the sequence of the two diagrams.

PSC/1 illustrated as supplied in sets PDS/1 and PDS/10.

### Scribe Set-up as supplied



Use with PSC/20  
& PSC/40 only

The order of assembly is as above when purchased, but parts C and D should be assembled square to each other (turn one through 90°) to reduce cutting impact.

This set-up is used for cutting the scribe across the ends of the rails. 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. Spacers I and shim J are only used on PSC/20 and PSC/40 assemblies.

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.

### 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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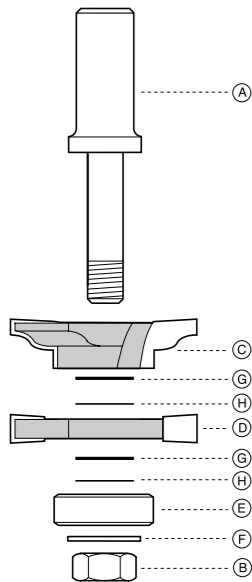


PS 28982  
Stockholding  
& Supply



RECYCLABLE

## Profile Set-up



When assembled, this cuts the profile along the length of the timber. The wood should be inverted first. The height of the cutter should be adjusted according to the scribe.

Each set is supplied with spare shims for use with the set after resharpening or if especially tight or loose joints are required.

— Shim 0.05mm  
 — Shim 0.1mm

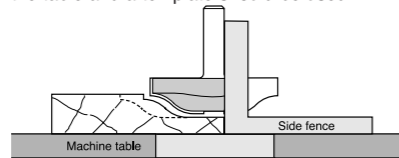
## OPERATION



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. This ensures at least 3/4 of the shank length is held in the collet.

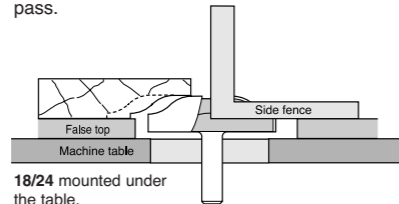
## Producing the Panel with 8mm Shank Panel Cutters

Panel cutters supplied in PDS/10 - PDS/12 sets are not fitted with a guide bearing. A side fence will therefore be required to guide the workpiece. For shaped panelling a copy pin in the table and a template should be used.



18/24 (as supplied in set PDS/10) mounted over the table.

The length of the tongue can be increased by altering the fence position prior to a second pass.

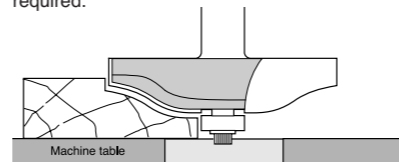


18/24 mounted under the table.

## Producing the Panel with 1/2" Shank Panel Cutters

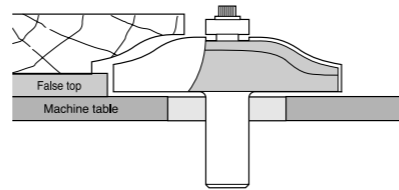


Panel cutters supplied in PDS/1 - PDS/5 sets are fitted with a guide bearing. This enables one to dispense with the fence. The cutter can also be used to produce a curved panel to fit into a curved top rail. A lead-on piece is required.



18/83 (as supplied in set PDS/1) mounted over the table.

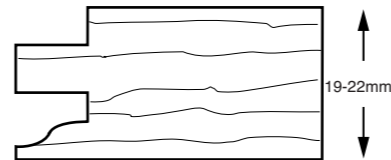
When used in an overhead routing machine, ensure material is held flat and firmly down onto the table with a down pressure guard.



18/83 mounted under the table.

## Scribe

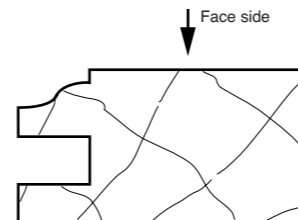
Used on ends of top and bottom rail.



↑ Face side

## Profile

Used along length of rails and styles.



If the cutter will not fit through your table, a false top will be required to achieve the correct depth. This should ideally be made from plywood or MDF. Always take a number of passes to improve finish and to ensure longer cutter life. Always feed timber against the direction of cutter rotation. **NOTE:** Diagrams show guards removed for clarity.

## SPARE PARTS

Please use only Trend original spare parts.

Item	Qty	Desc.	Ref.
A	1	Replacement arbor 1/2"	33/30x1/2
	1	Replacement arbor 8mm	33/30x8mm
B	1	Replacement arbor nut	ANUT/33/30
	1	Profile block for PSC/1	PSC/1A
C	1	Profile block for PSC/2	PSC/2A
	1	Profile block for PSC/3	PSC/3A
	1	Profile block for PSC/4	PSC/4A
	1	Profile block for PSC/5	PSC/5A
	1	Profile block for PSC/10	PSC/10A
	1	Profile block for PSC/20	PSC/20A
	1	Profile block for PSC/30	PSC/30A
	1	Profile block for PSC/40	PSC/40A
	1	Profile block for PSC/50	PSC/50A
	1	Groover for PSC/1, PSC/3 & PSC/5	SP-34/70TC
D	1	Groover for PSC/2 & PSC/4	SP-34/71TC
	1	Groover for PSC/10, PSC/30 & PSC/50	SP-34/70TC
	1	Groover for PSC/20 & PSC/40	SP-34/73TC
E	1	Bearing 22mm Ø	BB22
	1	Spacer set	SPACER/8
J	1	Instructions	INST/PDS

## MAINTENANCE

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

### Cleaning

- 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.
- Apply a rust protector to shanks. Do not use rust protector on ball bearing guides.

### Storage

- Return cutter to its packaging after use.

## Safety Points

- 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.
- Read and understand instructions supplied with power tool, attachment and cutter.
- Current Personal Protective Equipment (PPE) for eye, ear and respiratory protection must be worn. Keep hands, hair and clothes clear of the cutter.
- 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.
- 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.
- 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.
- 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.
- Ensure all visors, guards and dust extraction is fitted.
- The direction of routing must always be opposite to the cutter's direction of rotation.
- Do not switch power tool on with the cutter touching the workpiece.
- Trial cuts should be made in waste material before starting any project.
- Repair of tools is only allowed according to tool manufacturers instructions.

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



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