

T2

LAMINATE
TRIMMER



trend[®]
routing technology

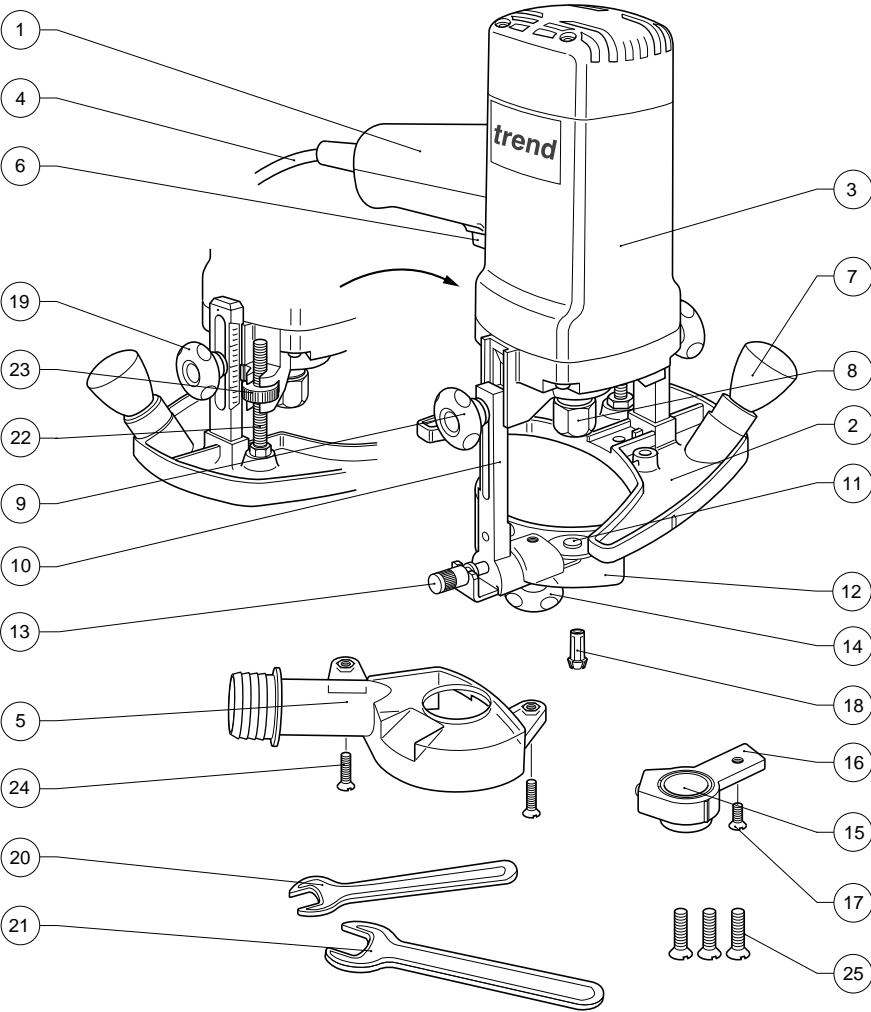
ITEMS ENCLOSED

- 1 x Copy follower
- 1 x Copy follower deflector
- 1 x Collet 1/4" (6.35mm) UK & Eire, Europe 8mm
- 1 x Guide bush assembly and fixing screw
- 1 x Spanner (17mm A/F)
- 1 x Spanner (15mm A/F)
- 1 x Dust spout/guard and fixing screws
- 3 x Accessory fixing screws
- 1 x Instructions
- 1 x Guarantee registration card

DESCRIPTION OF PARTS

- ① Main handle
- ② Router base assembly
- ③ Motor housing
- ④ Power cable
- ⑤ Dust spout/guard (external dia. 29mm)
- ⑥ On/Off Switch
- ⑦ Base grip knob
- ⑧ Collet nut
- ⑨ Thumb knob with washers for copy follower attachment
- ⑩ Copy follower
- ⑪ Copy follower bearing dia. 20mm
- ⑫ Copy follower deflector*
- ⑬ Copy follower adjustment knob
- ⑭ Copy follower locking knob
- ⑮ Template guide bush dia. 18mm
- ⑯ Template guide bush bracket
- ⑰ Template guide bush bracket screw
- ⑱ Collets UK & Eire 1/4" (6.35mm), Europe 8mm
- ⑲ Thumb knob with washers for base assembly
- ⑳ Spanner (15mm A/F)
- ㉑ Spanner (17mm A/F)
- ㉒ Base stud
- ㉓ Base stud adjustment knurled nut
- ㉔ Dust spout/guard fixing screw
- ㉕ Accessory Fixing Screw

* The copy follower deflector must only be fitted to the copy follower attachment when using unguided cutters with a 25mm cut length or longer.



SAFETY

General Safety

- Make sure the machine is switched off before inserting the plug in the socket.
- Do not switch on the laminate trimmer with the cutter in contact with the workpiece.
- Clamp the workpiece securely to prevent it from moving during the routing operation.
- Always trail the cable away from the working area.
- Always remove the plug from the socket before making any adjustments to the machine.
- Check that the cutter is fitted securely. Be careful when handling cutters as they are sharp.
- Always keep the area around the workpiece and the floor clear of obstacles.
- The direction of routing must always be opposite to the cutter's direction of rotation.
- Do not feed the cutter into the workpiece until it is at full speed.
- Always guide the laminate trimmer with both hands. Always keep second hand on the base grip knob to prevent tipping.
- Never exceed the maximum speed specified for the cutter.
- When you are finished, allow the machine to come to a complete stop.
- Do not allow objects to dangle over the work area i.e. do not wear loose clothing such as a tie. Roll sleeves back and ensure long hair is tied back.
- Check before starting to cut that clamps will not obstruct the path of the laminate trimmer. When cutting through the full thickness of the material, ensure that the cutter cannot foul the vice, bench edge or other obstacles beneath the workpiece.

Noise

The level of noise when routing may exceed 85 dB(A). It is therefore advisable to wear ear defenders especially if routing for long periods of time.

Eye Protection

Goggles, safety spectacles or visors should be worn to protect the eyes from ejected waste particles.

Dust Protection

The fine dust created when routing presents a severe health risk if it is inhaled. Always wear a dust protection mask or respirator and use the dust spout connected to a suitable extractor. Dust masks and filters should be changed regularly.

Electrical Safety

Power Supply

The electric motor has been designed for one voltage only. Always check that the power supply corresponds to the voltage on the rating plate. Machines marked for 230 volt can also be operated from a 220 volt supply.



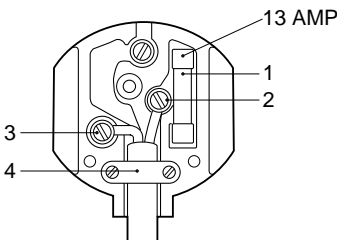
The T2 is double insulated in accordance with EN 50144; therefore no earth wire is required.

Mains Plug Replacement (UK & Ireland only)

Always check the condition of the cable and plug before starting with your work.

Should your mains plug need replacing and you are competent to do this, proceed as instructed below. If you are in doubt, contact an authorised Trend repair agent or a qualified electrician.

- Disconnect the plug from the supply.
- Cut off the plug and dispose of it safely; a plug with bared copper conductors is dangerous if engaged in a live socket outlet.
- Only fit 13 Amperes BS 1363A approved plugs fitted with a 13 Amp A.S.T.A approved BS 1362 fuse (1).
- The cable wire colours, or a letter, will be marked at the connection points of most good quality plugs. Attach the wires to their respective points in the plug (see below). Brown is for Live (L) (2) and Blue is for Neutral (N) (3).
- Before replacing the top cover of the mains plug ensure that the cable restraint (4) is holding the outer sheath of the cable firmly



and that the two leads are correctly fixed at the terminal screws.



IMPORTANT!

Never connect the live (L) or neutral (N) wires to the earth pin marked E or \perp

Using an Extension Cable

- If an extension cable is required, use an approved triple core extension cable suitable for the power input of this tool (see technical data).
- When using a cable reel, always unwind the cable completely.
- Also refer to the table below.

Cable Rating (Amperes)		
Cable length (m)	Voltage	
	240V	
	7.5	6A
	15	6A
	25	6A
	30	6A
	45	10A
60	15A	

Conductor size (mm ²)	Cable rating (Amperes)
0.75	6
1.00	10
1.50	15
2.50	20
4.00	25

ASSEMBLY & ADJUSTMENT

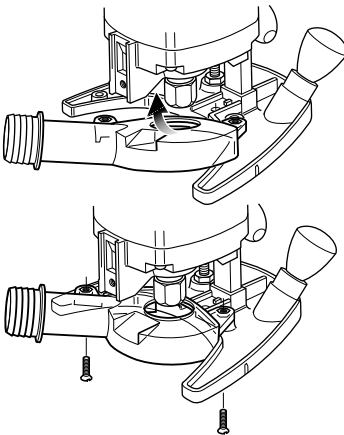
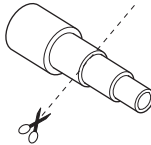
Fitting Base Assembly to Motor Unit

- Remove base fixing knobs and washers.
- Place base assembly into motor housing. Ensure knurled nut is between alloy posts on base.
- Fit spring washer onto thread on knob followed by washer. Thread knob assembly into tapped hole in motor housing and tighten.



Fitting Dust Spout/Guard

- Insert the dust spout/guard in the base. The dust spout/guard is suitable for dust extractors with a hose diameter of 29mm.
- Secure using two countersunk screws.
- Dismantle in reverse order.
- If using the T30 Vacuum Extractor with the T2, the power adaptor supplied with the T30 will need to be cut down to the 35mm diameter segment. This adaptor is also available as an accessory, Ref. WP-T30/056.

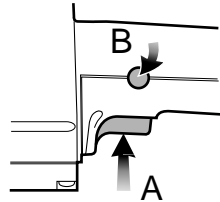


IMPORTANT!

The dust spout acts as a guard and must always be fitted to the machine when routing.

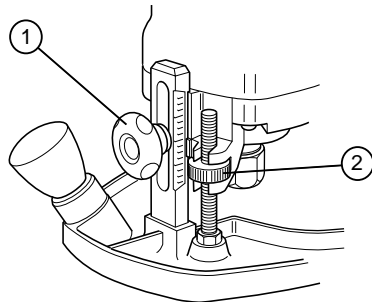
Switching On & Off

- To switch on router depress switch, to turn off release switch.
- To lock the switch on, depress switch and then depress button. To release, depress switch.



Adjusting the Depth of Cut

- Place the machine on the workpiece.
- Loosen base locking knob (1), turn knurled nut (2) clockwise to lower cutter height. Turn anti-clockwise to raise cutter height.
- Once height is set, tighten locking knob.
- Turn knurled nut slightly to take up the back-lash.



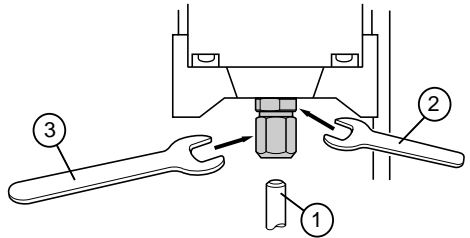
IMPORTANT!

- Make sure the machine is switched off before connecting it to the power supply.
- Never make adjustments when the laminate trimmer is running or plugged in.
- Deep cuts should always be routed in several passes.

Fitting and removing cutters

Fitting Cutters

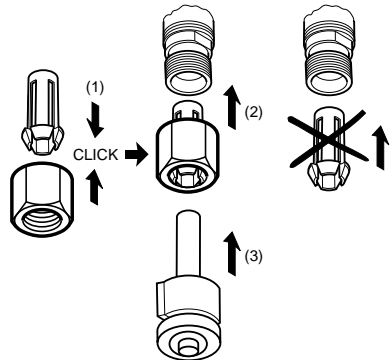
- Insert at least $\frac{3}{4}$ of the shank length of the cutter (1) into the collet.
- Place 15mm A/F spanner (2), onto flats on spindle.
- Tighten the collet nut with the 17mm A/F spanner (3). Do not use excessive force.



Removing Cutters

- Undo the 17mm A/F collet nut with the 17mm A/F spanner. Lock spindle with 15mm A/F spanner.
- Keep turning the spanner until the collet nut **tightens and then loosens again**. This is the fail-safe mechanism releasing the collet.
- The cutter should now slide out.
- Each time you finish using a cutter, remove it and store it in a safe place.

Correct Sequence for Fitting Collet, Nut and Cutter

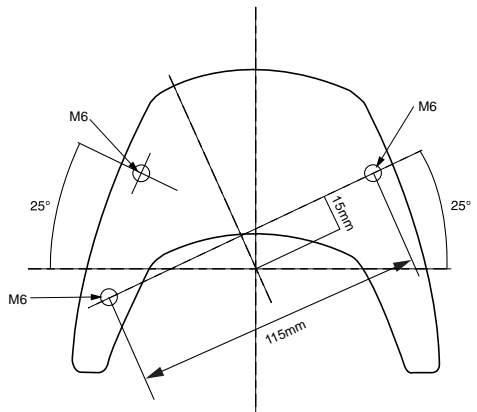


IMPORTANT!

- Do not tighten the collet without a cutter fitted.
- Always use cutters with shanks which match the diameter of the collet.
- Do not use cutters larger than 23mm diameter.

Trend Base Configuration (TBC) - Fixing Points for Accessories

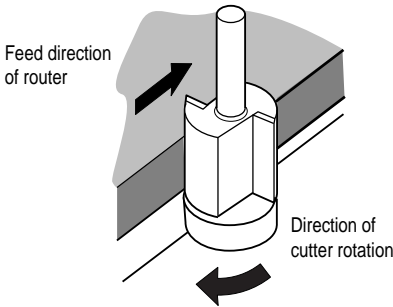
The router has three threaded holes M6 in its base that allow fitting of certain accessories and also fitting to router tables. Three M6x16mm countersunk screws are included for this purpose.



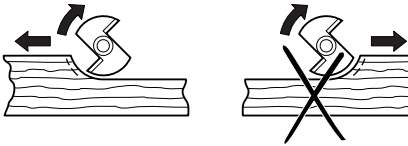
OPERATION

Cutting Direction

The direction of routing must always be opposite to the cutter's direction of rotation. Otherwise there is a risk of kick-back.



Feed Direction



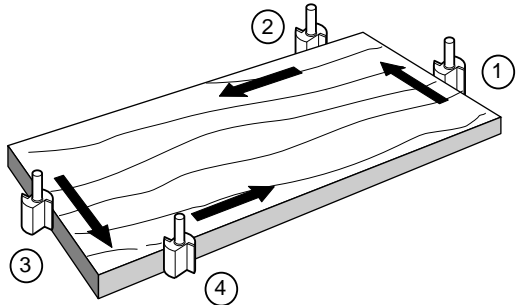
When routing along an edge, the direction of the router travel should be against that of the rotation of the cutter. This will create the correct cutting action and prevent the cutter 'snatching'. It will also pull the router towards the workpiece and hence the copy follower or guide bearing will be less likely to wander from the edge of the workpiece.

Feed Speed

The speed at which the cutter is fed into the wood must not be too fast that the motor slows down, or too slow that the cutter leaves burn marks on the face of the wood. Practice judging the speed by listening to the sound of the motor when trimming.

Trimming Natural Timbers

When edge trimming natural timbers, always mould the end grain first, followed by the long grain. This ensures that if there is 'breakout', this will be removed when the long grain is trimmed.

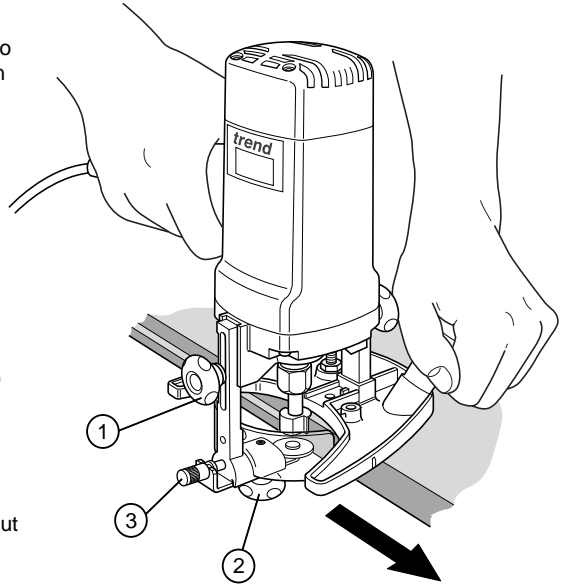


Copy Follower Routing

Copy follower routing allows unguided cutters to be used. The copy follower is fully adjustable in height and depth.

Fitting Copy Follower

- Fit dust spout/guard.
- To alter height, loosen knob (1) and move assembly up or down to suit cutter. Ensure bearing does not touch cutter. Once set tighten knob.
- To adjust side movement loosen lower knob (2) and turn knurled adjustment screw (3) to move bearing in or out. Once set tighten knob.
- The copy follower has a diameter of 20mm and can be used with a variety of cutters.
- The copy follower can be used with or without the clear plastic deflector (4) depending on the router cutter's cutting length. The deflector must not be used with cutters with a cut length of less than 25mm, due to the position of the dust extraction spout/guard.



IMPORTANT!

The dust spout/guard must be fitted at all times.

Using Copy Follower

- Before setting up the trimmer ensure copy follower position is correct and that cutter will not touch bearing.
- Switch on the trimmer and when cutter reaches full speed, gently enter cutter into the workpiece.
- Feed along workpiece, keeping sideways pressure.
- When finished, pull trimmer away from workpiece and switch off.



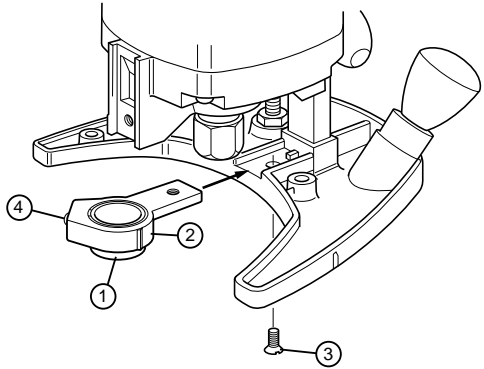
IMPORTANT!

- When using cutters with a different diameter to the copy bearing, ensure that the copy follower is kept perpendicular to the material to ensure a consistent depth of cut.
- The deflector on the copy follower attachment can only be fitted when using cutters with a cut length of larger than 25mm.

Template Guide Bush Routing

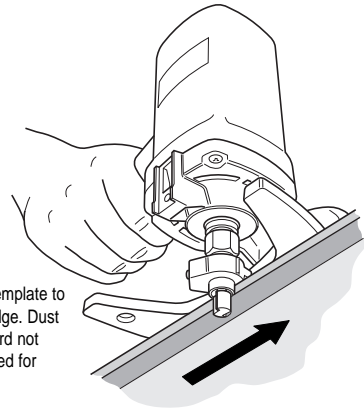
Fitting the Guide Bush

- The 18mm guide bush (1) is fitted into the bracket (2) which is fastened to the router's base from beneath using the M5 countersunk machine screw (3) supplied.
- The guide bush height (projection) can be adjusted by loosening the screw (4) using a small flat head screwdriver and moving bush up or down.
- Once set tighten grub screw.
- Fit dust spout/guard.



Routing with a Template

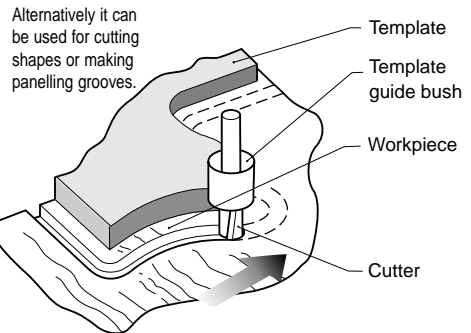
The guide bush is used in conjunction with a template when the routing operation is repetitive or the workpiece is complex in shape. The template is fixed to the upper surface of the workpiece. A cutter is chosen with a diameter which will pass through the centre of the bush leaving enough clearance. The cutter can be straight or shaped. The laminate trimmer can then be guided around the template so that the shape of the template will be replicated.



Using a template to rout an edge. Dust spout/guard not shown fitted for clarity.

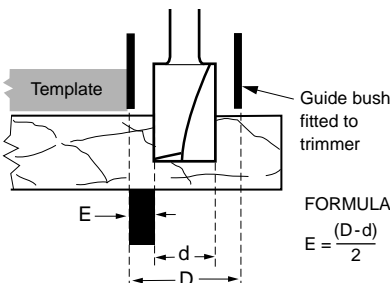
Making the Template

The template should be cut from 6mm or 1/4" MDF, plywood or plastic to the shape required. The guide bush offset needs to be allowed for when calculating the shape of the template. The template must be smaller by an amount equal to the difference between the 'outer edge of the guide ring' and the 'outer edge of the cutter'. See below for the offset calculation. The edge of the template must be free of imperfections as these will be replicated in the final workpiece.

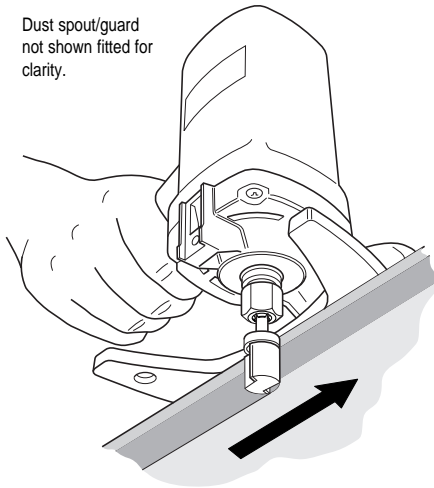


IMPORTANT!
Maximum cutter diameter for use with 18mm guide bush is 11mm.

Calculations for template offset



Bearing Guided Cutters



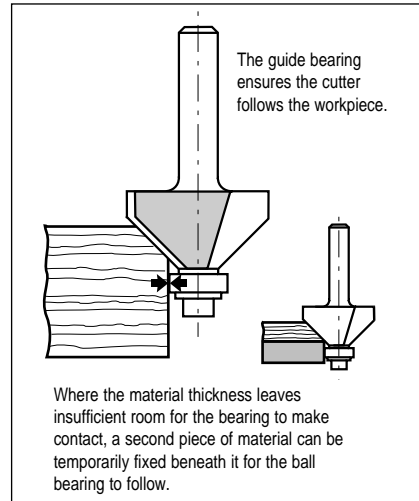
- Fit dust spout/guard.
- Fit the bearing guided cutter into the collet. The cutter diameter must not exceed 23mm.
- Place laminate trimmer onto the workpiece.
- Set height of cutter by adjusting the knurled nut and then tightening the locking knob.
- Switch on the machine.
- With the bearing of the cutter running along board edge, trim the edge of the workpiece by moving the laminate trimmer in the direction shown.
- A continuous motion should be used to prevent burning of the workpiece. When possible, take a number of passes at increased cutter depths. A light final pass will produce a good finish.
- When complete, retract the carriage by releasing the locking grip knob.
- Switch off the laminate trimmer.

Ball Bearing Guided Cutters

Edge profiling and shaping cutters are available with a bearing fitted to the end. This enables shaped or straight workpieces to be trimmed.

The edge must be free from imperfections as these will be reflected in the finish of the mould.

With certain shapes such as the chamfer cutter below, increasing the depth of cut will produce a larger chamfered edge.



IMPORTANT!

- Keep downward pressure on the base to prevent tipping.
- The dust spout/guard must be fitted at all times.

MAINTENANCE AND CARE



Lubrication

- The bearings of the machine need no lubrication, as they are sealed.
- Keep the cooling vents on the motor housing clean and unobstructed at all times. Blow out any dust and dirt at regular intervals.
- Visually check the carbon brushes. In the event of excessive sparking, they may need changing.
- After about 40 operating hours inspection by a authorised Trend service agent is recommended.



Cleaning

- Keep the machine clean at all times. Some maintenance products and solvents may damage the plastic parts, these include products containing Benzene, Trichloroethyle Chloride and Ammonia.
- Never use any caustic agents to clean the plastic parts.

Router Cutters

- Please ensure that your cutters are always sharp and well maintained. This will place less load on the motor, increase the working life of the machine and give a perfect cut. T.C.T. cutters must be treated especially carefully, because their cutting edges are brittle and could chip if they are mishandled or dropped.
- You will find a large selection of cutters and accessories in the latest Trend Routing Catalogue.



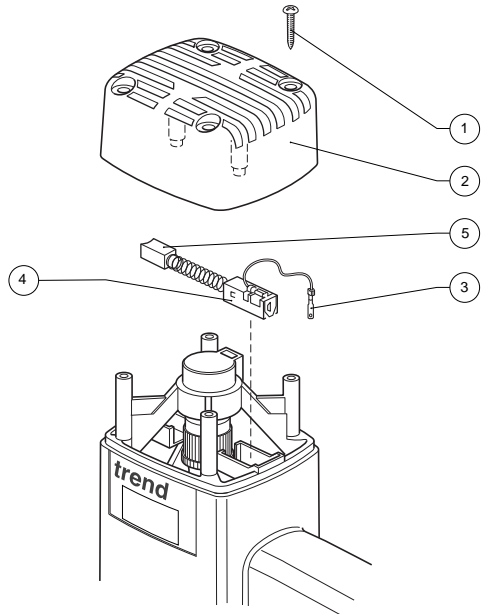
IMPORTANT!

Ensure machine is isolated from power supply.



IMPORTANT!

How to change the carbon brushes.



IMPORTANT!

It is advisable to have the brushes replaced by an authorised Trend service agent. The router will also be given a thorough inspection.

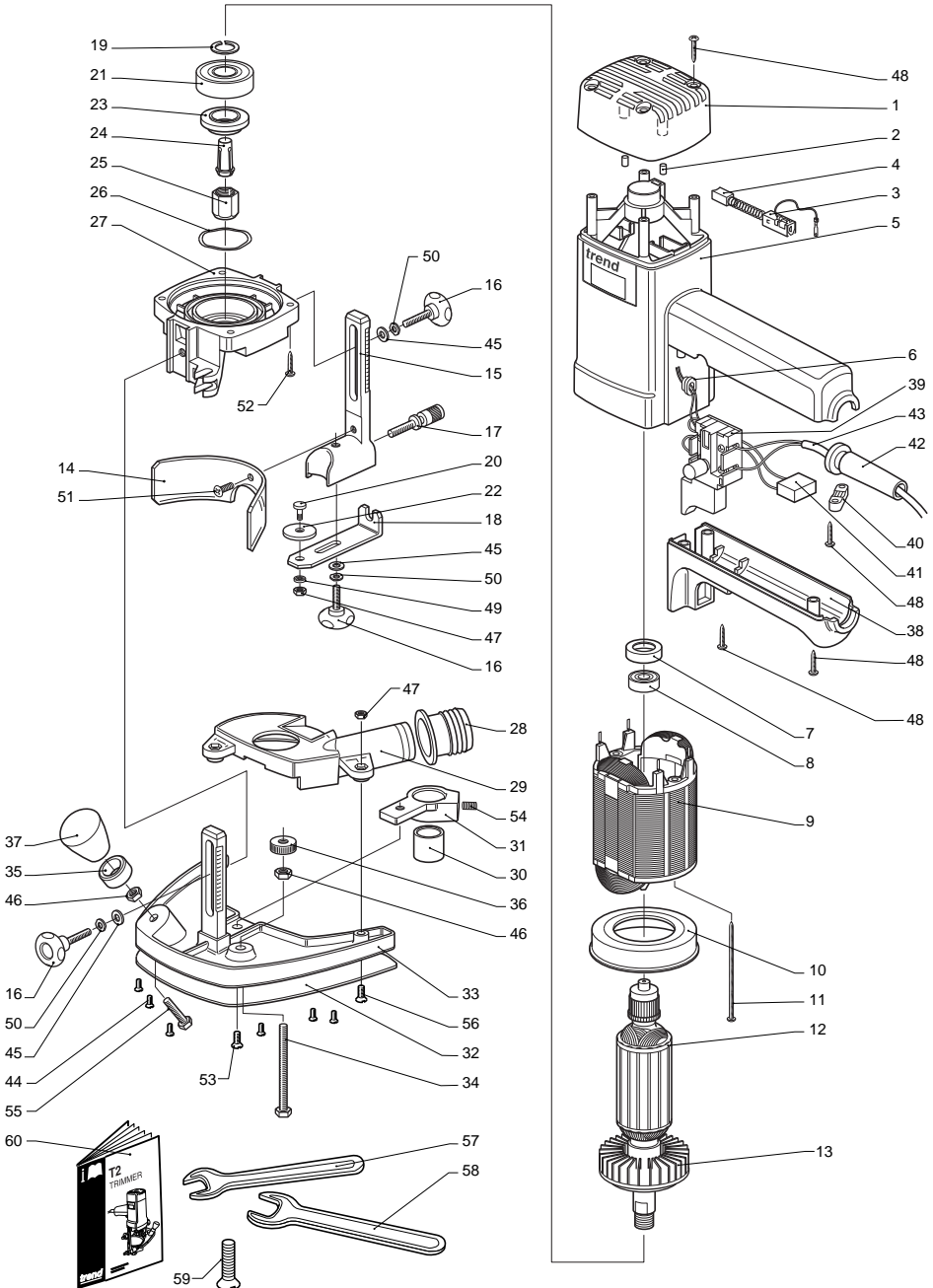
- After undoing the four screws (1), take off the cover (2).
- Unclip the wire (3) and remove brush holder (4), replace the carbon brush (5) and re-insert.
- Always use original T2 spare parts.

T2 - SPARE PARTS LIST			v1.0 05/2002
Item	Qty	Description	Ref.
1	1	Top Vent	WP-T2/001
2	2	Rubber Pin	WP-T2/002
3	2	Brush Holder	WP-T2/003
4	2	Carbon Brush 230V (1 pair)	WP-T2/004
5	1	Stator Housing	WP-T2/005
6	1	Housing plug	WP-T2/006
7	1	Bearing Cover	WP-T2/007
8	1	Top Bearing 7mm x 19mm x 6mm 607ZZ	WP-T2/008
9	1	Field 230V	WP-T2/009
10	1	Deflector Baffle	WP-T2/010
11	2	Machine Screw Pan M4 x 70mm Pozi	WP-T2/011
12	1	Armature 230V	WP-T2/012
13	1	Fan	WP-T2/013
14	1	Copy Follower Deflector	WP-T2/014
15	1	Copy Follower Cast Bracket	WP-T2/015
16	3	Thumb Knob M6 x 20mm	WP-T2/016
17	1	Copy Follower Adjustment Screw M6	WP-T2/017
18	1	Copy Follower Angled Bracket	WP-T2/018
19	1	Bearing Spacer	WP-T2/019
20	1	Copy Follower Fixing Screw	WP-T2/020
21	1	Bottom Bearing 17mm x 35mm x10mm 6003ZZ	WP-T2/021
22	1	Copy Follower Disc 20mm x 6mm x 3mm	WP-T2/022
23	1	Bearing Cover	WP-T2/023
24	1	Collet 6.35mm (T2)	CLT/T2/635
	1	Collet 8.0mm (T2/EURO)	CLT/T2/8
25	1	Collet Nut	CLT/NUT/T2
26	1	Ring 28mm x 34mm x 0.5mm	WP-T2/026
27	1	Lower Bearing Housing	WP-T2/027
28	1	Dust Spout Adapter	WP-T2/028
29	1	Dust Spout/Guard	WP-T2/029
30	1	Guide Bush Tube Type 18mm Dia x 18mm Long	GB/T2/18
31	1	Guide Bush Holder Casting	WP-T2/031
32	1	Phenolic Base Slider	WP-T2/032
33	1	Base Casting	WP-T2/033
34	1	Set Screw Hex M6 x 60mm	WP-T2/034
35	1	Grip Knob Spacer	WP-T2/035
36	1	Knurled Nut M6	WP-T2/036
37	1	Grip Knob M6	WP-T2/037
38	1	Handle Cap	WP-T2/038
39	1	Switch 230V	WP-T2/039
40	1	Cable Clip	WP-T2/040
41	1	Condenser	WP-T2/041

T2 - SPARE PARTS LIST			V1.0 05/2002
Item	Qty	Description	Ref.
42	1	Cable Guard	WP-T2/042
43	1	2 Core Cable With Plug 230V UK (T2)	WP-T2/043
	1	2 Core Cable With Plug 230V Euro (T2/EURO)	WP-T2EURO/043
44	6	Machine Screw Csk M4 x 8 Pozi	WP-SCW/54
45	3	Washer 6.5mm x 12mm x 1.8mm	WP-WASH/11
46	1	Nut Hex M6	WP-NUT/06
47	3	Nut Hex M5	WP-NUT/06
48	7	Screw Self Tapping 4.8mm x 19mm Pozi	WP-T2/048
49	1	Star Washer M5	WP-WASH/39
50	3	Spring Washer M6	WP-T2/050
51	1	Machine Screw Pan M4 x 8mm Pozi	WP-T2/051
52	4	Screw Self Tapping 4.8mm x 22mm Pozi	WP-T2/052
53	1	Machine Screw Csk M5 x 12mm Slot	WP-SCW/71
54	1	Grub Screw M5 x 10mm Slot	WP-T2/054
55	1	Set Screw Hex M6 x 25mm	WP-T2/055
56	2	Machine Screw Csk M5 x 20mm Slot	WP-SCW/72
57	1	Spanner 15mm A/F	SPAN/15
58	1	Spanner 17mm A/F	SPAN/17
59	3	Machine Screw Csk M6 x 16mm Slot	WP-SCW/26
60	1	Manual	MANU/T2

T2 SPARE PARTS DIAGRAM

v1.0 05/2002



TECHNICAL DATA

Voltage	UK & Eire	230V
Ampage		2.1A
Power input		450W
No load speed		24,000min-1
Router carriage		1 column
Router carriage stroke		40mm
Collet size	UK & Eire	1/4 inch (6.35mm)
	Europe	8mm
Cutter diameter, max		23mm
Weight		1.7kg
Fuse	UK & Eire	230V 13A in plug
	Europe	230V 13A in mains

Guarantee

- The machine carries a manufacturers guarantee in accordance with the conditions on the enclosed guarantee registration card.

Recycling

- Machine, accessories and packaging should be sorted for environmentally friendly recycling.

CE DECLARATION OF CONFORMITY

Laminate Trimmer T2 & T2/EURO

We declare under our sole responsibility that this product is in conformity with the following standards of standardised documents:
EN 50144, EN 55014, EN 60555, in accordance with the 73/23/EEC regulations. 89/336/EEC (as of 1/1/1996). 89/392/EEC.

 Trend Machinery & Cutting Tools Ltd.

Level of sound pressure according to 86/188/EEC & 89/392/EEC, measured according to EN 50144:

Lpa (sound pressure) 75.1 dB(A)1
Lwa (acoustic power) 88.1 dB(A)2



INFORMATION ON NOISE/VIBRATION

The noise level when working can exceed 85 dB(A).
Wear ear protection!

Weighted root mean square acceleration value according to EN 50144:

<2.5 m/s² (hand arm method)

Stephen Phillips

Managing Director
Stephen Phillips

trend[®]
routing technology

Trend Machinery & Cutting Tools Ltd.
1/5/2002



RECYCLABLE

Trend Machinery & Cutting Tools Ltd.

Odhams Trading Estate St Albans Road
Watford WD24 7TR England

Enquiries: _____ 0800 487363

Technical Support: _____ 0044 (0) 1923 224681

Fax: _____ 0044 (0) 1923 236879

Email: _____ mailserver@trendm.co.uk

WWW: _____ www.trendmachinery.co.uk