



**CraftPro
Panel Raiser
with Back Cutter**

**C170A,
C183B &
C184A**



INST/C170A v1.0

trend[®]
routing technology

Please
read carefully
before use

**CRAFTPRO
PANEL RAISER WITH BACK CUTTER
REF. C170A, C183B & C184A**

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).



Before use of cutter, please ensure it is correctly assembled and locking nut is fully tightened.

INTENDED USE

This cutter is intended to be used in a fixed head variable speed router with a suitable collet fitted to cut natural timbers to create a panel for a panelled door. The router must be in a fixed head position, either overhead or in a table routing machine. The router must have a variable speed facility to reduce the speed accordingly. The cutter has a back cutter fitted to give a constant tongue thickness. The cutting edges must be staggered to each other to reduce the cutting impact.

Material thickness:	C170A	min. 16mm*	max. 25.4mm
	C183B	min. 18mm*	max. 25.4mm
	C184A	min. 21mm*	max. 25.4mm

Tongue thickness:	6.3mm
Panel reveal size:	C170A/C183B 36.4mm
	C184A 34.9mm

*The minimum thickness does not require the back of the panel to be moulded by the back cutter.



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.

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

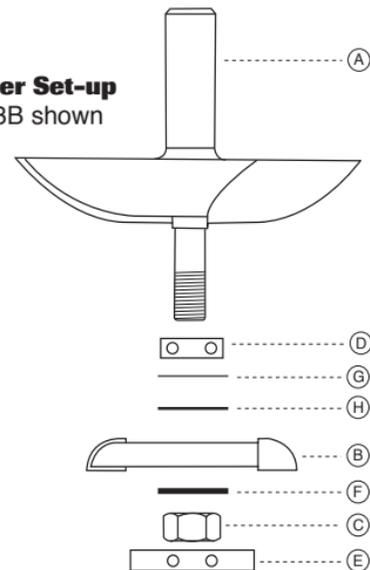
ITEMS REQUIRED

- Variable speed heavy duty router with suitable collet fitted.
- Router table, with suitable cutter aperture diameter, complete with all safety devices.
- 13mm A/F spanner.
- Hand tools.

ITEM ENCLOSED & DESCRIPTION OF PARTS

- A. Panel raiser with spindle arbor **x1**
- B. Back cutter **x1**
- C. Nut 13mm A/F **x1**
- D. Ball bearing 16mm dia. **x1**
- E. Ball bearing 31.75mm dia. **x1**
- F. Washer 1.0mm **x1**
- G. Shims 0.05mm **x1**
- H. Shims 0.1mm **x1**
- I. Instructions **x1**

**Cutter Set-up
C183B shown**



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

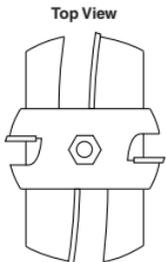
OPERATION



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.

Loosen locking nut, rotate the back cutter by 90° to the panel cutter and then retighten nut.

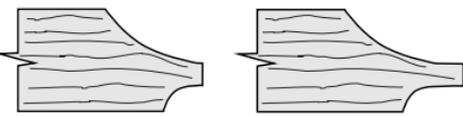
When using these sets, shallow passes must be taken at all times. This can be achieved by adjusting the back fence.



The profile will require shallow passes to achieve the full depth. As the tool has a back cutter fitted the shallow depth of cuts cannot be achieved by raising the cutter height, instead the back fence must be moved back after each cut.

The tools Ref. C183B and C184A include a larger bearing which can be used to take a shallower cut and also create a smaller reveal of 28.6mm and 27mm respectively.

Reveal C183B shown



Reveal with 31.8mm bearing

Reveal with 16mm bearing



The material being cut will need to be supported and held securely.



Recommended speed is 12,000 rpm.



Ensure working position is comfortable and component is clamped securely. Consider working environment before using tools.



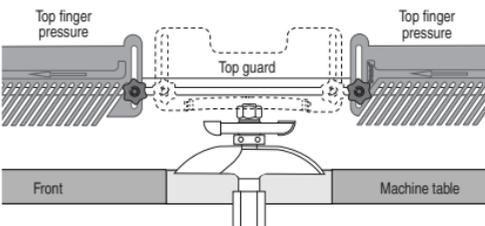
Regularly check knobs, handles and locking nuts are tight.

Router Table Set-up

Due to the cutter height, the top safety pressure which is directly above the tool will need to be moved away from the tool, or moved forward of the tool if possible, so that it does not foul the back cutter.

Extra top safety pressures will be needed to be placed on the back fence either side of the guard.

The router table back fence sliding cheeks must be set according to the manufacturers instructions to reduce the gap.



Before making any cuts ensure the cutter does not foul the safety pressures or top guard. Extra top safety pressures will be needed to be placed on the back fence either side of the guard.

Cutting the Panel

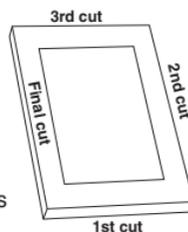


The back fence must be set forward for the first pass and then gradually moved back to allow the mould depth to be routed.

The panel should be flat, if the panel is bowed the tongue thickness will be less than 6.3mm.

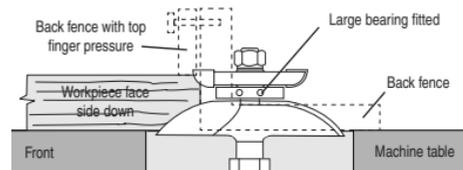
The minimal number of passes is three per panel edge.

The panel must be routed in a series of passes. The panel edges should be routed in a sequence, first cut across the grain, second cut along the grain, third cut across the grain and final cut along the grain. In a table the panel is machined face side down.

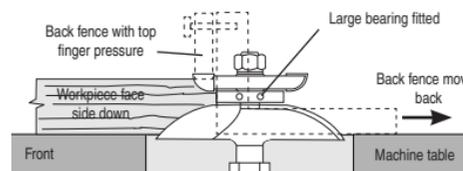


Always feed timber against the direction of cutter rotation. Always take a number of passes to improve finish, ensure longer cutter life and to reduce load on tool.

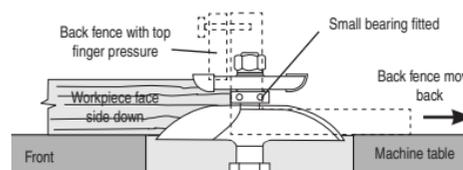
1st Pass



2nd Pass



3rd Pass



SPARE PARTS

Please use only Trend original spare parts and accessories.

Item	Qty.	Desc.	Ref. (1 off)
B	1	Back Cutter	SP-C170A, SP-C184A
C	1	Replacement Arbor Nut	ANUT/C170A
D	a	Bearing 16mm Dia.	BB16
E	1	Bearing 31.75mm Dia.	BB318
	1	Spacer Set	SPACER/8
I	1	Instructions	INST/C170A

MAINTENANCE

Please use only Trend original spare parts and accessories.

The accessory has been designed to operate over a long period of time with the minimum of 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

- 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.
- 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 for more safety advice.



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