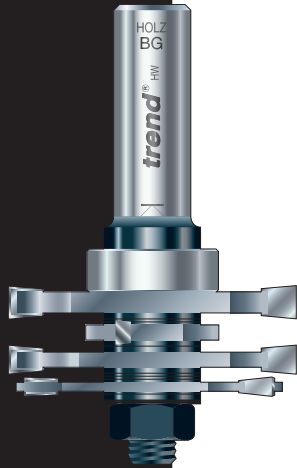




Quadriset[®]
QUAD



Please read carefully before use

QUADRISET[®] MULTI-PURPOSE SLOTING CUTTER SET REF. QUAD

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 98/37/EC (identified by the CE marking on the power tool).

INTENDED USE

This cutter is intended to enable excellent results in the following applications:

Grooving/dadoing with single cutter

Widths: 3.2mm (1/8"); 4.0mm (5/32"),
4.8mm (3/16"), 6.35mm (1/4").

Grooving with cutter combinations

Achieving continuous width from 5.7mm to 18mm in increments of 0.1mm.

Tongue and Groove along wood lengths

For jointing, aligning or cladding.

Tongue and Groove frames -

For doors, windows, pictures etc.

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
- Router table or overhead router stand
- Hand tools



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



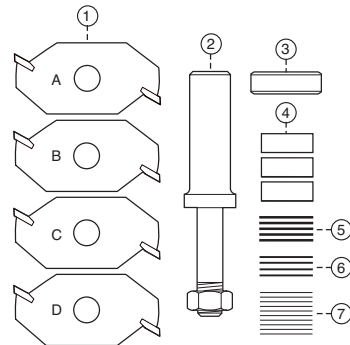
Recommended speed is 24,000rpm

PARTS SUPPLIED IN SET

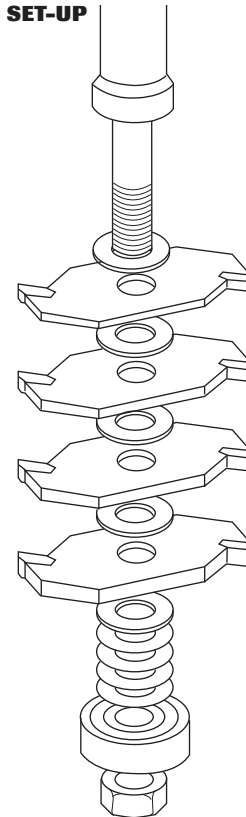
see diagrams

1. Single cutters marked:
A - width 3.2mm, B - width 4.0mm
C - width 4.8mm, D - width 6.3mm **x1**
2. Arbor 13mm A/F **x1**
3. Bearing
22mm diameter 7mm width **x1**
4. Spacer 6.0mm **x3**
5. Washer 1.0mm **x5**
6. Shim 0.5mm **x4**
7. Shim 0.1mm **x10**

All spacers, washers and shims have diameter 16mm and bore 8mm.



QUAD SET-UP



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.

© Trend Machinery & Cutting Tools Ltd. 2007 E&OE
© All trademarks acknowledged

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: _____ enquiry@trendm.co.uk
Web: _____ www.trend-uk.com



5 027654 319338 >



RS 28982
Stockholding
& Supply



RECYCLABLE

trend[®]
routing technology

INST/QUAD v5.0

OPERATION



GROOVING WITH SINGLE CUTTER

When using one cutter only, the following fixed widths can be performed:

3.2mm (1/8") with cutter A

4.0mm (5/32") with cutter B

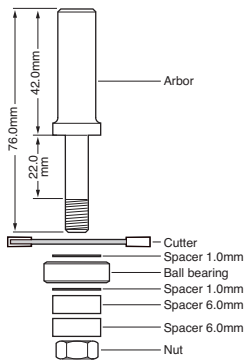
4.8mm (3/16") with cutter C

6.35mm (1/4") with cutter D

Ensure that the cutter is assembled for correct direction of rotation (marking of thickness is facing arbor shaft)

The ball bearing may be above or below the cutter, but the washers must always be on both sides of the ball bearing to enable its free rotation.

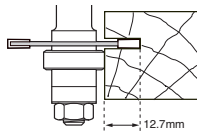
The overall length of the assembly must be at least 22mm in order to be properly secured by the nut.



Typical assembly with one cutter

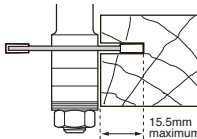
WORKING WITH BALL BEARING

Normal use with ball bearing will give a constant depth of 12.7mm (1/2").



WORKING WITHOUT BALL BEARING

If depth other than 12.7mm is required, remove the ball bearing and use the fence. Maximum depth will be 15.5mm. The wood should not touch the spacers or shims.



GROOVING WITH COMBINED ASSEMBLIES

By assembling two cutters or more, every width of groove or dado can be achieved from 5.7mm to 18mm in increments of 0.1mm. The cutters should be assembled square to each other to facilitate cutting and to enable overlapping of widths.

1. Total thickness of shims required to achieve full cutting width for combined assembly

A	Shims max. 0.8mm	3.2mm (1/8")
B	Shims max. 0.8mm	4.0mm (5/32")
C	Shims max. 1.1mm	4.8mm (3/16")
D	Shims max. 1.4mm	6.35mm (1/4")

2. Combination Limits

Combination of Cutters	Width of Cut Min. - Max.
A + B	5.6 - 7.1mm
A + B	6.0 - 8.0mm
A + D	7.3 - 9.5mm
B + C	6.8 - 8.7mm
B + D	8.1 - 10.2mm
C + D	8.6 - 11.1mm
A + B + C	8.5 - 11.9mm
A + B + D	9.8 - 13.4mm
B + C + D	10.6 - 15.0mm
A + B + C + D	12.3 - 18.0mm

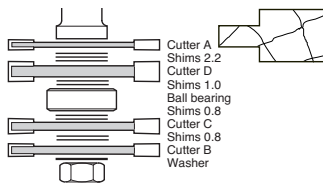
3. Recommended combinations for varying cutting widths For intermediate cutting widths, remove or add shims accordingly.

Width (mm)	5.7	6	7	8	9	10	11	12	13	14	15	16	17	18
Cutter	A	A	A	A	C	C	C	B	B	A	A	A	A	A
Shims	0	0.3	1.0	0.7	0.4	1.4	2.4	0.4	1.0	0.4	0.4	1.4	1.4	1.5
Cutter	B	B	C	D	D	D	D	C	C	B	B	B	B	B
Shims								1.0	1.4	0.3	1.3	1.3	1.3	1.8
Cutter								D	D	C	C	C	C	C
Shims										1.0	1.0	1.0	2.0	2.5
Cutter										D	D	D	D	D

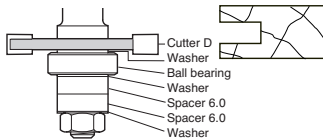
TONGUE AND GROOVE CUTTING

Tongue and groove cutting is used mainly for aligning and framing. The Quadriset® can be used for these purposes for wood thickness from 9mm (using the 3.2mm groover) to 22mm (using the 6.3mm groover). When working with the ball bearing and the 6.35mm cutter, the limits of the wood thickness will be 14mm to 22mm, the groove being in the centre.

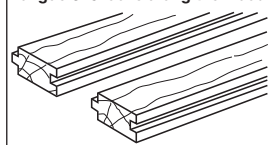
Cutting the Tongue



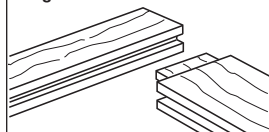
Cutting the Groove



Tongue & Groove along the wood



Tongue & Groove frame corner



If tongue and groove cutting is to be performed on wood thinner than 14mm (the lowest limit for a 6.3mm groove cut in the centre), it can be carried out with the other cutters according to the following table:

Wood 9mm and more		Wood 10mm and more		Wood 11mm and more	
Groove	Tongue	Groove	Tongue	Groove	Tongue
3.2mm	C	4.0mm	C	4.8mm	C
A	D	B	D	C	D
				7.3mm	D

SPARE PARTS

Description	Ref.
Groover A 3.2mm	SP-QUAD/18
Groover B 4.0mm	SP-QUAD/532
Groover C 4.8mm	SP-QUAD/316
Groover D 6.3mm	SP-QUAD/14
Replacement Arbor	33/30X1/2
Bearing 22mm Ø	BB22
Replacement Arbor Nut	ANUT/33/30
Spacer Set	SPACER/8

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 (n_{max}) 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 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.