



Biscuit Jointer Set 342



INST/342 v7.1

trend[®]

routing technology

Please read carefully before use

BISCUIT JOINTER SET REF. 342

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 set can be used both in a portable router or in a fixed position, either mounted overhead or inverted in a table.

Biscuit jointing is a strong, fast and accurate way to join hardwoods, softwood, plywood and composite boards edge to edge and as a corner joint.

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.

Ensure working position is comfortable and component is clamped securely. Please keep children and visitors away from tools and work area. All tools have a residual risk, so must therefore be handled with caution.

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.
- Hand tools.
- Jig making equipment & materials.
- 11mm A/F spanner.

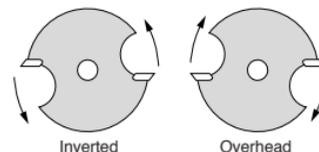
ITEMS ENCLOSED & DESCRIPTION OF PARTS

- A. Arbor **x1**
- B. Nut 11mm A/F **x1**
- C. Groover 40mm dia. x kerf 4mm **x1**
- D. Ball bearing guide, one of the following to be fitted:
15mm dia. sleeved **x1**
19mm dia. **x1**
23mm dia. sleeved **x1**
- E. Spacer 5.1mm for 342X1/4TC **x1** for 342X1/2TC **x3**
- F. Step washer 1/4" bore **x1**
- G. 3mm spacer for 342X1/4 & 8MMTC **x3** for 342X1/2TC **x2**
- H. Instructions **x1**

ASSEMBLY

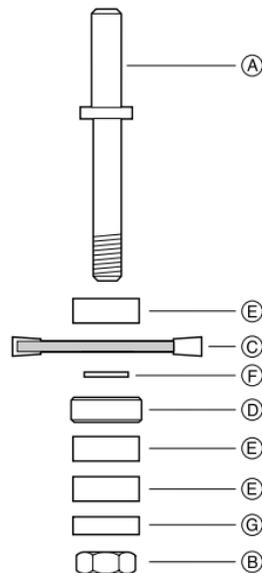
The set is supplied unassembled. Depending on the biscuit size used, the relevant ball bearing should be fitted onto the arbor, this bearing will then automatically set the depth of groove. Ensure the step washer is fitted in the recess side of the sleeved ball bearing and the groover is assembled the correct way round ie, to match the spindle rotation.

Plan view of rotation



Wherever possible please fit groover on the spindle towards the shank end. Fitting of the groover at the nut end will allow thicker material to be machined, but care must be taken to avoid excessive side load.

Suggested Biscuit Jointer set-up for 342X1/2TC



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

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.

© Trend Machinery & Cutting Tools Ltd. 2014 E&OE
© All trademarks acknowledged

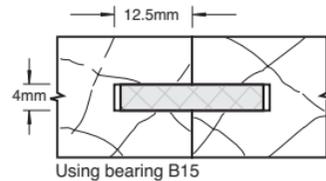
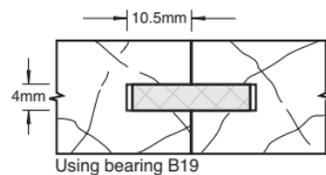
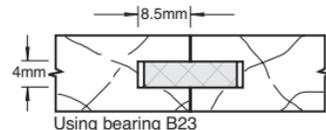
Trend Machinery & Cutting Tools Ltd.

Odhams Trading Estate St. Albans Road
Watford WD24 7TR England
Tel: 0044(0)1923 249911
technical@trendm.co.uk
www.trend-uk.com



RECYCLABLE

Cross-section of Biscuit Joints



Plan of Biscuits

No. 0 biscuit dimensions:
47.5mm x 15.5mm x 4mm
suitable for 8-12mm board

No. 10 biscuit dimensions:
53mm x 19mm x 4mm
suitable for 13-18mm board

No. 20 biscuit dimensions:
60mm x 23mm x 4mm
suitable for 19mm+ board

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.

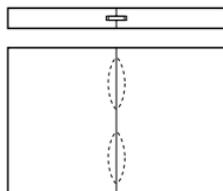
Prepare the timber to the required thickness.

Assemble set as instructions using the correct ball bearing to suit the size of biscuit required. Ensure nut is tight.



Recommended speed is 24,000 rpm.

Edge to Edge Joints



When biscuit jointing using a hand held router, the base of the machine is run on the face side for both joints.

The face sides of both sections of timber should be marked by pencil where each biscuit is required. The centres of each biscuit pocket should be between 150mm to 250mm. The biscuits should also be no less than 50mm from the ends of the timber.

The cutter height is set to cut on the centre line and plunges until the ball bearing touches the edge of the timber.

Whilst cutting the groove, the router should be moved forward to make the groove long enough to insert the biscuit. The finished edge will have a series of pockets for each biscuit.

A continuous groove can also be routed, but although quicker to cut, the joint would be weaker.

Care must be taken not to release the plunge of the router if the router base aperture is less than 40mm, as the tooling may be damaged.

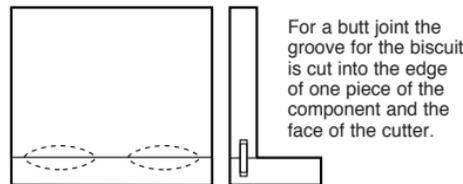
When using the biscuit jointing set on a fixed head router, the same method is used as before, but a different method of setting the length of the cut is required. The material should also be swung into the cutter.

An easy method to judge the pocket length on an inverted router is to mark the end positions of the pocket on the top down pressure clamp.

Butt Joint (or Corner Joint)

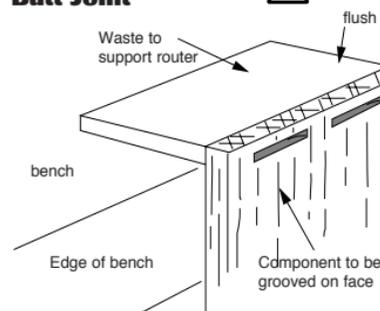


The edge cut is carried out using the same methods as mentioned for edge to edge joints. The face cut is made by clamping the component on to the edge of a workbench and butting up to it a piece of waste material. The top edge of the component must be flush with the waste material. The waste material will give better support for the hand router. The grooving cuts are then carried out as before.



As one part of the joint is on the face of the material, the depth of the groove should not be too deep so as to weaken the component, the correct size of biscuit should be used to take this into account.

Method to Rout Pocket for Butt Joint



Gluing Up

After the grooves are routed, the joint should be dry cramped to check for fit. A water based glue (PVA) is used with the biscuit in the pocket, which will expand as moisture is absorbed. The boards are simply clamped together until the glue is dry.

SPARE PARTS

Please use only Trend original spare parts and accessories.

Item	Qty	Description	Ref. (1 off)
A		Arbor 1/2" shank	33/60X1/2
		Arbor 1/4" shank	33/60X1/4
C		Slotter 40mm x 4.0mm TCT	SL/GG
D		Bearing 15.0mm dia.	B15
		Bearing 19.0mm dia.	B19
		Bearing 23.0mm dia.	B23
F		Step Washer 1/4" bore	BWASH/14
B		Replacement arbor nut	ANUT/33/60
H		Instructions	INST/342

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

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 (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.
- 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.



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.