



# CraftPro Biscuit Jointer C152



Please read carefully  
before use

## CRAFTPRO BISCUIT JOINTER CUTTER SET REF. C152

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 be used in a routing machine to cut a biscuit joint in wood and wood based material.

### 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

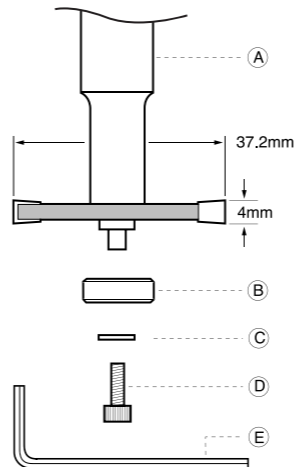
- Router with suitable collet fitted.
- Handtools.



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

### ITEMS ENCLOSED & DESCRIPTION OF PARTS

- Cutter **x1**
- Ball bearing guide, one of the following to be fitted:  
12.7mm dia. **x1**  
15.9mm dia. **x1**  
19.1mm dia. **x1**
- Washer **x1**
- Screw **x1**
- Hex key 2.5mm A/F **x1**
- Instructions **x1**



The set is supplied assembled with the B127A ball bearing fitted. Dependant on the biscuit size used, the relevant ball bearing should be fitted onto the cutter, this bearing will then automatically set the depth of groove.

### Plan of Biscuits

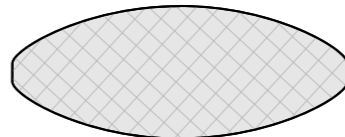
**No.0 biscuit dimensions**  
47.5mm x 15.5mm x 4mm  
suitable for 8mm - 12mm board



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



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



### 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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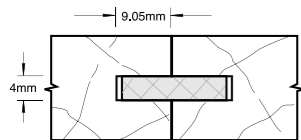
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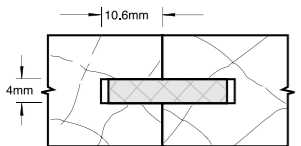


PTO

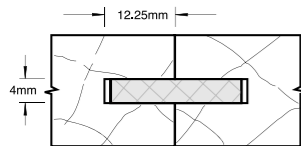
## Cross-Section of Biscuits Joints



Using bearing B19A



Using bearing B16A



Using bearing B127A

### 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 timber to the required thickness. Assemble cutter as per instructions using the correct ball bearing to suit the size of biscuit required. Ensure the hex screw is tight.



**Recommended speed is 18,000rpm.**

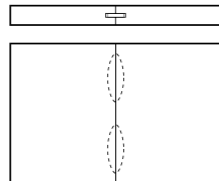
### Edge to Edge Joints



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 in pencil where each biscuit is required. The centre 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 all 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 38mm, as the tooling may be damaged.

When using the biscuit jointing set on a fixed head router, a different method of setting the length of cut is required.

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

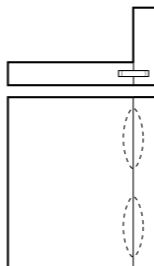
### Butt Joint (or corner joint)



For a butt joint, the groove for the biscuit is cut into the edge of one piece of the component and the face of the other.

The edge cut is carried out using the same method as edge to edge joints.

The face cut is made by clamping the component onto the edge of the workbench and butting up to a piece of waste material.

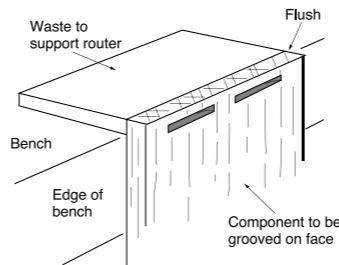


The top edge of the component must be flush with the waste material.

The waste material will give better support for the hand router. The grooving cuts are then carried out as before.



**That 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, and the correct size of biscuit should be used to take this into account.**



### 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.

| Item | Qty. | Desc.               | Ref. (1 off) |
|------|------|---------------------|--------------|
| B    | 1    | Bearing 12.7mm dia. | B127A        |
| B    | 1    | Bearing 15.9mm dia. | B16A         |
| B    | 1    | Bearing 19.1mm dia. | B19A         |
| D    | 1    | Screw               | SP-J         |
| C    | 1    | Washer              |              |
| E    | 1    | Hex Key 2.5mm A/F   |              |
| F    | 1    | Instructions        | INST/C151    |

## 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

1. 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.
2. Read and understand instructions supplied with power tool, attachment and cutter.
3. Current Personal Protective Equipment (PPE) for eye, ear and respiratory protection must be worn. Keep hands, hair and clothes clear of the cutter.
4. 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.
5. The maximum speed (n<sub>max</sub>) marked on tool or in instructions or on packaging shall not be exceeded. Where stated, the speed range should be adhered to.
6. 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.
7. 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.
8. Ensure all visors, guards and dust extraction is fitted.
9. The direction of routing must always be opposite to the cutter's direction of rotation.
10. Do not switch power tool on with the cutter touching the workpiece.
11. Trial cuts should be made in waste material before starting any project.
12. Repair of tools is only allowed according to tool manufacturers instructions.
13. 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](http://www.trend-uk.com/safety) for more safety advice.



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