

**Wadkin**

**INSTRUCTION MANUAL**

**Heavy Duty Spindle Moulder**

**Type BER 3**

**No. B505**

# HEAVY DUTY SPINDLE MOULDER

## TYPE BER 3

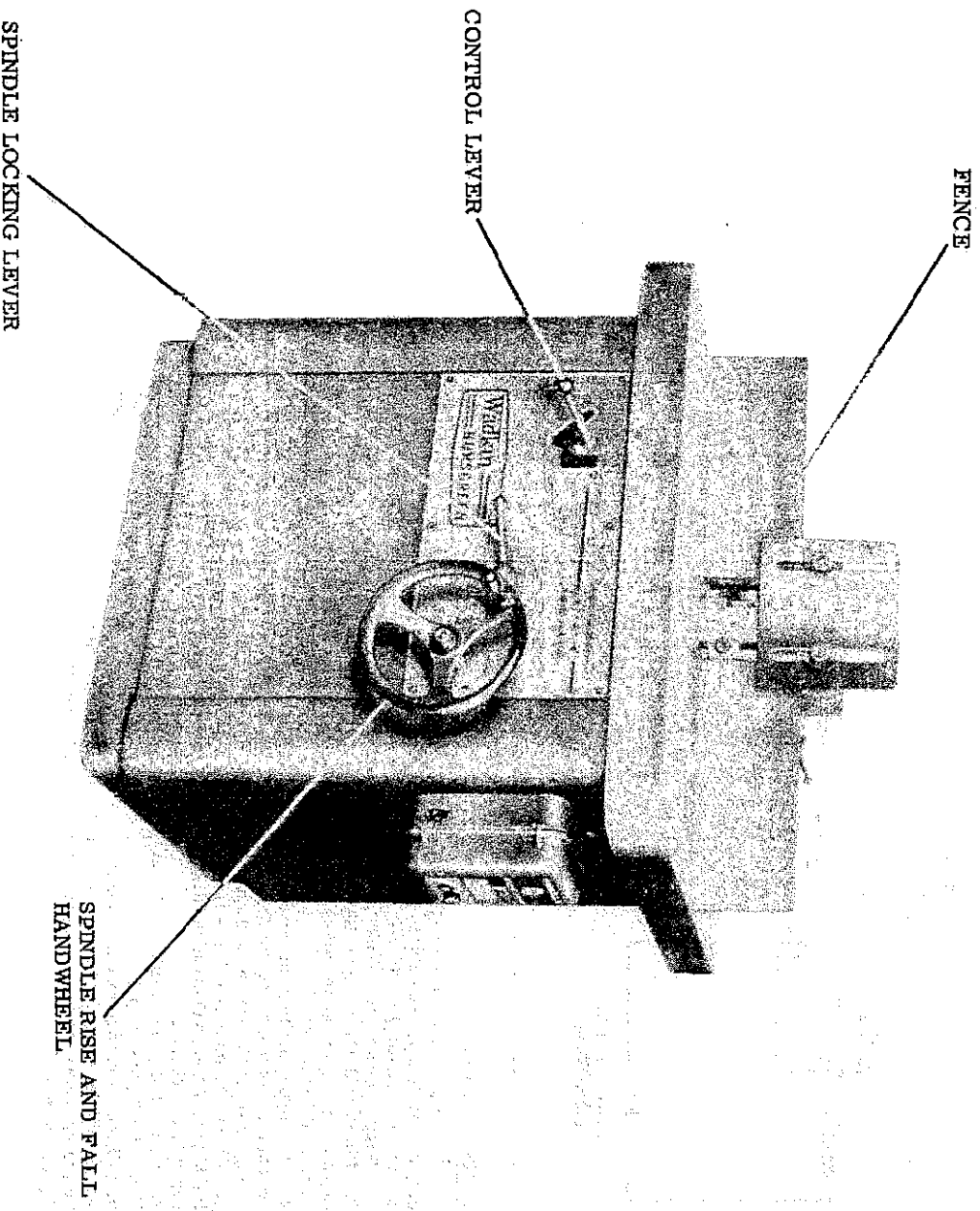


FIG. 1.

### SPECIFICATION

Diameter of top piece	1 1/4"	30mm
Optional diameters of top piece	1" and 30mm	915 x 815mm
Size of table	36" x 32"	150mm
Speed of spindle	2, 800, 4, 500, 5, 600 and 8, 000rpm.	840mm
Rise and fall of spindle	6"	80, 120, 175, 230mm
Table height	33"	150 x 400mm
Three circular table plates giving openings of	3 1/4", 4 1/4", 7", 9"	
Size of fence plates	6" x 16"	
HP of motor		5 1/2 (7 1/2 optional)
Speed of motor, 50 cycles		3, 000 rpm
Speed of motor, 60 cycles		3, 600 rpm
Floor space	36" x 36"	
Approx. net weight	780 lb	
Approx. gross weight	1, 000 lb	
Approx. shipping dimensions	46 cu. ft.	
		915 x 915mm
		350 kg
		450 kg
		1, 30m. 3

**INSTALLATION**

Remove protective coating from bright parts by applying a cloth soaked in paraffin, turpentine or other solvent.

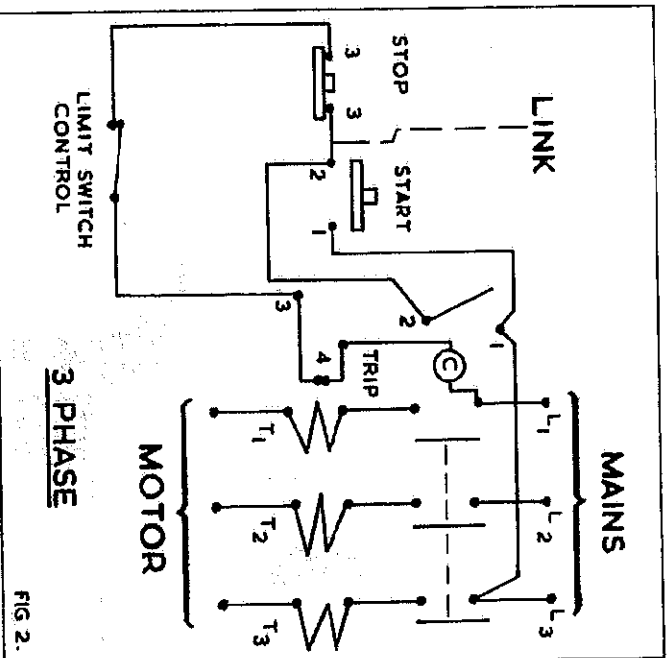


FIG. 2.

**WIRING DETAILS**

The motor and control gear have been wired in before despatch all that is required is to connect the power supply to the starter or isolator when fitted.

- Points to note when connecting to power supply:-
1. Check that the voltage, phase and frequency correspond to those on the motor plate, also the correct coils and heaters are fitted to the starter.
  2. It is important that the correct size of cable is used to give the correct voltage at the starter. Too light a cable will give a voltage drop at the starter and may damage the motor.
  3. Check the main line fuses are of the correct capacity. See list below. When an isolator is fitted, the fuses are of the correct capacity as received.
  4. Connect the line leads to the appropriate terminals. See Fig. 2 for 3 phase supply
  5. Check all connections are sound.
  6. Check the rotation of the motor for the correct direction. If this is incorrect, reverse any two of the line lead connections for 3 phase supply.

Voltage	Phase	H. P.	S. W. G. Tinned Copper Wire	Fuse Rating Amps
220	3	5 1/4	18	45
380/420	3	5 1/2	22	24
550	3	5 1/2	23	20
220	3	7 1/4	17	65
380/420	3	7 1/2	18	38
500	3	7 1/2	22	24

**LUBRICATION**

It is advisable to keep all bright parts covered with a thin film of oil to prevent rusting.

TYPE OF OIL RECOMMENDED POWER EM 125  
 TYPE OF GREASE RECOMMENDED SHELL ALVANIA 3  
 TYPE OF GREASE RECOMMENDED CASTROL-LEASE BRAKE  
 FOR BRAKE CABLE CABLE LUBRICANT

**FOUNDATION**

See Fig. 4. for bolt positions and clearances required. When installing the machine, level the table by packing under the feet. Foundation bolts are not supplied with the machine except by special order.

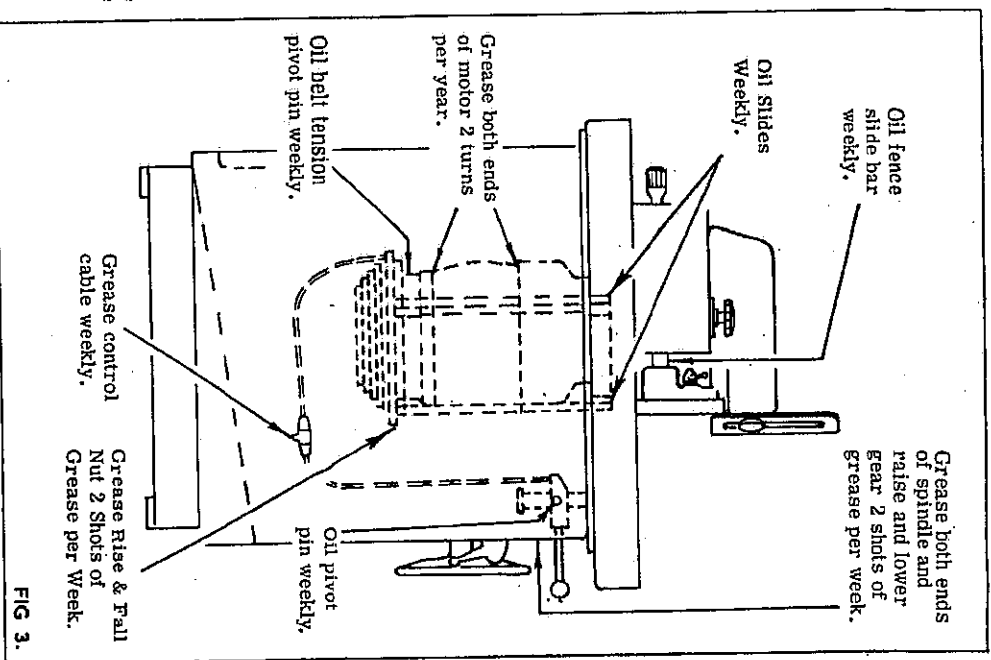


FIG. 3.

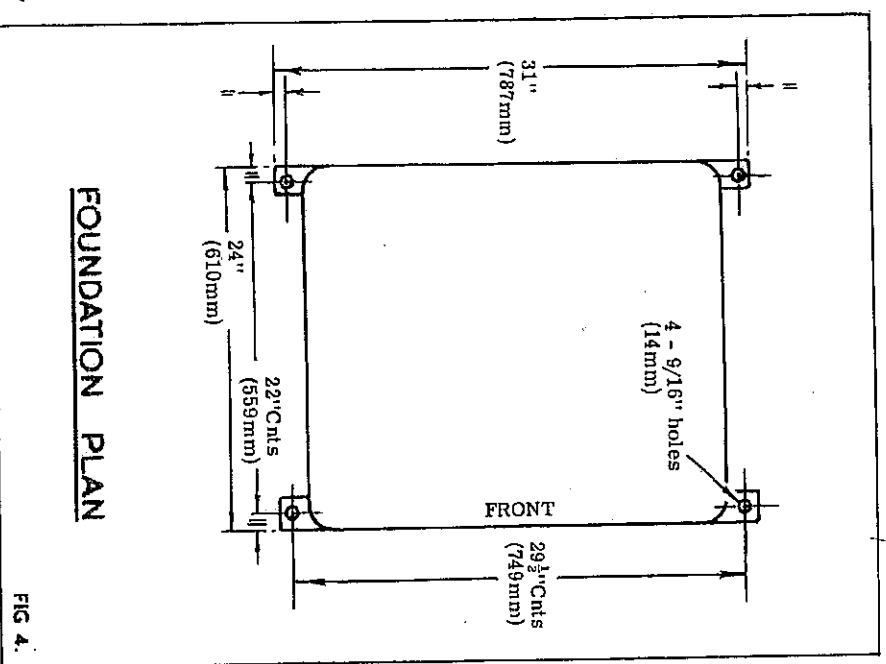


FIG. 4.

#### RAISE AND LOWER OF SPINDLE

The spindle rise and fall is by means of the handwheel "A" in Fig. 6 and operates through spiral gears giving maximum travel of 8" (152mm).

The spindle assembly can be locked at any height by means of the Locking Lever "B".

Whilst the rise and fall movement of the spindle provides an immediate adjustment of the cutter height, further adjustment outside the range of this can be affected by re-positioning the collars on the work spindle.

#### ADJUSTMENT OF BRAKE

The brake on the machine is pre-set before leaving the factory but, should the brake require adjustment due to normal wear, the undermentioned procedure should be followed:-

To adjust for wear, the hexagon locknuts on the end of the brake pull rod should be loosened off and adjusted gradually until the correct brake adjustment is obtained. The locknuts should then be re-tightened.

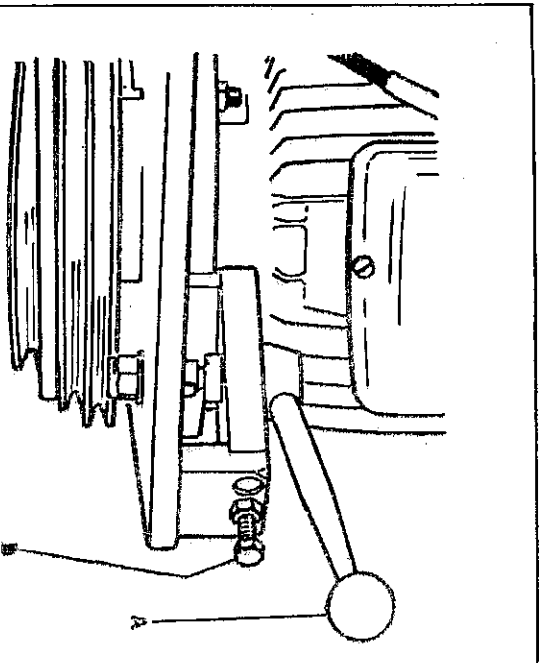


FIG. 5.

#### BELT TENSION

The machine is driven by an Alpha section vee belt from a 5HP (Std), 7½HP (Optional extra) flange mounted motor.

To change the spindle speed ensure that the control lever is in the "Free" position. Unlock the motor and release the belt tension by turning the hand lever "A" in Fig. 5 anticlockwise. Re-position the belt to give the required speed in accordance with the speed indicator plate fixed above the access door at the rear of the machine. Turn the hand lever "A" clockwise to automatically retension the belt and lock the motor.

The degree of belt tension is pre-set in our works but adjustment may be necessary within the life of the machine. To increase the tension, turn the screw "B" in Fig. 5 clockwise to decrease tension turn in opposite direction. Any adjustment should be made gradually until the required belt tension is reached.

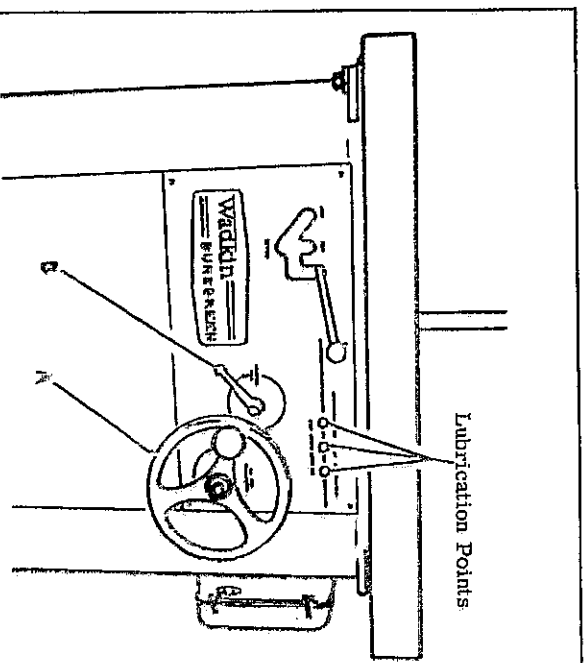


FIG. 6

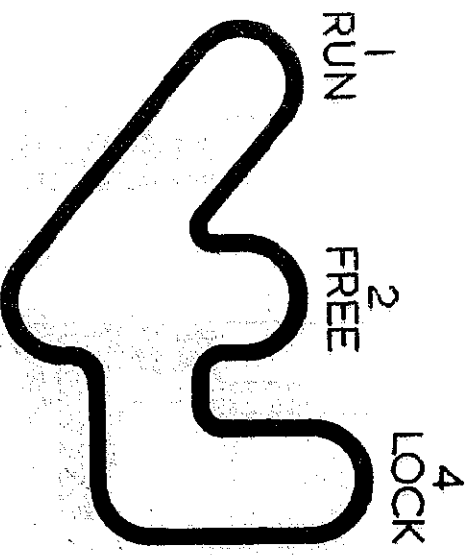


FIG. 7.

#### BURSGREEN CONTROL GATE

The control gate is clearly shown in Fig. 7 and has four positions.

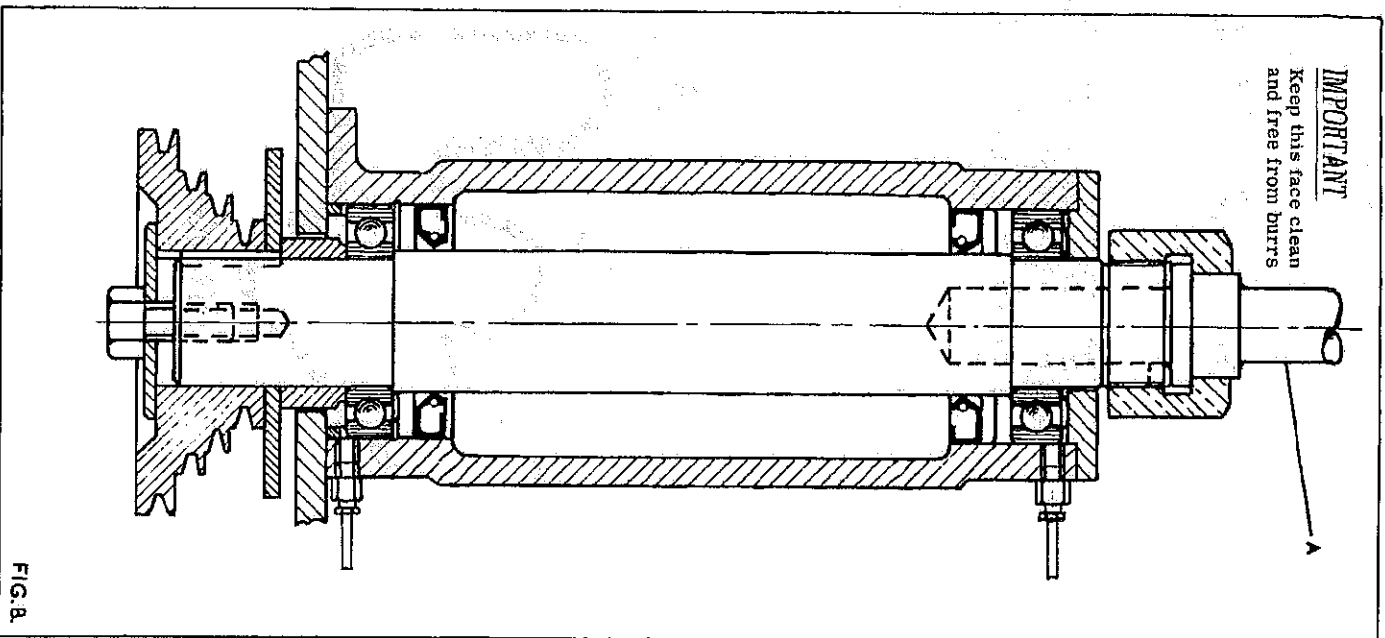
Position 1. "Run". The lever must be in this position before the motor will start.

Position 2. "Free". The lever must be in this position at all times when the machine is idle or being set up. Although the work spindle is quite free to rotate by hand for cutter setting, an automatic cut-out switch ensures that the motor cannot be accidentally started.

Position 3. "Brake". Movement of the lever from the "Run" to this "Brake" position automatically switches off the motor and light pressure on the lever operates an efficient spindle brake.

Position 4. "Lock". When the lever is in this position the motor is automatically cut-out and the main spindle is firmly locked to facilitate removing or re-fitting of the work spindle and cutter equipment. The lock is effected by a spring loaded plunger which engages in any of four positions.

If may be necessary to rotate the spindle slowly by hand to ensure that the plunger is fully engaged in one of these positions.



#### WORK SPINDLE INSTALLATION

The three removable table rings give table openings of 9", 7",  $4\frac{1}{2}$ " and  $3\frac{1}{2}$ " dia (229, 178, 121 and 83mm). The required table opening should be selected before proceeding to fit the work spindle. To insert the work spindle the undermentioned procedure should be followed:-

Insert the work spindle "A" in Fig. 8 into the main spindle through the table opening selected. Great care should be taken to ensure that the work and main spindle seatings are completely free from all burrs, dirt and rust. A thin film of oil should be placed on the work spindle seatings before inserting. Align the peg in the work spindle with the slot in the main spindle and press spindle onto seating.

Move control lever to "Lock" position as previously described and screw spindle locknut securely to the main spindle, firmly locking the work spindle in position.

To remove the work spindle reverse the above procedure.

#### Important

Always ensure at all times that the work spindle is securely held by the spindle locknut before starting the machine.

#### FENCE ADJUSTMENT

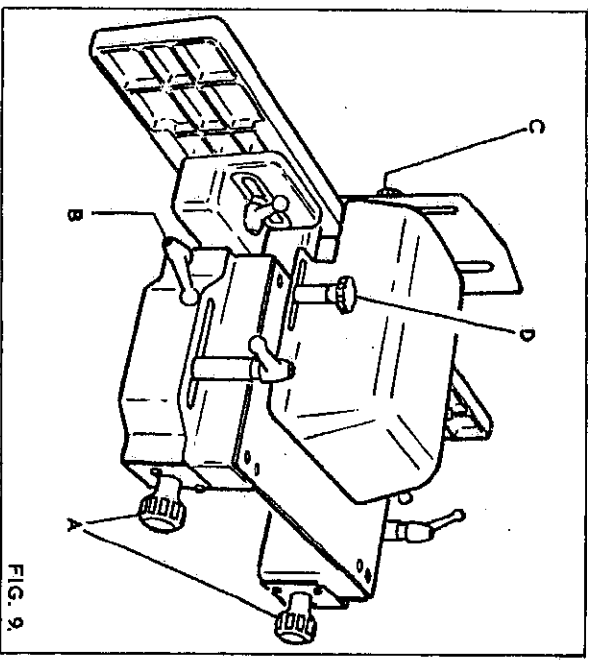
Each fence plate can be independently adjusted by means of the plastic handwheels "A" in Fig. 9. The fence plates can be set to the desired position and locked by the adjustable handles "B". The front fence plates can also be adjusted lengthwise.

The fence plates should be locked both ways at all times when the machine is in use.

The fence is fitted with a safety guard and a "shaw" guard can also be fitted if required.

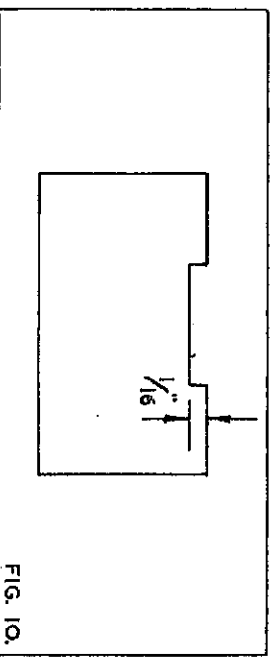
The safety guard is adjustable depending on the section of timber being worked. This guard is shown in position in Fig. 9 To adjust the guard for various sections of timber, unscrew the plastic handwheels "C", set to required position and relock.

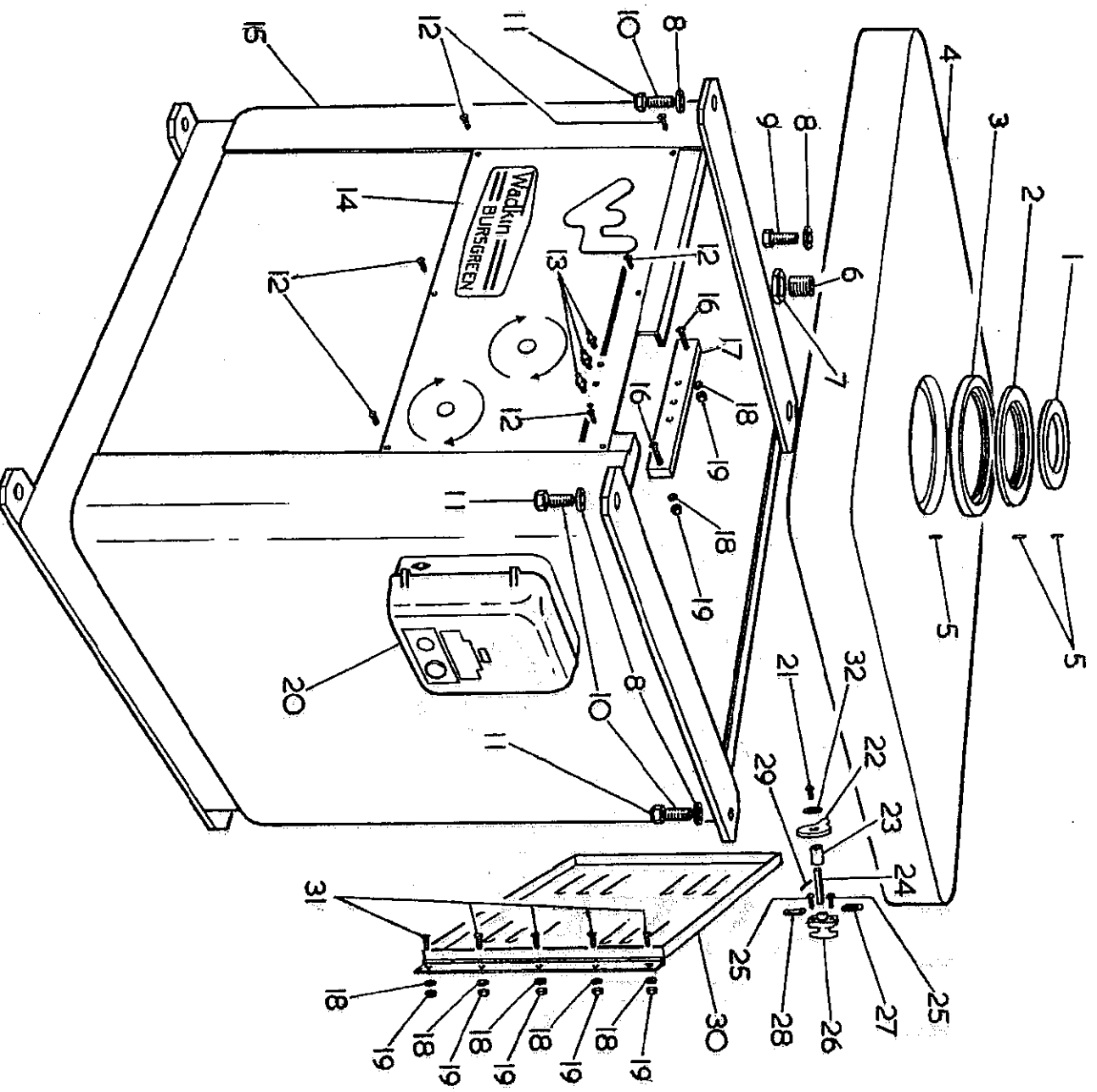
To adjust the safety guard in relation to the fence plates loosen the plastic handwheels "D", position the safety guard and relock.



#### GENERAL HINTS

1. Always select the correct speed for the cutter equipment being used. Wadkin/Burgreen cutterblocks are normally stamped with the maximum permissible speed, but this may need to be reduced dependent on shape and general condition of cutters being used.
2. Use sharp cutters which should be reasonably well balanced.
3. Ensure the cutters are tight on the blocks before starting machine. Use spanners provided and never fit a piece of piping to obtain greater leverage. This will strain the nuts and bolts and ultimately make them unsafe.
4. Never pack the cutters with sandpaper. This is most dangerous as the grit collapses when the cutter is working, and the cutter works loose. For packing use one thickness only of brown paper.
5. Keep nuts and bolts clean and keep oil on the threads.
6. Never run the cutter equipment at higher than the recommended speed.
7. Always use the guards available to ensure maximum protection.
8. Make good robust jigs and ensure that the parts are located securely on the jig.
9. When changing cutter equipment always ensure the machine control lever is in the "Free" or "Lock" position. If in doubt isolate the machine electrically.
10. Always notch cutters for French spindles as shown in Fig. 10 for the spindle locking bolt to locate the cutter.

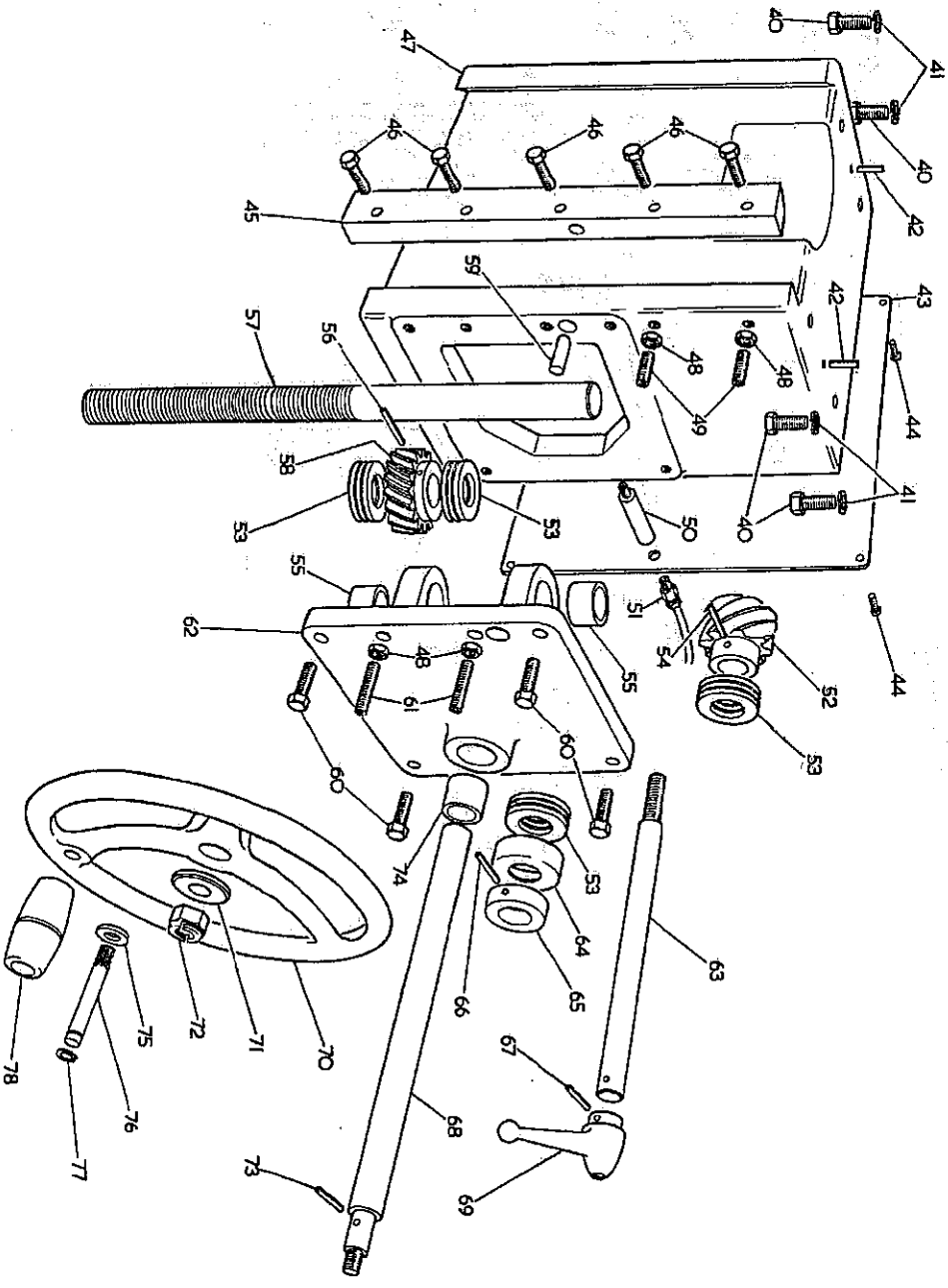




### MAIN FRAME ASSEMBLY

Ref. No.	Part No.	No. Off	Description	Ref. No.	Part No.	No. Off	Description
1	B-1057/24	1	Small table ring	17	B-1057/85	1	Grease nipple backing plate
2	B-1057/25	1	Medium table ring	18		7	3/4" washer
3	B-1057/26	1	Large table ring	19		7	1/4" whit nut
4	E-1057/2	1	Main table	20	ZTR3	7	Brooks starter
5		3	1/8" dia x 1/2" long groverlok spring dowel	21		1	3/16" B. S. F. x 1/4" long round head screw
6	A-1057/49	1	Table adjuster	22		1	Latch for rear door
7		1	1" simplex nut	23		1	Distance collar for rear door handle
8	A-1057/148	4	1" washer	24	T-44-11E	1	Spindle for handle
9		1	1/2" whit x 2 1/2" long hexagon head bolt	25		2	3/16" whit x 5/16" long round head screw
10		1	1/2" whit x 2" long stud	26	T-44A RE	1	Handle for handle on rear door
11		3	1/2" whit aerolight nut	27		1	Washer for handle on rear door
12		3	1/2" whit x 3/4" long round head screw	28		1	Bump washer for handle on rear door
13		6	1/8" gas grease nipple	29		1	1/8" dia x 3/4" long groverlok dowel
14		3	Control plate	30	C-1057/47	1	Rear door for base
15	E-1057/45	1	Sheet steel base	31		5	1/4" whit x 3/4" long round head screw
16		2	1/4" whit x 1" long countersunk screw	32		1	3/16" B. S. F. washer

NOTE :-  
 When ordering replacement parts quote  
 part no. and serial number of the machine.

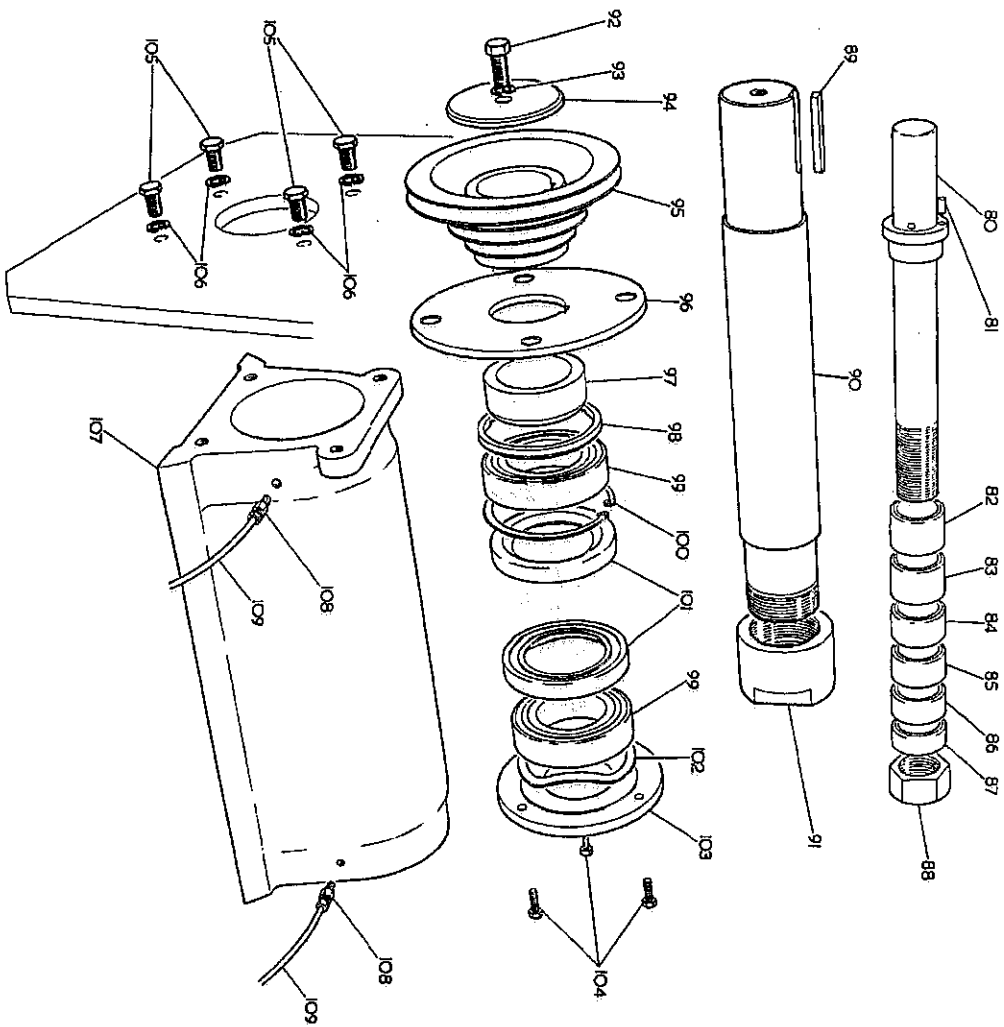


## RISE & FALL ASSEMBLY

Ref.No	Part No.	No. Off	Description	Ref.No	Part No.	No. Off	Description
40		4	5/8" whit x 1 1/4" long hexagon head bolts	60		4	3/8" whit x 1" long hexagon head bolt
41		4	5/8" spring washers	61		2	3/8" whit x 2" long socket head grub screw
42		2	1/4" dia x 1" long groverlok spring dowel	62	C-1057/4	1	Rise and fall bracket
43	A-1057/48	1	Gearbox cover	63	A-1057/36	1	Slide locking shaft
44	B-1057/43	4	3/16" whit x 3/8" long round head screw	64	A-1057/41	1	Rise and fall bearing cover
45		1	Spindle slide gnd strip	65	A-1057/39	1	Collar for handwheel shaft
46		5	3/8" whit x 1 1/2" long hexagon head bolt	66		1	3/16" dia x 2" long groverlok spring dowel
47	D-1057/1	1	Rise and fall slide	67		1	3/16" dia x 7/8" long groverlok spring dowel
48		4	3/8" whit locknut	68	A-1057/37	1	Adjustable handle 3/4" female plain
49		2	3/8" whit x 1 1/2" long socket head grub screw	69		1	Rise and fall handwheel
50	A-1031/62	1	Grease tube	70	C-1044/56	1	Rise and fall handle
51	S65/2	1	Straight connector (brass)	71	A-1056/75	1	Washer for rise and fall nut
52	A-1033/204	1	Spiral rise and fall pinion	72		1	3/4" whit aerodight nut
53	SKF 08	4	Thrust bearing	73		1	3/16" dia x 1.3/8" long groverlok spring dowel
54		1	3/16" dia x 1 1/2" long groverlok spring dowel	74		1	1" y/d x 1 1/4" o/d x 1 1/4" long ollite bush
55		2	1" y/d x 1 1/2" o/d x 3/4" long ollite bush	75		1	Collar for Rise and fall handle spindle
56		1	3/16" dia x 1 1/4" long groverlok spring dowel	76	A-1057/158	1	Rise and fall handle spindle
57		1	Rise and fall screw	77	S100/37	1	Circlip for handle spindle
58	A-1033/205	1	Spiral rise and fall gear	78	A-1057/157	1	Rise and fall plastic handle
59	A-1057/38	1	Rise and fall slide locking bol				

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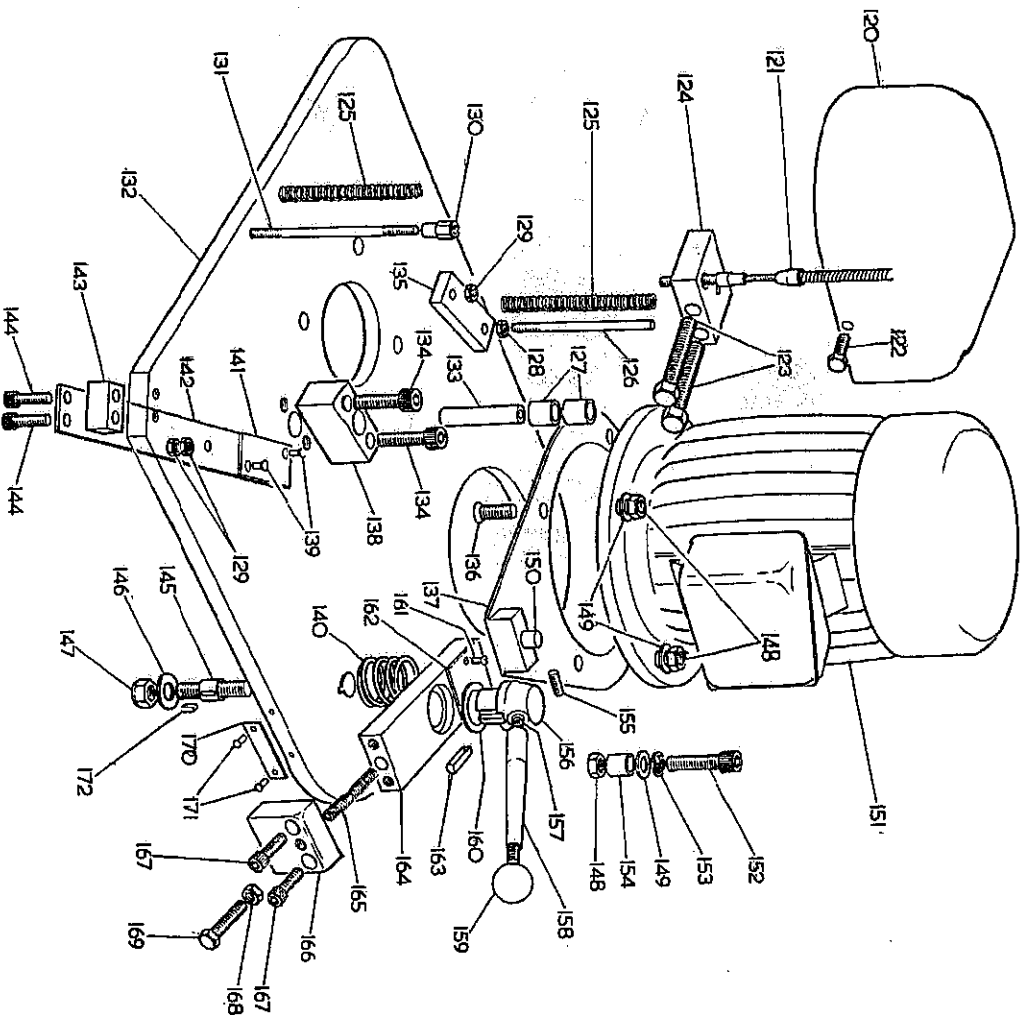


## SPINDLE HOUSING ASSEMBLY

Ref.No.	Part No.	No.Off	Description	Ref.No.	Part No.	No.Off	Description
80	B-1057/54	1	1 1/2" dia work spindle	A-1057/140	1	1	1" bore x 3/4" long spacing collar (Extra)
	B-1057/112	1	1" dia work spindle (Extra)	A-1057/139	1	1	30mm bore x 3/4" long spacing collar (Extra)
	B-1057/88	1	30mm work spindle (Extra)	A-1046/32	1	1	1 1/4" spindle nut
81	A-1057/138	1	5/16" dia x 7/8" long dowel	A-1057/150	1	1	1" BSF spindle nut
82	A-1057/140	1	1 1/4" bore x 2" long spacing collar	C-1057/27	1	1	30mm spindle nut
	A-1057/139	1	1" bore x 2" long spacing collar (Extra)	C-1057/31	1	1	Key for main spindle shaft
	A-1057/138	1	30mm bore x 2" long spacing collar (Extra)	B-1057/31	1	1	Main spindle nut
83	A-1057/138	1	1 1/4" bore x 1 1/4" long spacing collar (Extra)	A-1046/63	1	1	1/2" white x 1 1/2" long hexagon head bolt
	A-1057/140	1	1" bore x 1 1/2" long spacing collar (Extra)	A-1057/52	1	1	3/4" spring washer
	A-1057/139	1	30mm bore x 1 1/2" long spacing collar (Extra)	B-1057/33	1	1	1/2" spring washer
84	A-1057/138	1	1 1/4" bore x 1 1/4" long spacing collar (Extra)	A-1057/30	1	1	Pulley locking washer
	A-1057/140	1	1" bore x 1 1/4" long spacing collar (Extra)	C-1057/30	1	1	Spindle Pulley
	A-1057/139	1	30mm bore x 1 1/4" long spacing collar (Extra)	A-1057/30	1	1	Bearing spacer
85	A-1057/138	1	1 1/4" bore x 1" long spacing collar (Extra)	C-1057/30	2	2	Bearing spacer
	A-1057/140	1	1" bore x 1" long spacing collar (Extra)	SKF 6211	2	2	Bearing
	A-1057/139	1	30mm bore x 1" long spacing collar (Extra)	W39425551R4	1	1	100mm Internal circlip
	A-1057/138	1	1 1/4" bore x 3/4" long spacing collar (Extra)	EPL 68	2	2	Oil seal
	A-1057/140	1	1" bore x 3/4" long spacing collar (Extra)	B-1057/23	1	1	Bump washer
	A-1057/139	1	30mm bore x 1" long spacing collar (Extra)		1	1	Dust cap
86	A-1057/138	1	1 1/4" bore x 3/4" long spacing collar (Extra)		3	3	5/16" white x 3/4" long hexagon head bolt
	A-1057/140	1	1" bore x 3/4" long spacing collar (Extra)		4	4	3/4" BSF spring washer
	A-1057/139	1	30mm bore x 3/4" long spacing collar (Extra)	D-1057/3	1	1	Spindle housing
	A-1057/138	1	1 1/4" bore x 3/4" long spacing collar (Extra)	S65/2	2	2	Straight connector
	A-1057/139	1	30mm bore x 3/4" long spacing collar (Extra)		2	2	3/16" dia nylon pipe
87	A-1057/138	1	1 1/4" bore x 3/4" long spacing collar (Extra)				

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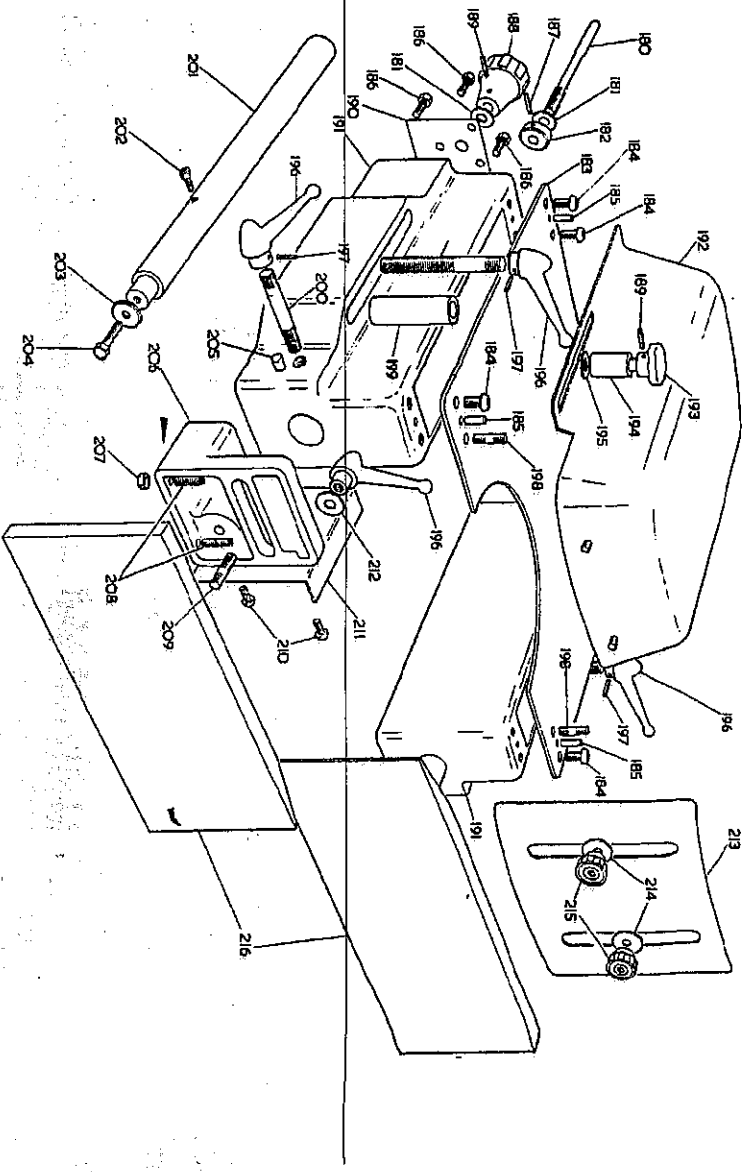


## MOTOR MOUNTING ASSEMBLY

Ref.No	Part No.	No. Off	Description	Ref.No	Part No.	No. Off	Description
120	C-1057/134	1	Motor cover	147		1	½" whit aerolight nut
121	B-1046/75	1	Cable assembly	148		5	3/8" whit nut
122		2	5/16" whit x 3/8" long round head screw	148		5	3/8" washer
123		2	3/8" whit x 2¼" long hexagon head bolt	150	A-1057/154	1	Motor tension dowel
124	A-1057/13	2	Cable support plate	151		1	Brook motor, 5-5HP, 3, 000rpm flange mounted, frame size D-112K
125	A-1045/136	2	Cable return spring	151		1	Brook motor, 7-5HP, 3, 000rpm flange mounted, frame size D-132S
126	A-1057/14	1	Brake spring guide	152		1	3/8" whit x 2" long socket head capscrew
127		2	½" bore x 5/8" o/d x ¾" long oilite bush	153		1	3/8" spring washer
128		1	¾" whit locknut	154	A-1057/42	1	Motor pivot bush
129		3	¾" B. S. F. locknut	154		1	Motor pivot bush
130	A-1057/9	1	Brake locknut	155		1	3/8" whit x ½" long socket head grub screw
131	A-1057/18	1	Brake control rod	155		1	Clamp nut
132	C-1057/28	1	Rise and fall plate	156	A-1057/22	1	Motor tension spring
133	A-1057/11	1	Spindle locking pin	157		1	3/8" whit x 1" long socket head grub screw
134		2	3/8" whit x 1" long socket head capscrew	158	B-1027/26	1	Motor locking handle
135		1	Cable anchor plate	159		1	3/8" whit x 1¼" dia plastic ball
136	A-1057/12	4	3/8" whit x 1¼" long socket head countersunk screw	160	A-1057/51	1	Washer for motor clamp
137		1	Motor tension plate	161		2	3/16" whit x 3/8" long round head screw
138	B-1057/82	1	Motor tension plate	162	A-1057/151	1	Cover for motor tension clamp
139	A-1057/10	2	Locking pin location block	163	A-1057/21	1	Motor tension peg
140		2	3/16" x 3/8" long countersunk copper rivet	164	A-1057/19	1	Motor tension peg
141	A-1033/194	1	Motor tension release spring	165	A-1057/58	1	Motor tension spring
142	A-1057/16	1	Brake pad	166		2	Motor clamp heel
143	A-1057/15	1	Brake plate	167	A-1057/5	1	Motor clamp heel
144	A-1057/17	1	Brake plate heel	168		1	5/16" whit nut
145		2	3/8" whit x 1¼" long socket head capscrew	169	A-1057/86	1	Belt tension instruction plate
146	A-1057/20	1	Motor clamp stud	170		2	1/8" rivet
		1	¾" washer	172		1	3/16" x 5/8" long key

### NOTE :-

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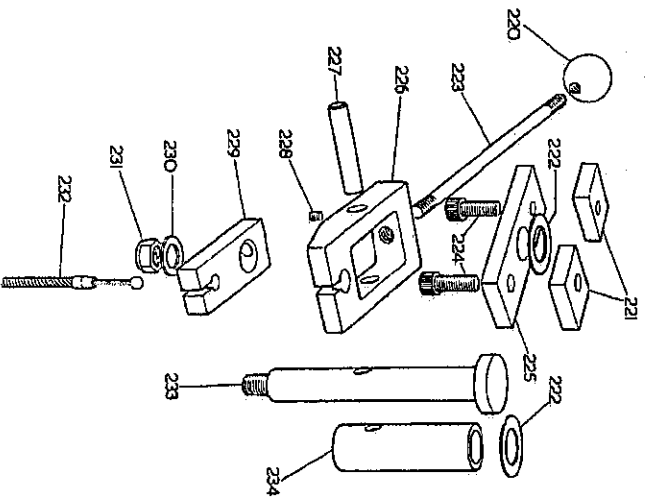


## FENCE ASSEMBLY

Ref.No.	Part No.	No.Off	Description
180	A-1057/97	2	Fence adjusting screw
181	B-1057/98	4	1/4" brass washer
182	A-1057/67	2	Collar for fence adjustment screw
183	C-1057/182	1	Fence tie plate
184		6	3/8" whit x 2" long socket head button screw
185		4	1/2" dia x 1/4" long fluted dowel
186		2	3/16" dia x 1 1/2" long hexagon head bolt
187		2	2" dia plastic handwheel 3/8" plain bore
188		2	3/16" dia x 1" long groverlok spring dowel
189		4	Pressure pads
190	B-1057/94	2	Right hand fence body
191	D-1057/91	1	Left hand fence body
192	D-1057/92	1	Fence cover
193	B-S-509	2	2. 1/8" dia plastic handwheel 3/8" plain bore
194	A-1057/149	2	Fence cover locking post
195		6	3/8" washer
196		2	Adjustable handle 3/4" whit bore
197		4	3/16" dia x 1 1/2" long groverlok spring dowel
198		4	3/8" whit x 1" long stud

Ref.No.	Part No.	No.Off	Description
199	A-1046/28	2	Spacer
200	B-1057/98	2	1/4" whit x 1 1/2" long stud
201		2	Slide bar
202		2	1/4" whit x 3/4" long socket head cap screw
203	A-1792/67	2	Washer for fence slide bar
204		2	3/8" whit x 2" long hexagon head bolt
205		2	3/8" dia x 5/16" long brass bolt
206	C-1057/89	1	Right hand fence plate bracket
207		4	Left hand fence plate bracket
208		4	3/8" whit nut
209		4	3/8" whit x 1 1/2" long brass grub screw
210		2	1/4" whit x 1 1/2" long stud
211	B-1057/104	2	1/4" whit x 3/4" long socket head button screw
212		2	Chip deflector
213	B-1057/95	1	1" washer
214		2	Front guard
215		2	5/16" washer
216	C-1057/101	2	1 1/2" dia plastic handwheel 5/16" whit fence plate

## CONTROL LEVER ASSEMBLY

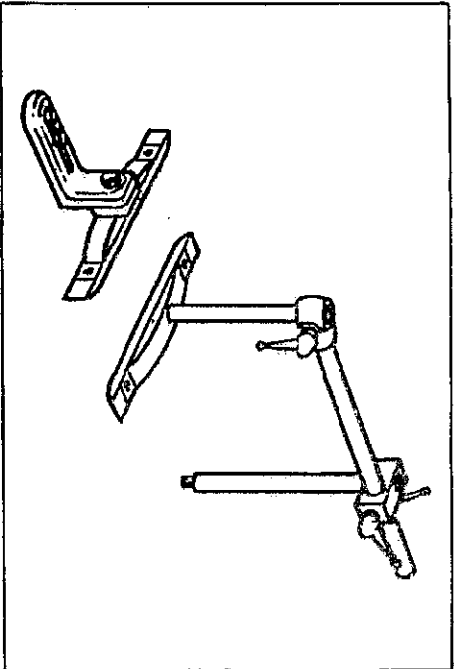


Ref.No.	Part No.	No.Off	Description
220	A-1057/79	1	1 1/4" dia plastic ball 1/2" whit
221	A-1057/127	2	Brake packing piece
222	A-1057/95	2	Washer for brake pivot
223		1	Control handle
224	A-1057/78	2	3/8" whit x 1 1/2" long socket head cap screw
225	A-1057/8	1	Swivel pin anchor plate
226	A-1057/9	1	Yoke for brake
227		1	1/4" whit x 3/8" long socket head grub screw
228	A-1057/7	1	Brake anchor plate
229		1	1/2" washer
230	B-1046/76	1	1/4" whit aero/light nut
231	A-1057/6	1	Cable
232	A-1057/77	1	Brake swivel pin
233		1	Swivel pin sleeve
234		1	

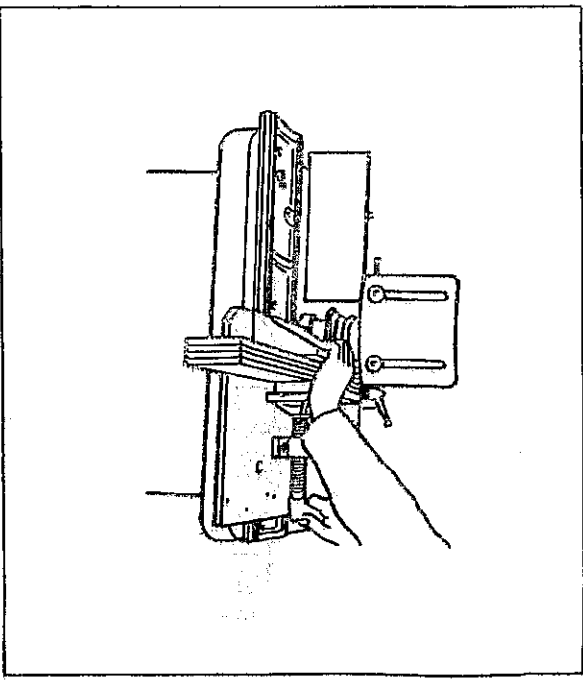
### NOTE :-

When ordering replacement parts quote part no. and serial number of the machine.





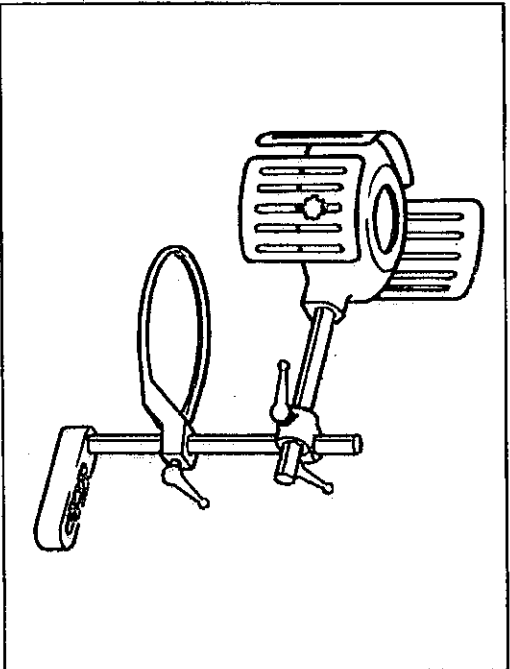
**SHAW GUARD :-** This guard provides top and side pressure and ensures safety in operation for use with the standard fence or as effectively with the ring fence for curved work.



**CORNER LOCKING ATTACHMENT TYPE E. F.**

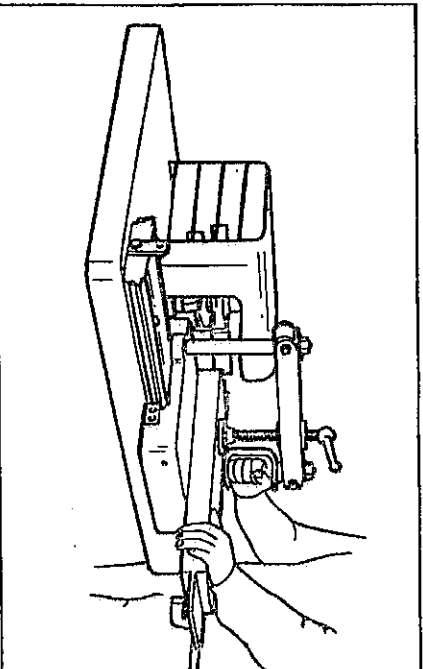
This attachment is capable of dealing with work up to 8" in depth and of any desired pitch. Any number of boards up to 8" in thickness can be clamped together and machined at the one operation. The attachment consists of a sliding table mounted on a slide frame secured to the main table of the machine. This table is provided with fence and clamp for securing the work and slides past the cutters by hand.

The ordinary spindle moulder fence is used as a stop for placing the boards in position. We can supply a special top piece 1 1/4" diameter with suitable key and each cutter is arranged with a keyway so that the cutters are staggered around the spindle to give an even cut.



**SAFETY GUARD AND RING FENCE**

The safety guard has adjustable flaps which completely cover the cutter equipment. This is used in conjunction with the ring fence which is for use on all types of curved work.

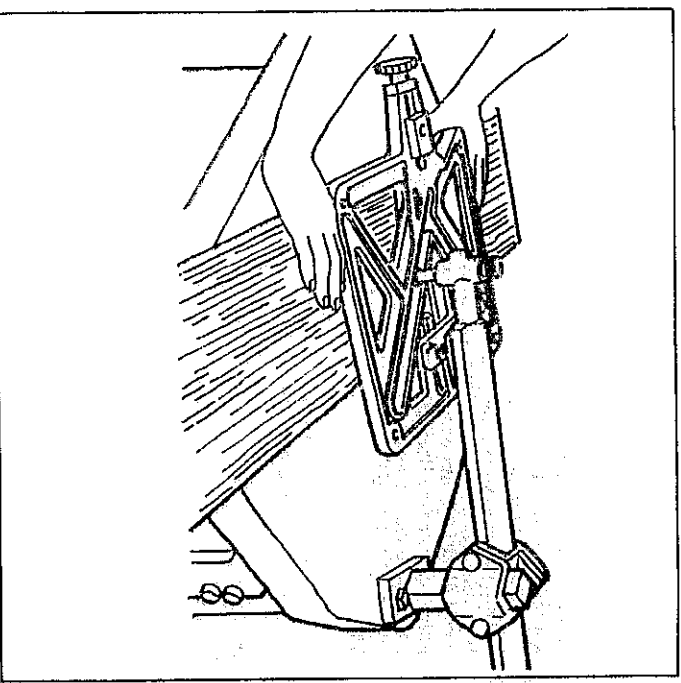


**TENONING ATTACHMENT TYPE E. G.**

This is an efficient and inexpensive method of tenoning on a spindle moulder. The attachment will cut single or double tenons up to 5" long, 11" wide; it will scribe either single or double at the same operation; it will cut angular tenons; it can be used for half lapping.

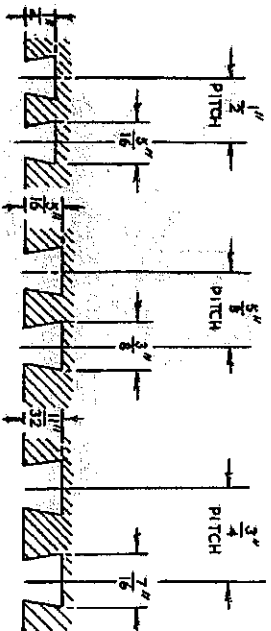
Shoulders of tenons are left dead square and no hand work is required on the tenons when they come off the machine.

The attachment is provided with stops to ensure exact length between shoulders. No setting out is required.



**STAIR HOUSING ATTACHMENT :-** This attachment consists of template guide roller, arm and pillar.

This attachment can be fitted in a few minutes. The roller guide which controls the cut, is rigidly carried on a solid steel arm from a pillar and centred with the spindle. The template is secured to stair string by means of a hand nut. The template is reversible to produce a pair of strings right and left hand without resetting. Marking out is practically eliminated and a complete pair of strings can be cut in less time than is normally taken in marking out.

**SPINDLES & ADAPTORS**

**STANDARD LOOSE SPINDLES** :- 1" or 1 1/4" dia (25mm and 30mm) available. These are for carrying standard bore cutterblocks, slotted collars, grooving saws, etc. The spindle threads are right hand, and all spindles are supplied with locknut and a set of making up collars.



**SLOTTED FRENCH SPINDLE**:- For carrying one 1/2" (6mm) thick cutter only, which is secured by a hardened steel set screw. Maximum recommended speed :- 4, 500rpm

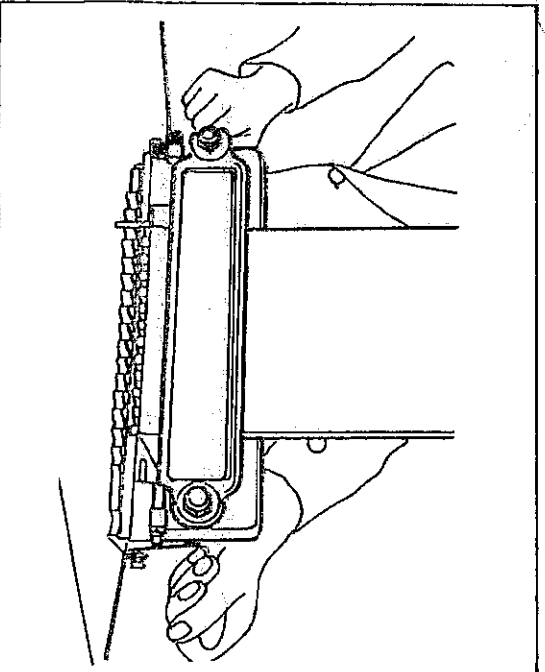
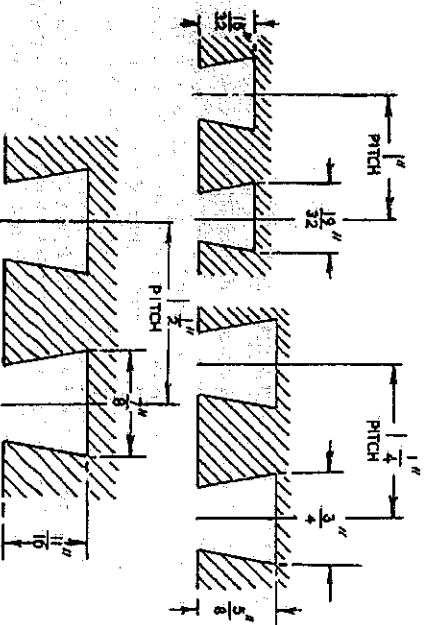


**DOVETAIL ATTACHMENT TYPE E, E.** :- For board up to 12" (305mm) wide supplied complete with comb plate, collet adaptor and 3/8" dia. (9mm) H. type collet

This attachment is a very simple efficient device for dovetailing two boards at right angles to each other. They are clamped in position and suitable stops are provided for setting. Both the dovetail and the pin are produced at the same operation, and the pin is rounded so that no hand work is necessary.

Guide plates and bits are available for the following pitches 1/4", 5/8", 3/4", 1", 1 1/4" and 1 1/2" (13mm, 16mm, 19mm, 25mm, 32mm and 38mm)

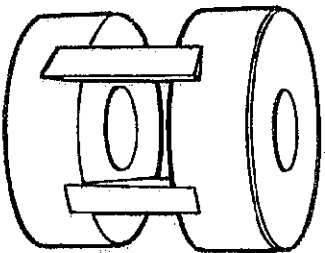
**Note**:- When ordering spare dovetail bits, please specify pitch size not the diameter of the bit.



**COLLET TYPE ROUTER ADAPTOR** :- This adaptor is supplied complete with 3/8", 1/2" and 9/16" (9mm, 13mm, and 14mm) "H" type collets. It enables standard router cutters to be used.

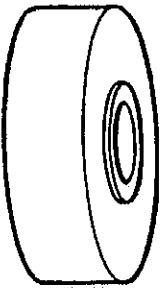


**ADAPTOR FOR STAIR HOUSING ATTACHMENT** :- Special adaptor having a 5/8" bore (15mm) to accept both "Z" type and clothes peg type cutter.



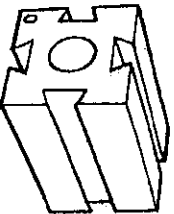
**PLAIN SLOTTED COLLARS :-**

For 1" (25mm) dia. work spindle :- 2 $\frac{1}{2}$ " (64mm) dia with  $\frac{1}{2}$ " (6mm) wide slots  
 Minimum cutting circle :- 3" (76mm)  
 For 1 $\frac{1}{2}$ " (30mm) dia work spindle :- 3" (76mm) dia with  $\frac{1}{4}$ " (6mm) wide slots  
 Minimum cutting circle :- 3.5/8" (92mm)  
 Slotted collar cutters have many advantages, they have a good cutting angle, a comparatively small cutting circle and are easy to shape, maintain and re-grind and also inexpensive. The maximum cutter projection should not exceed 5/8" (16mm) to ensure maximum strength and support  
 2 $\frac{1}{2}$ " (64mm) dia x 1" (25mm) bore or 3.3/8" (86mm) dia x 1 $\frac{1}{4}$ " (30mm) bore ball bearing type slotted collars also available.



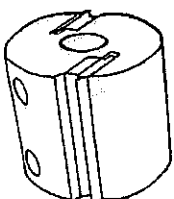
**BALL BEARING GUIDES :-** Available in two sizes for 3 $\frac{1}{2}$ " and 4" cutterblocks (89mm and 101mm)

3 $\frac{1}{2}$ " (89mm) dia x 1" (25mm) bore  
 4.1/8" (104mm) dia x 1" (25mm) bore



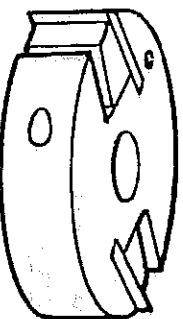
**SQUARE CUTTERBLOCKS :-** These cutterblocks are used for long runs, cutters working in pairs. Two or more may be mounted on a single block to build up a mould.

For 1" dia (25mm) work spindle:-  
 2 $\frac{1}{2}$ " (64mm) square x 3" (76mm) long complete with 4 -  $\frac{1}{2}$ " whit (13mm) dovetails cutter bolts, nuts and washers.  
 Maximum recommended speed :- 4, 500rpm  
 For 1 $\frac{1}{2}$ " dia (30mm) work spindle:-  
 3 $\frac{1}{2}$ " (89mm) square x 3" (76mm) long complete with 4 - 5/8" whit dovetail cutter bolts, nuts and washers.  
 Maximum recommended speed :- 4, 500rpm  
 3 $\frac{1}{2}$ " (89mm) square x 4" (102mm) long complete with 4-5/8" whit dovetail cutter bolts, nuts and washers  
 Maximum recommended speed :- 4, 500rpm  
 3 $\frac{1}{2}$ " (89mm) square x 5" (127mm) long complete with 4 - 5/8" whit dovetail cutter bolts, nuts and washers  
 Maximum recommended speed :- 4, 500rpm  
 3 $\frac{1}{2}$ " (89mm) square x 6" (152mm) long complete with 4 - 5/8" whit dovetail cutter bolts, nuts and washers  
 Maximum recommended speed :- 4, 500rpm



**CIRCULAR CUTTERBLOCKS :-** These cutterblocks have wedge type clamping for safety. They are smooth running and used for facing or shallow rebores etc.

For 1" dia (25mm) work spindle :-  
 3 $\frac{1}{2}$ " (89mm) diameter circular cutterblock, 3" (76mm) long or 2" (50mm) long.  
 Maximum recommended speed:- 7, 000rpm  
 For 1 $\frac{1}{2}$ " dia (30mm) work spindle:-  
 4 $\frac{1}{2}$ " (102mm) diameter circular cutterblock 3" (76mm) long  
 Maximum recommended speed :- 7, 000rpm  
 4 $\frac{1}{2}$ " (108mm) diameter circular cutterblock 4" (102mm) long  
 Maximum recommended speed :- 6, 000rpm  
 4 $\frac{1}{2}$ " (108mm) diameter circular cutterblock 6" (152mm) long  
 Maximum recommended speed :- 4, 500rpm

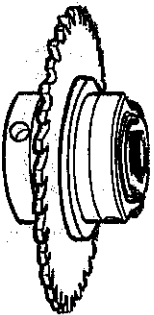


**TWO KNIFE WEDGE TYPE MouldING CUTTERBLOCK**

These cutterblocks are designed to take from 5/32" (4mm) to  $\frac{1}{2}$ " (6mm) thick cutters this permits tungsten carbide tipped cutters to be used when necessary.

The cutters can be used for mouldings requiring up to  $\frac{1}{2}$ " (13mm) cutter projection when using  $\frac{1}{4}$ " thick cutters  
 4" (102mm) dia x 15/16" (24mm) thick x 1" (25mm) bore Part No QR60  
 This block uses 5/32" (4mm) thick cutters only.

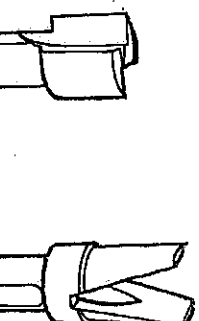
- 4. 7/8" (124mm) dia x 15/16" (24mm) thick x 1" (25mm) bore, Part No. QR 11/B
- 4. 7/8" (124mm) dia x 15/16" (24mm) thick x 1 $\frac{1}{2}$ " (30mm) bore, Part No. QR 1/B
- 4. 7/8" (124mm) dia x 1 $\frac{1}{4}$ " (32mm) thick x 1 $\frac{1}{4}$ " (30mm) bore, Part No. QR 2
- 4. 7/8" (124mm) dia x 1 $\frac{1}{2}$ " (38mm) thick x 1 $\frac{1}{4}$ " (30mm) bore, Part No. QR 10
- 4. 7/8" (124mm) dia x 2" (50mm) thick x 1 $\frac{1}{2}$ " (30mm) bore, Part No. QR 3
- 4. 7/8" (124mm) dia x 2" (50mm) thick x 1 $\frac{1}{2}$ " (30mm) bore, 4 Knife Part No. QR66
- 5. 3/8" (137mm) dia x 15/16" (24mm) thick x 1 $\frac{1}{2}$ " (32mm) bore Part No. QR 4
- 4. 7/8" (124mm) dia x 2" (51mm) thick x 1 $\frac{1}{2}$ " (32mm) bore, with top and bottom bevels. Part No. QR 57
- 8" (203mm) dia x 15/16" (24mm) thick x 1 $\frac{1}{2}$ " (32mm) bore, Part No. QR 16



**WOBBLE SAW :-**

These saws are used where varied widths of grooving are called for, and where quantities are small. They are not recommended for quantity production or where precision accuracy or the highest standard of finish is required.

6" (151mm) diameter for grooves 1/8" to 3/4" (3mm to 19mm)  
 For use on 1" and 1 1/2" dia (25mm and 30mm) spindles  
 Maximum recommended speed 4,500rpm.

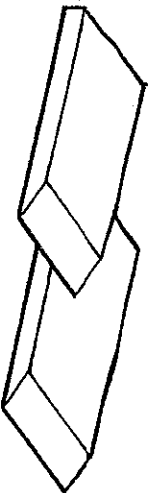


**CUTTERS FOR STAIR HOUSING ATTACHMENT :-**

Z Type and Clothes peg type 5/8" dia shank.

These cutters are designed to give a slightly undercut trench and perfectly uniform wedge space. All have 5/8" dia shank.

**CUTTERS.**

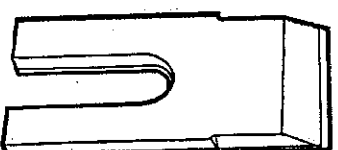
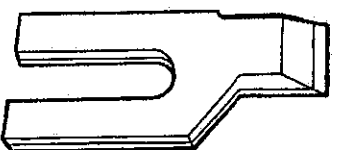


**CUTTERS FOR QR BLOCKS**

VZ Cutters 5/32" thick	T. C. Tipped
3/4" on cut	VZ/T
1" on cut	VZ1/T
1 1/4" on cut	VZ2/T
1 3/4" on cut	VZ3/T
1 3/4" on cut	VZ4
2" on cut	VZ5
2 1/2" on cut	VZ6

**T. C. Tipped**

3/4" Thick	T. C. Tipped
3/4" on cut	VZ20
1" on cut	VZ21
1 1/4" on cut	VZ22
1 1/2" on cut	VZ23
1 3/4" on cut	VZ24
2" on cut	VZ25
2 1/4" on cut	VZ26
2 1/2" on cut	VZ27



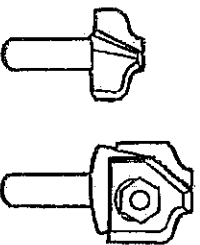
**Rebate & Square Irons**

For 3/2" square cutterblock :-

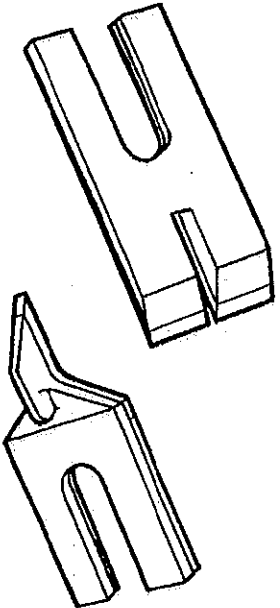
Rebate Irons		Square Irons	
On Cut	Part Nos.	On Cut	Part Nos.
1/2"	VQ1	1 1/4"	VQ13
5/8"	VQ3	1 1/2"	VQ14
3/4"	VQ5	2"	VQ15
7/8"	VQ7	2 1/4"	VQ16
1"	VQ9	2 1/2"	VQ17
1 1/4"	VQ11	3"	VQ18

For 3 1/2" square cutterblock :-

Rebate Irons		Square Irons	
On Cut	Part Nos.	On Cut	Part Nos.
1/2"	TB1	1 1/4"	TB14
5/8"	TB3	2"	TB15
3/4"	TB5	2 1/4"	TB16
7/8"	TB7	2 1/2"	TB17
1"	TB9	2 3/4"	TB18
1 1/4"	TB11	3"	TB19
1 1/2"	TB13		TB13a



**Router Cutters:**



**Tonguing and Grooving Irons**

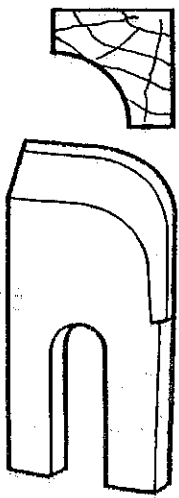
For 2½" square cutterblock :-  
Part No.

Size	Tonguing Cutter	Grooving Cutter
1/8"	VS1	VR1
3/16"	VS2	VR2
¼"	VS3	VR3
5/16"	VS4	VR4
3/8"	VS5	VR5

For 3½" square cutterblock :-  
Part No.

Size	Tonguing Cutter	Grooving Cutter
1/8"	TV	TX
3/8"	TV1	TX1
5/8"	TV2	TX2
7/8"	TV3	TX3
1"	TV4	TX4

**Scotia Cutters**



For 2½" sq. cutterblock

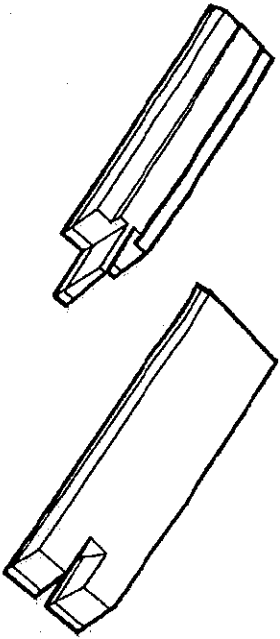
Dim A.	Part No.	Part No.
¼"	BTJ1	TJ1
3/8"	BTJ2	TJ2
½"	BTJ3	TJ3
5/8"	BTJ4	TJ4
7/8"	BTJ5	TJ5
1"	BTJ6	TJ6
	BTJ7	TJ7

For 2½" dia Slotted Collars

Part No.
BTE1
BTE2
BTE3
BTE4
BTE5
BTE6
BTE7

For 3" dia Slotted Collars

Part No.
TE1
TE2
TE3
TE4
TE5
TE6
TE7



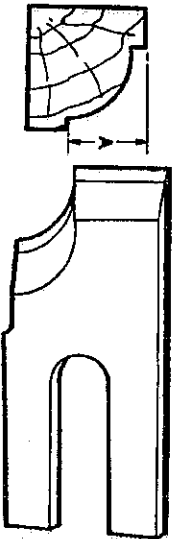
**Beading Cutters**

For 2½" dia slotted collars :-  
Part No.

Size	Tonguing Cutter	Grooving Cutter
3/16"	BVL1	BVJ1
¼"	BVL2	BVJ2
5/16"	BVL3	BVJ3
3/8"	BVL4	BVJ4

For 3" dia slotted collars:-  
Part No.

Size	Tonguing Cutter	Grooving Cutter
¼"	VL1	VJ1
3/8"	VL2	VJ2
½"	VL3	VJ3
5/8"	VL4	VJ4



**Ovolo Cutters**

For 2½" Square Cutterblock

Dim A.	Part No.
¼"	BTF1
3/8"	BTF2
½"	BTF3
5/8"	BTF4
¾"	BTF5
7/8"	BTF6
1"	BTF7

For 3½" Square Cutterblock

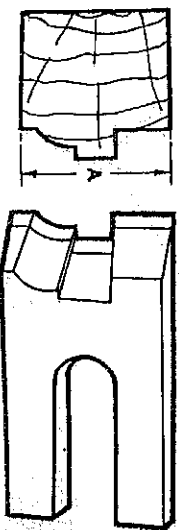
Dim A.	Part No.
¼"	TF1
3/8"	TF2
½"	TF3
5/8"	TF4
¾"	TF5
7/8"	TF6
1"	TF7

For 2½" dia. Slotted Collars

Dim A.	Part No.
¼"	BTH1
3/8"	BTH2
½"	BTH3
5/8"	BTH4
¾"	BTH5
7/8"	BTH6
1"	BTH7

For 3" dia. Slotted Collars

Dim A.	Part No.
¼"	TH1
3/8"	TH2
½"	TH3
5/8"	TH4
¾"	TH5
7/8"	TH6
1"	TH7



**Sash Cutters**

For 2½" sq. cutterblock

Dim A.	Part No.
1.3/8"	BTR1
1.5/8"	BTR2
1.7/8"	BTR3

For 3½" sq. cutterblock

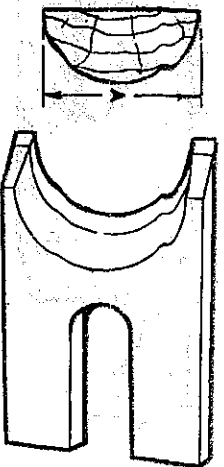
Dim A.	Part No.
1.3/8"	BTR1
1.5/8"	TR2
1.7/8"	TR3

For 2½" dia Slotted Collars

Part No.
BTT1
BTT2
BTT3

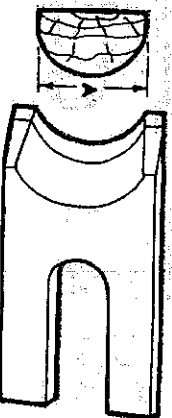
For 3" dia Slotted Collars

Part No.
TT1
TT2
TT3



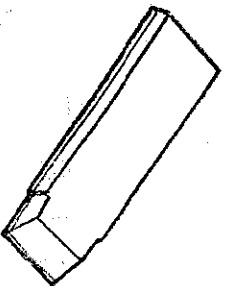
### Full Nosing Cutters

Dim A	Part No.	Part No.	Part No.	Part No.
3/8"	BVFE1	VF1	BVH1	VH1
	BVFE2	VF2	BVH2	VH2
	BVFE3	VF3	BVH3	VH3
	BVFE4	VF4	BVH4	VH4
	BVFE5	VF5	BVH5	VH5
	1.1/8"	BVFE6a	BVH6a	VH6a
	1 1/4"	BVFE6	BVH6	VH6
	1 1/2"	BVFE7	BVH7	VH7
	1 3/4"	BVFE8	BVH8	VH8
2"	BVFE9	BVH9	VH9	



### Shallow Nosing Cutters

Dim A	Part No.	Part No.	Part No.	Part No.
5/8"	VB1	VD1	VH1	VD1
	VB2	VD2	VH2	VD2
	VB3	VD3	VH3	VD3
	7/8"	VB4	VD4	VD4
	1"	VB5	VD5	VD5
	1 1/4"	VB6	VD6	VD6
	1 1/2"	VB7	VD7	VD7
	1 3/4"	VB8	VD8	VD8
	2"	VB9	VD9	VD9



On Cut	For 2 1/2" dia Slotted Collars	For 3" dia Slotted Collars
3/4"	BVN1	VN1
1"	BVN2	VN2
1 1/4"	BVN3	VN3
1 1/2"	BVN4	VN4
1 3/4"	BVN5	VN5
2"	BVN6	VN6
2 1/4"	BVN7	VN7
2 3/4"	BVN8	VN8
3"	BVN9	VN9
	BVN10	VN10

## CUTTERS AND CUTTER STEELS FOR SPINDLE MOULDERS

Special grades of steel are used for making cutters for different duties and applications on the spindle moulder. The following is a rough guide.

High speed steel on iron :- is used for long life and for cutting hard woods. High speed steel is brittle and is usually welded to a softer steel back for all types of unsupported irons. These are used on square cutterblocks, slotted collars and some thin knife moulding cutterblocks. A large range of irons for the square cutterblock and slotted collars are readily available in this steel.

Solid high speed steel :- is more brittle and is only used where the cutters are supported very close up to the cutting edge e.g. a thin knife on the circular cutterblock, or where a strong section can be used such as a milled to pattern slotted collar cutter.

Alloy steel on iron :- is less expensive than high speed steel on iron, and is more ductile. Alloy steel is not as hard and will not stand up to heavy cutting or hard woods as well as high speed steel. A large range of irons for the square cutterblock and slotted collars are readily available in this steel.

Solid alloy steel :- is normally supplied in bar form in the soft condition for cutting up by the customer. It is easily hardened and tempered and is normally used for french spindle work up to 6,000 rpm where cutters are held by a locking screw in spindle, locking direct on to the side of the cutter.

All the above types can be supplied in bar form, micrometer ground to precision limits. The alloy and alloy on iron 3/16" (5mm) x 3/4" (20mm) up to 1/2" (6mm) x 3" (76mm) in the soft condition and the solid high speed steel 5/32" (4mm) x 1 1/2" (38mm) and 5/32" (4mm) x 2" (50mm) and high speed steel on iron 1/4" (6mm) x 1 1/4" (32mm) and 1/4" (6mm) x 1 1/2" (38mm) in the heat treated condition. These latter bars cannot be cut with a tool and the blanks should be ordered to correct grinding lengths unless the user has suitable grinding wheel equipment for cutting to length himself.

All the above cutters can be ground on the usual standard grinding equipment.

Tungsten carbide tips :- These are specially made for use on hardwoods, woods with high silica content also plywoods and hardboards where High Speed Steel will not stand up to the abrasive action. It is much more expensive but gives very much longer life. A limited range of these cutters for slotted collars and square cutterblocks are available. Special shapes can be supplied to order.

N.B. Special diamond impregnated grinding wheels and diamond hand caps are essential for shaping and servicing Tungsten Carbide Tipped Tools. These are available but expensive for the small user for whom we can offer a cutter grinding service if required.

### SHAPING CUTTERS

When shaping cutters for any mould on any type of cutterhead or slotted collars it is important that the correct allowance is made to the depth of form cutter.

Fig. 10 shows the projections of the cutter to produce a simple rebate. For example using the 3 1/2" square cutterblock, to produce a 1" (25mm) deep rebate the cutter must have a depth of form of 1.3/16" (30mm) this being due to the angle at which the cutter strikes the work on the line "AA". When a shaped mould is required to be cut it is necessary to plot out the form of the cutter; this is shown in fig. 11.

It is important when selecting blanks from which to make the cutter that they have the minimum necessary overhang. Also a blank as near the shape and width as possible should be selected so that there will be less waste and less change of overheating cutters when grinding.

The minimum cutting circle is fixed to give the necessary clearance for the bolt head when working with straight irons only.

The cutting angle which is normally 35° is shown at "B", in fig. 10 and the cutting angle at "C" this angle varies with the size of the cutterblock and the depth of the mould

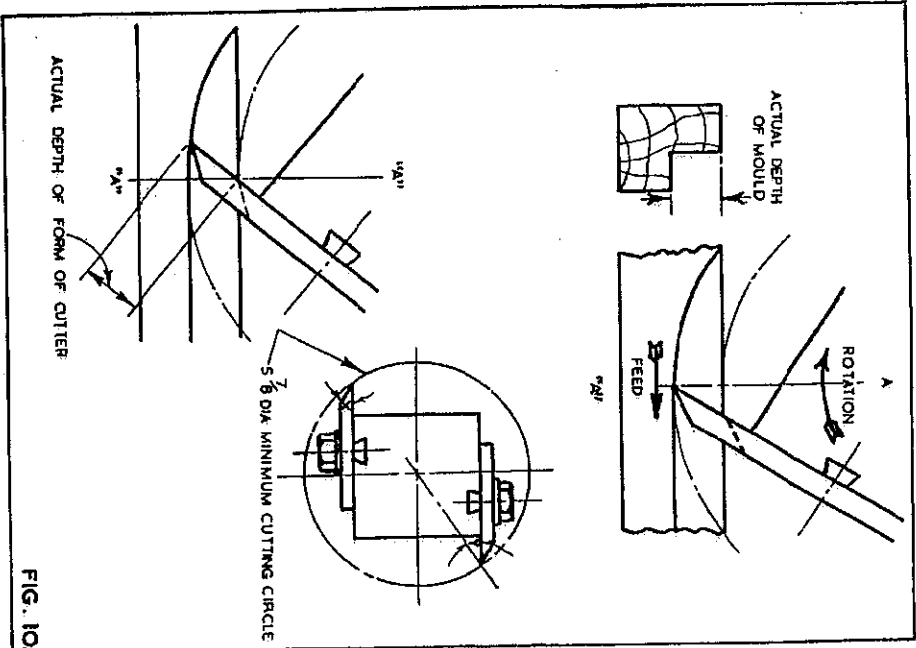


FIG. 10.

To obtain the correct cutter form for a shaped mould, without using the moulders rule, it is necessary to plot this out as shown. First the square block and cutter at minimum cutting circle are drawn out at "Y" in fig. 11. The radius of the minimum cutting circle is drawn around to the centre line and divided up by the lines A, B, C, D and E, into either 1/16" (2mm) or 1/8" (3mm) according to the size and intricacy of the shape, these lines are then struck round from the centre line radially to the face of the cutter.

At "X" the lines A1, B1, C1, D1, and E1 are carried across as shown, also at "W" the mould is produced exactly as at "Z" and divided up the same, the lines 1, 2, 3, 4 and 5 which are from the points where lines A, B, C, etc. intersect the edge of the mould, are then drawn across to "X" thus E1 is cut by 1; D1 by 2, etc. The points of intersection are joined as shown thus giving the correct projected form of the cutter.

This takes up considerable time to do for each shape of cutters required, and can be very much reduced by using the moulder's rule as shown in fig. 12. This is a graph on which the form can be plotted and automatically gives the necessary allowance on the depth of form.

When the mould is to be a standard, a template should be made to the projected form to which the cutters can be shaped when the job repeats. This will ensure uniformity on all future runs.

**MOULDERS RULE**

A permanent moulder's rule can be made by the customer in sheet brass and aluminium and will then be handy for use in the workshop.

To plot the form of a cutter by use of the moulder's rule it is necessary to draw the full size shape of the mould on tracing paper and rule 1/8" (3mm) squares as shown in fig. 12a. This is then placed alongside the moulder's rule and projected across, this will give a series of dots which must be joined to give the form of the cutter. The cutter blank chosen must be wide enough to give at least 1/8" (3mm) overlap beyond the edge of the mould. The depth of form of the cutter for the same mould varies slightly when used on a 3/4" (89mm) or 2 1/2" (64mm) square cutterblock due to the different cutting diameters. Moulder's rules are required for each size of square block. The cutters are not interchangeable from one size of cutterblock to another if a really accurate mould is required.

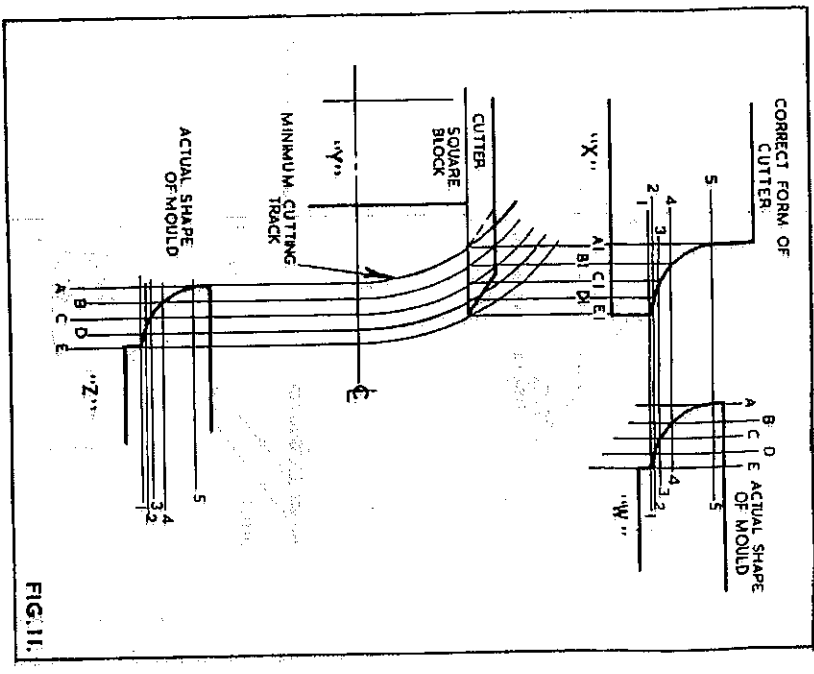


FIG. 11.

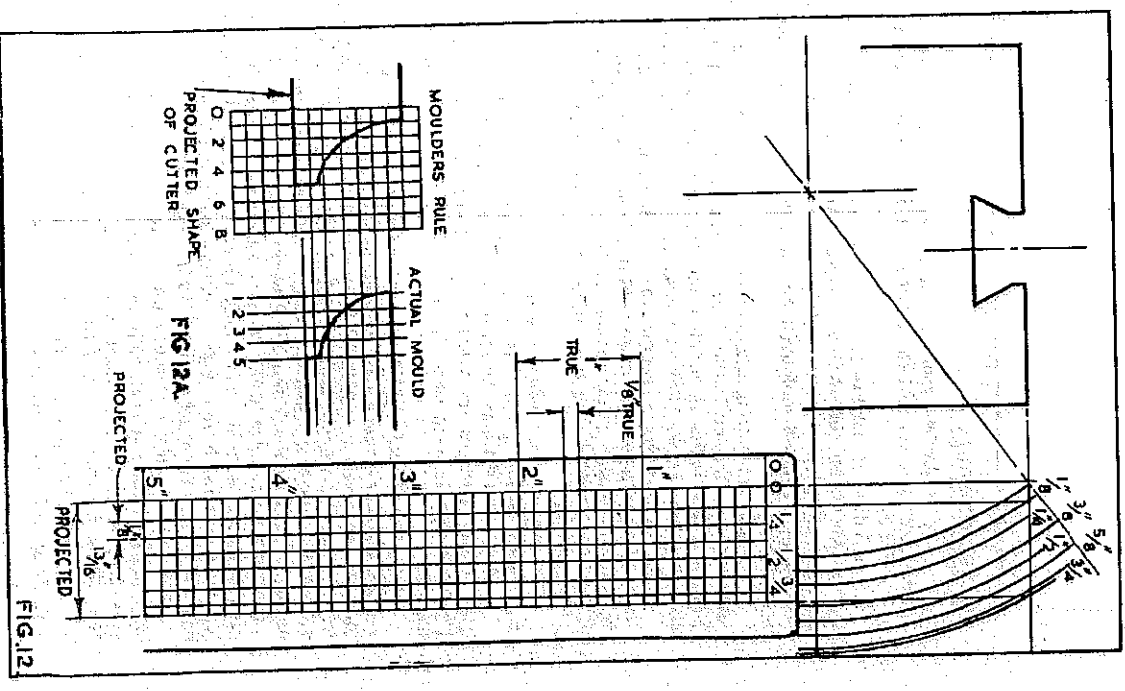


FIG. 12.

FIG. 12A.

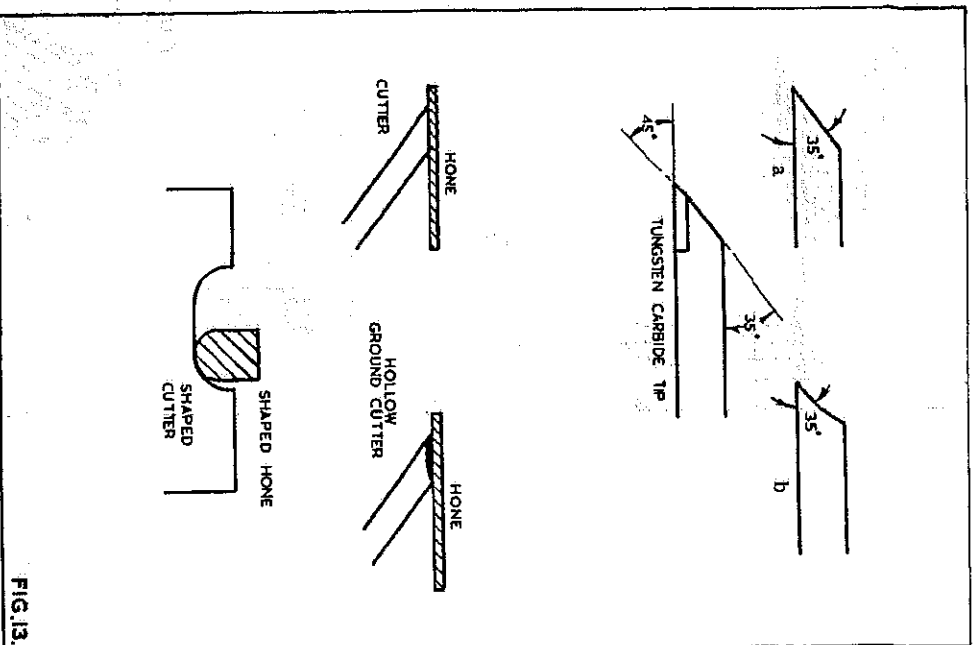


FIG. 13.

### CUTTER GRINDING

Cutter should be ground carefully avoiding any overheating as this will crack or soften cutters so that they will not stand up to the work.

A solution of soluble oil and water should be handy and the cutters should be held in this occasionally to cool them. This solution will also prevent rusting. Cutters should never be allowed to become discoloured during grinding, as this indicates overheating.

The correct cutting angle of 35° for most cutters should be maintained as this gives the correct strength to the cutting edge. When hollow grinding is carried out, the angle of the cutting edge, should be kept as near 35° as possible, see fig. 13(a) and (b).

Hollow grinding is recommended wherever possible, as a keen cutting edge is more easily obtained when hand lapping. When lapping or stoning a flat ground cutter, a good edge is more difficult to obtain due to the tendency to rock the stone and leave a convex face.

Good open grain wheels should be used and should not be allowed to become glazed, as this will cause excessive heat.

About 12" (304mm) diameter wheels used down to 10" (254mm) give the best radius for a hollow grind and an economic life. 8" (204mm) wheels used down to 6" (153mm) leave the grind too hollow.

Tungsten carbide tipped cutters should be purchased the shape required and re-ground only as necessary. In this case cutters should be relieved at 35° on the steel position and the tips finished with a diamond impregnated wheel at 45° as shown, using only very light cuts to prevent cracking. The diamond wheel should not be allowed to touch the steel backing as this clogs the wheel and causes excessive heat. Where available a copious flow of coolant should be used. They may be honed with a Diamond hand lap, as the cutter becomes dull, until a re-grind is necessary. A thin oil lubricant should be used on the hand lap.

All cutter blanks sent out by us are ground only and if used as choppers or rebate cutters require honing with a 142 carborundum slip stone to produce a razor sharp edge before commencing to cut. This will ensure a good finish on the wood and an easy feed. Dull cutters give a poor, rough and plucked out finish, and make it difficult to feed the job past the cutters. Honing should be done

by a reciprocating or rotary motion on the cutter, using a little paraffin to give "bite" to the stone. The honing stone is a much finer grit than the grinding wheel and leaves a sharp keen edge. A number of honing stones of different shapes, e.g. round sticks or square sticks will be found helpful in honing shaped cutters.

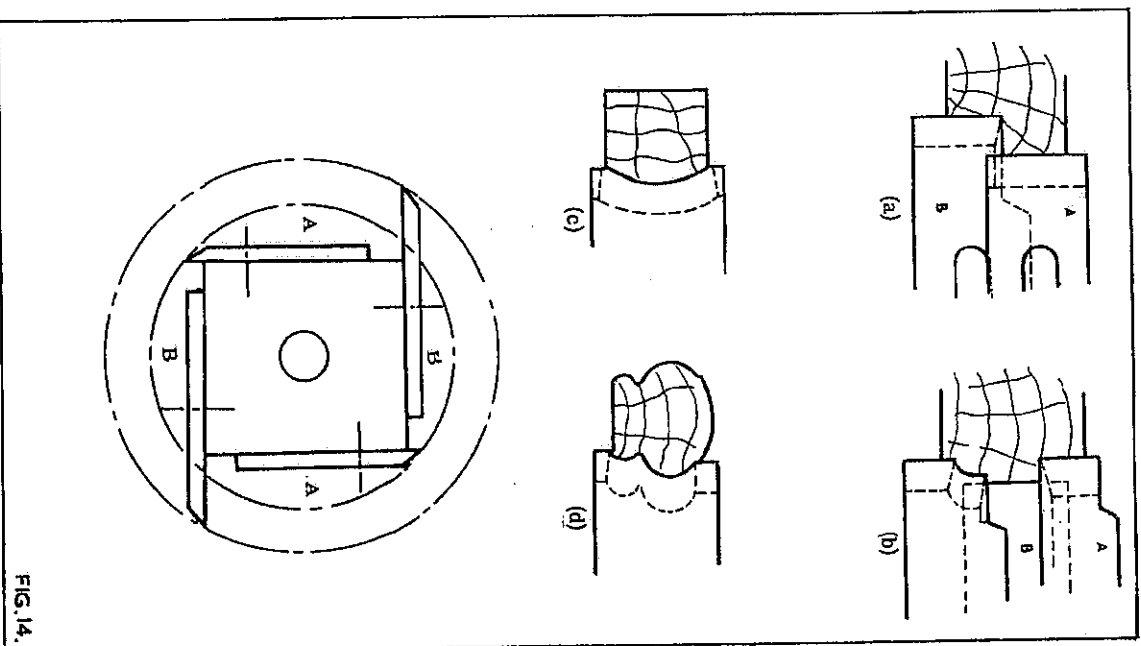


FIG. 14.

### TYPICAL CUTTER LAYOUTS

In all cases where possible when using square cutterblocks it is advisable to break up the cut over two or more pairs of cutters, this has many advantages as is shown in the examples shown in fig. 14.

Fig. 14 (a) SIMPLE REBATE. By using two pair of cutters there is very little grinding to be done, only side relief on the cutters "B" to give a good clean cut and prevent burning. Cutters are mounted on all sides of the block. This also spreads the cut over the four sides of the block and gives a smoother action.

Fig. 14 (b) SASH MOULD. This is best worked with three pairs of cutters as it enables correct side relief to be obtained on all cuts. It also allows the same cutters to be used with varying widths of mould as they can easily be adjusted sideways.

Fig. 14 (c) and (d) HAND RAIL MOULD. This is broken up into three separate operations. At fig. 14 (c) the top is worked first so that the timber runs on a flat face. This cut is done by only one pair of cutters. At fig. 14 (d) the sides are worked in two operations, one pair of cutters doing all the side work.

By breaking the moulds up as illustrated, it is possible to use the same cutters for many moulds thus reducing the total quantity of cutters required, it makes grinding of side relief a simple operation and enables the exact shape to be obtained by adjusting pairs of cutters across each other. It is essential to have each pair of cutters balanced for smooth vibrationless of the machine.

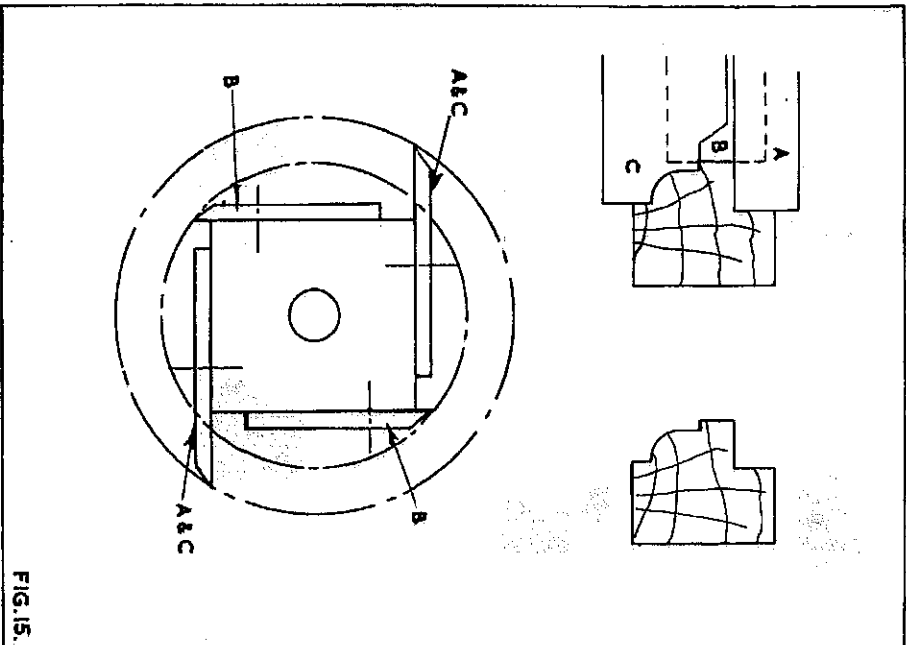


FIG. 15.

**FRAMING ON SQUARE BLOCK FIG. 15.**

Equipment required :- 1½" (30mm) diameter loose screwed spindle, square cutterblock three pairs of cutters, straight fence and saw guard. The cutters will have to be shaped to suit the moulded portion, allowing for angle by using the moulder's rule. Each pair of cutters must be balanced to prevent vibration, then accurately set up on the square block, so that all are cutting.

The cutterblock is then mounted on the spindle, fences set correctly in line, top and side spring pressures set to hold work firmly to the fences, adjustable.

Spindle speed :- 4, 500 rpm.

Note :- Cutters are always used in pairs to maintain balance.

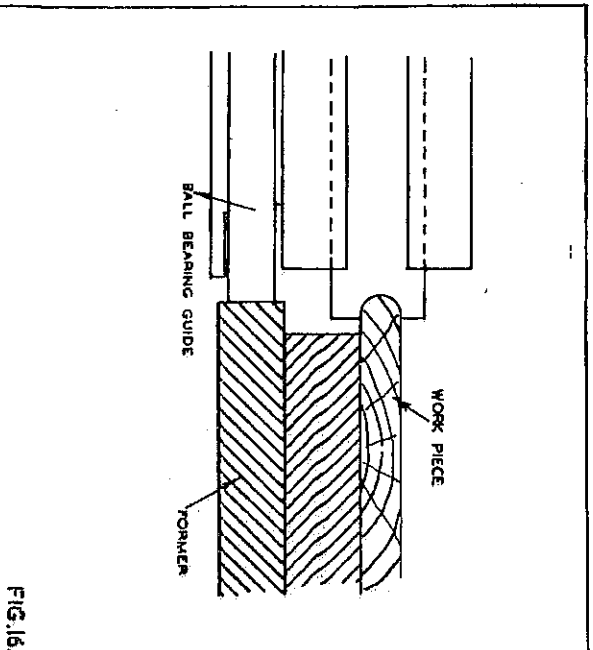


FIG. 16.

**SHAPED PANEL ON SLOTTED COLLARS FIG. 16.**

Equipment required :- 1" (25mm) diameter loose screwed spindle one pair of slotted (one being the ball bearing type) one pair nosing cutters and safety guard with flaps. The cutters are set up in the collars keeping minimum track in line with the bottom ball bearing slotted collar. The collars are mounted on a 1" (25mm) diameter loose top piece. The work piece is held by spikes to master former which is below the work.

The safety guard is set to cover the cutters and top piece. The former is passed across the guide. The cutters are completely shielded from the operator's hand by the work.

Spindle speed :- 7, 000 rpm.

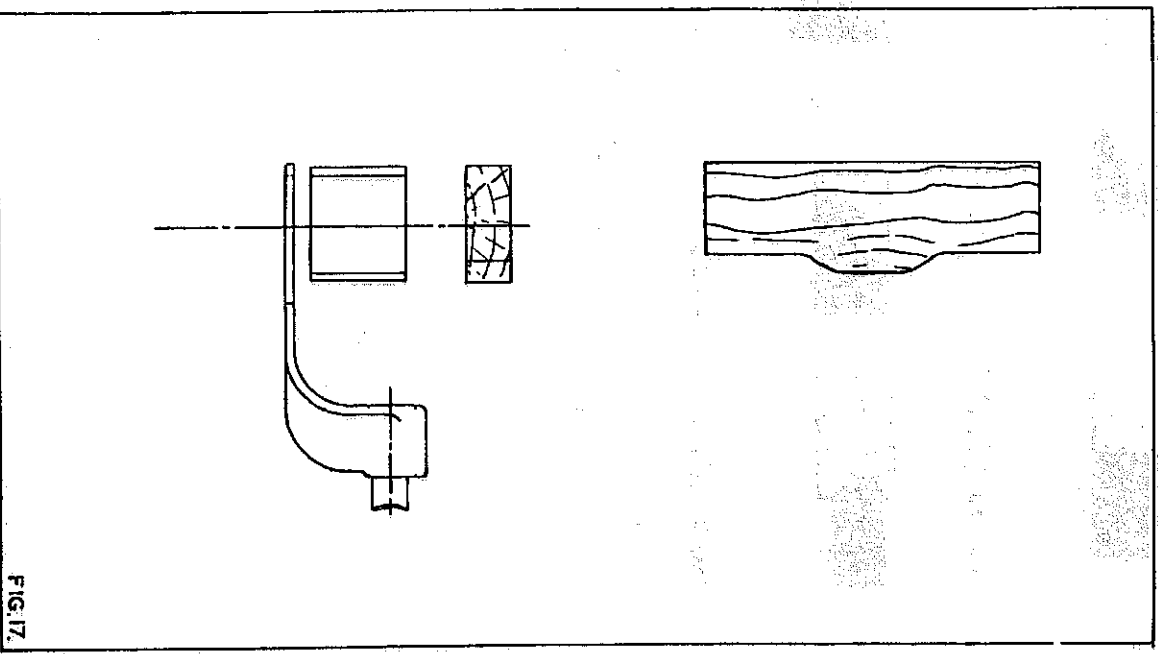


FIG. 17.

**CIRCULAR CUTTERBLOCK WORK FIG. 17**

Equipment required :- 1½" (30mm) diameter loose top piece, 3" (76mm) deep circular cutterblock, ring fence and safety guard with flaps.

The cutterblock is mounted on the 1½" (30mm) diameter loose top piece and set so that cuttertrack is in line with the ring fence as shown in Fig. 17. The guard is then set to cover up block and top piece leaving only sufficient room for work to pass underneath.

Work is to be mounted on a shaped fixture which is held up to the ring fence. Contact must always be at the same point on the ring fence to ensure even depth of cut. This is essential due to the shape of the ring.

The circular block gives a good smooth cut and finish to work.

Spindle speed :- 7, 000 rpm.

## A FULL RANGE OF SOLID PROFILE CUTTERS CAN BE PROFITABLY USED.



**No. 2** 1 1/2" Square edge  
Cutter (1 1/2" bore)



**No. 8** 3/16" Tonguitting  
Cutter (1 1/2" bore)



**No. 9** 3/16" Grooving  
Cutter (1 1/2" bore)



**No. 13** Reversible Glue  
Joint (1 1/2" bore)



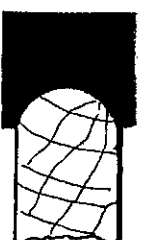
**No. 19** 5/16" Rad. Ovoid  
Cutter (1 1/2" bore)



**No. 22** 3/4" dia. Nosing  
Cutter (1 1/2" bore)



**No. 23** 7/8" dia. Nosing  
Cutter (1 1/2" bore)



**No. 24** 1" dia. Nosing  
Cutter (1 1/2" bore)



**No. 31** 1/2" Rad. Cutter  
(1 1/2" bore)



**No. 36** 3/8" Rad. Ogee  
Cutter (1 1/2" bore)



**No. 42** 45° Angle  
Cutter (1 1/2" bore)



**No. 43** 30° Angle  
Cutter (1 1/2" bore)



**No. 51** Table edge  
Cutter (1 1/2" bore)

### INSTRUCTION FOR REGRINDING PROFILE CUTTERS

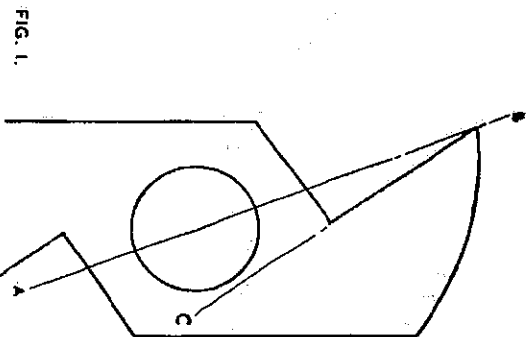


FIG. 1.

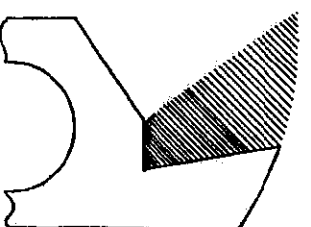
There are two methods of grinding these cutters:

1. With precision tool grinder. This method involves grinding the cutter on an arbor between centres. The machine should be set to grind the face of the cutter so that angle ABC, in Fig. 1 is the same after grinding as it was originally.
2. With hand or bench grinder.

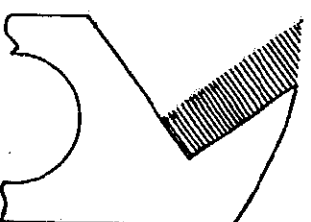
Before regrinding the cutters by this method ensure that the check chart supplied with the cutters is to hand. To check the angle of the cutters, place the new ground face, i.e. line BC, in Fig. 1, against that of the check chart and when the angles correct the bore of the cutter should correspond to that of the check chart. This ensures that the correct angle is maintained at all time.

#### NOTES

1. A slight variation in the angle ABC, in Fig. 1 on opposite wings of the cutter is not too important, but for the best results avoid having the point "B" in Fig. 1 or its opposite on a different radius. This would cause one cutting edge to do all the cutting and would make the cutter out of balance and cause vibration.



CORRECT



WRONG

FIG. 2.

FIG. 3.

2. When making single cuts with more than one cutter in the set up always STAGGER the cutting edges rather than line them up. Doing this improves the quality of the work and reduces vibration and chatter. Staggered cutters require less power than "in line" cutters.
3. Cutters must always be ground in the root of the tooth, as shown in Fig. 2 never as in Fig. 3. Otherwise the cutters will drag or fail to cut the complete shape. Failure in observing this point results in weakening the tooth form and shortening the usable life of the cutter.

#### 4. REGRINDING SERVICE

We offer precision regrinding service and the charges are moderate and the service prompt.

#### RETURN THE CUTTERS TO:

BURNSGREEN (DURHAM) LIMITED,  
FENCE HOUSES,  
HOUGHTON LE SPRING,  
CO. DURHAM  
ENGLAND

#### CAUTION

We do not recommend these cutters to be used on anything but short runs of plywood or resin bonded wood substitutes, because resinous glues used in making plywood etc. are extremely hard and abrasive. This causes the cutters to overheat and soften if not of the Tungsten Carbide Tipped variety. Write for prices of special tipped cutters for such materials.