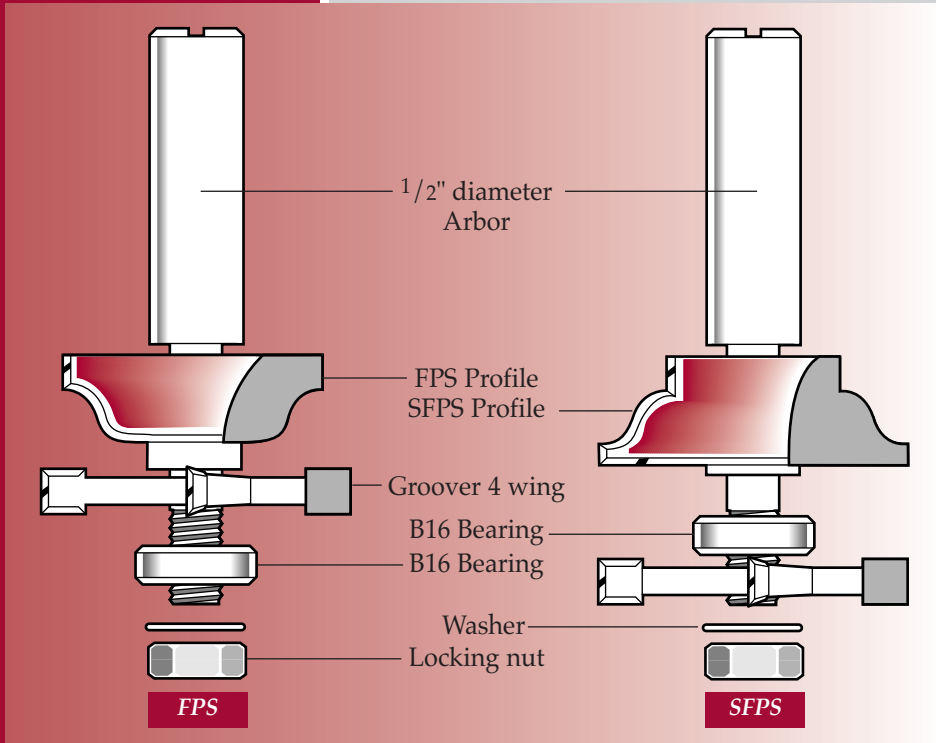


# Titman's

INSTRUCTIONS  
FOR USE

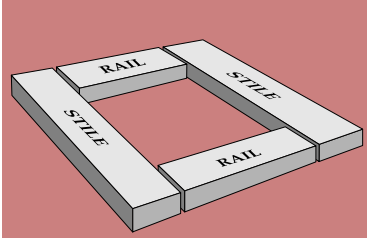
## FPS - SFPS Profile and Scribe Sets



*A two piece cutter set. Scale 1-1*

*A dedicated male and female cutter set that offers seven various profiles on an arbor.*

*The set can be used on fixed head routers, portable machines or inverted in a router table.*



## Correct use of FPS and SFPS cutter sets

Make sure your work area is safe and free from obstruction. Get organised and be safe with your routing machine. Read our Safety Guide.

The first requirements on all profiling and scribing sets are:

Be sure to use good quality timber hardwood or softwood.

Ensure the timber is planed and square and all pieces are the same thickness - ideal timber thickness is 22mm.

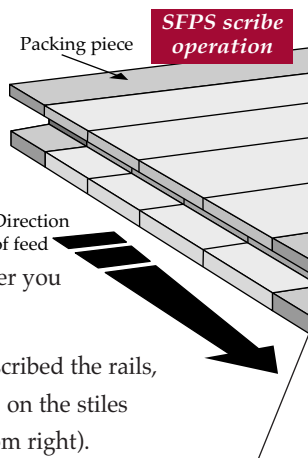
**1** First cut your rails to size in preparation for machining the scribe section, if you profile first you could have breakout problems when cutting your scribes. Ensuring all rails are the same thickness, clamp together, possibly four at a time, with packing pieces at each end, this will prevent breakout at the end of the cut.

Place the SFPS cutter into the machine, (three quarters of shank must be gripped in the collet). Make sure face plate is smooth and free from obstruction. Set depth stop to exact depth required to cut scribe and tenon

allowing sufficient strength on the quirk part.

**2** Machine (rout) both ends of rails taking care not to breakout at the end and make sure you set your packing pieces exactly to the end of the timber you wish to cut.

**3** When you have scribed the rails, then run the profile on the stiles and rails, (see bottom right).

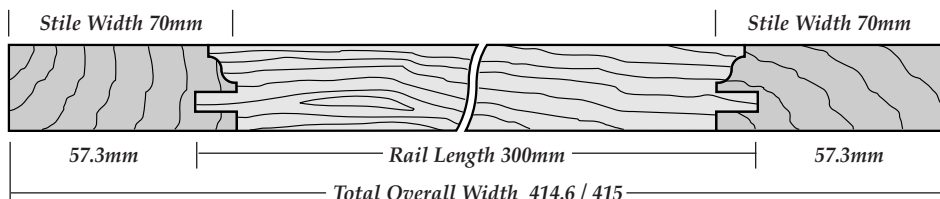


Quirk part-leave minimum of 2mm thick

When producing rails, work out your overall door width from the bottom of the groove (groove depth is 12.7mm).

### For example

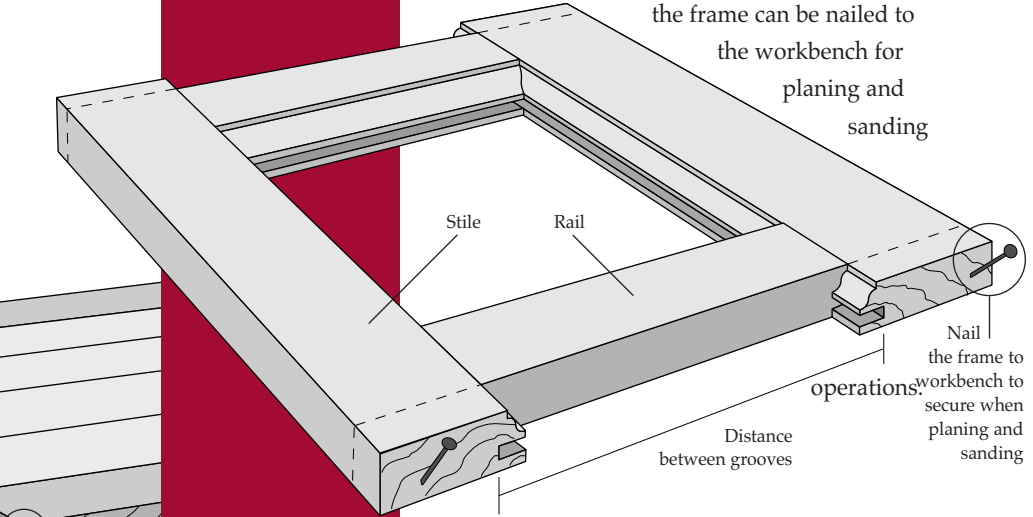
Width of stile	= 70mm
Less 12.7 (groove depth)	= 57.3 approx
Length of rail	= 300mm
Less 2 x 12.7 for tenon length	= 275 + 140 (140 = 2 x the stile width)
Total door width	= 415mm



# Producing Stiles and Rails

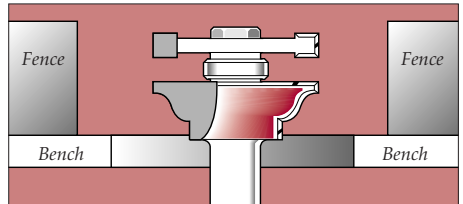
When producing stiles always leave 20mm longer at both ends. This allows for run out when profiling the edge, and by leaving the stiles longer

the frame can be nailed to the workbench for planing and sanding



See separate Titman leaflet for producing the panels

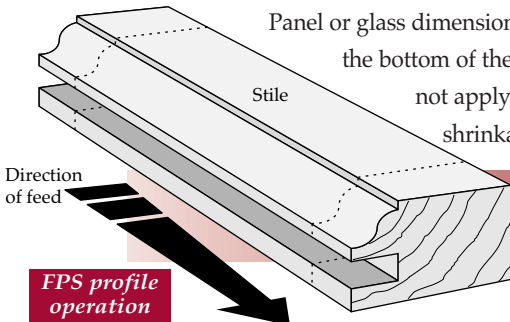
Packing piece



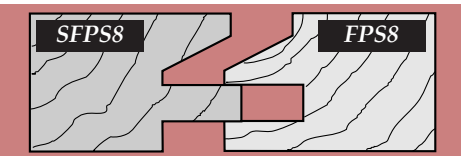
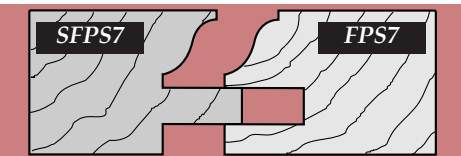
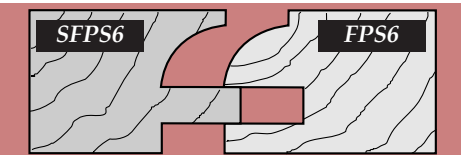
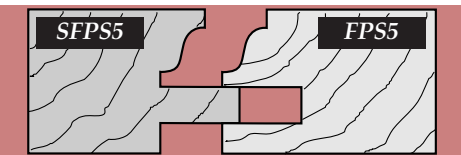
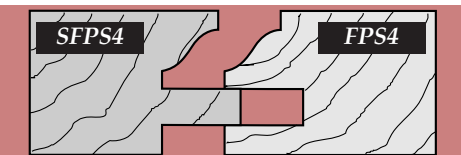
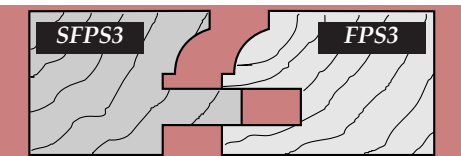
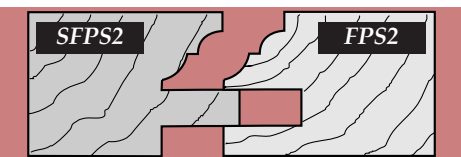
Cutter undermounted for Profiling

Profiling stiles and rails is best achieved on a Router Table with the cutter in the undermount mode.

Panel or glass dimensions are determined by the distance between the bottom of the grooves. Allow 2-3mm for correct fit, do not apply glue to the panel as this will restrict any shrinkage and cause the panel to split.



See the full range of shapes and Titman hints on back page



## Hints

- 1** Always use a test piece to check that profile and scribe match.
- 2** Make sure you locate on the roller bearing, all sizes are checked from the bearing diameter and is our absolute datum point.
- 3** When using these cutters in a router table, be very careful when running the scribing cutter (SFPS) it is good practice to clamp the material in a form of jig box to allow for a secure grip on the components.
- 4** Return cutters to an authorised Titman Distributor to ensure safe and correct sharpening and matching of cutters.
- 5** Remember:  
**Measure twice - cut once.**

The complete sets are shown on the left.

For further information on this or any other Titman product or service, please contact our Technical Department.



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