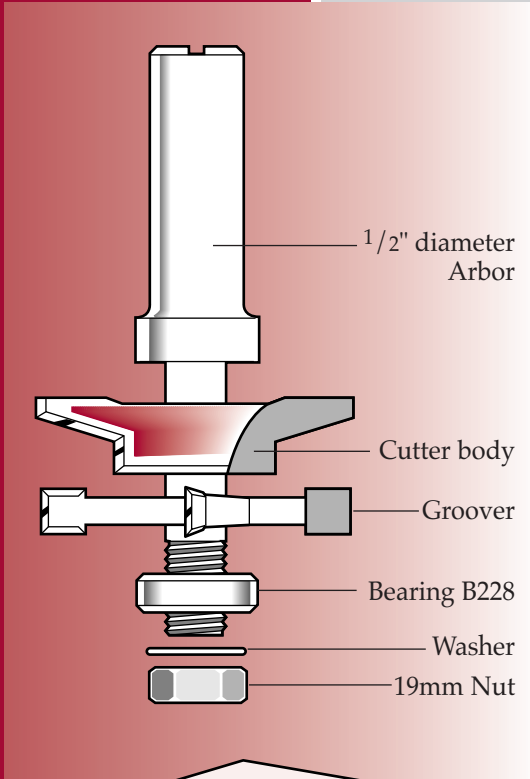


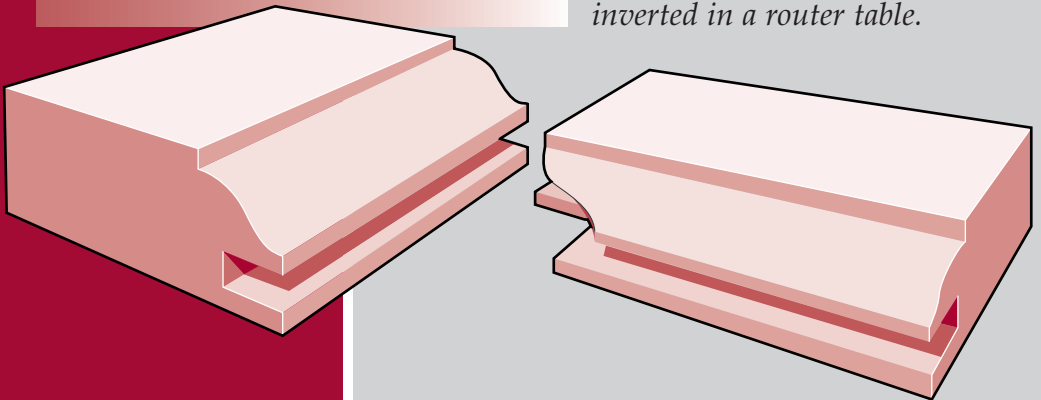
Titman's Profile/Scribe Cutter

INSTRUCTIONS FOR USE



A one piece cutter set. Scale 1-1

A profile and scribe cutter mounted onto one arbor with a bearing designed for short production runs. The one cutter will cut both the scribe and profile by simply removing the securing nut and washer on the bottom of the arbor and re-assembling the groover, bearing and cutter. The set is suitable for timber thicknesses of 18 - 22mm and is for use on fixed head machines, portable machines over 2HP and inverted in a router table.



Correct use of RPSS sets on portable machines

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 The first operation in this procedure is to 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. With the rails cut to size, ensuring all are the same thickness, clamp the rails together possibly four at a time plus a packing piece at each end.

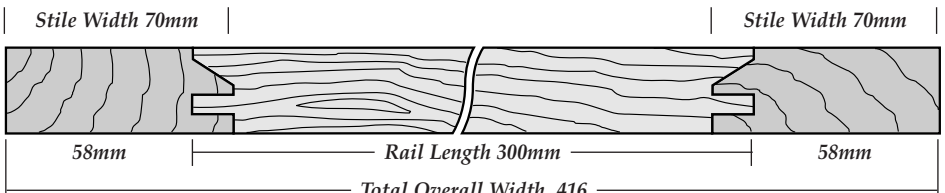
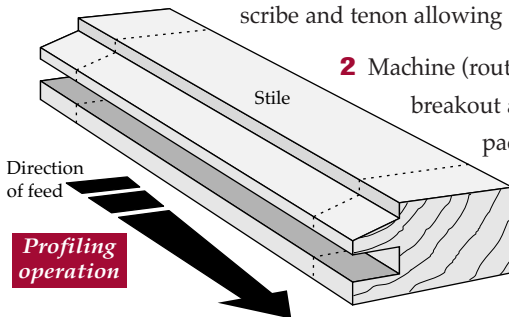
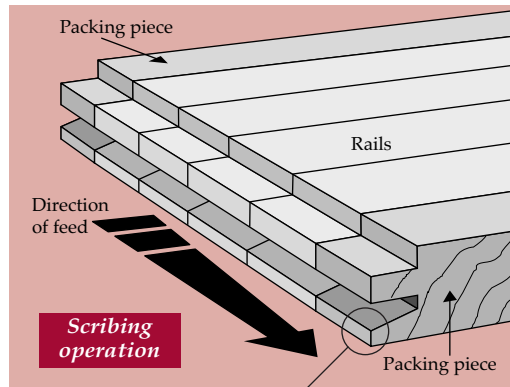
With all rails clamped together with the ends perfectly flush, take the cutter and assemble to the scribe position. Make sure the cutter is inserted into the collet by 3/4 of the shank length. Ensure the face plate of the machine is level and smooth. Set depth stop to exact depth required to cut

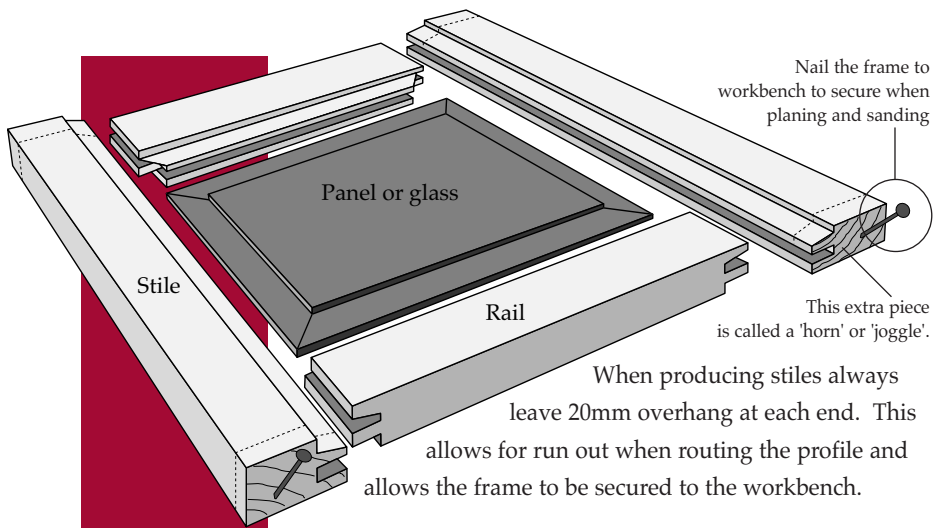
scribe and tenon allowing sufficient strength on the quirk part.

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.

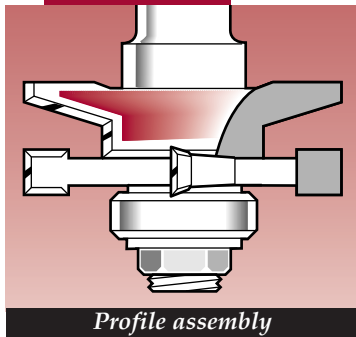
Make sure your work area is safe and free from obstruction. Get organised and be safe with your routing machine. Read our Safety Guide.



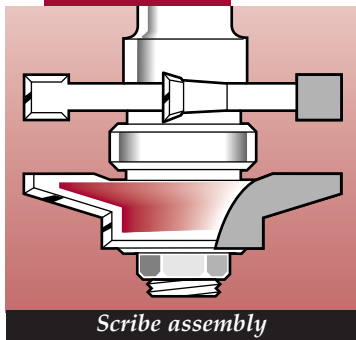
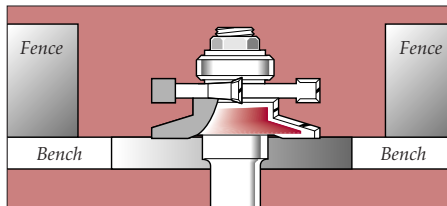


When producing stiles always leave 20mm overhang at each end. This allows for run out when routing the profile and allows the frame to be secured to the workbench.

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.



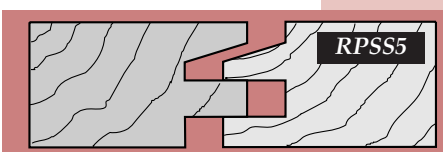
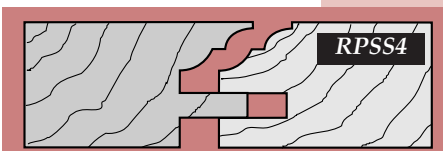
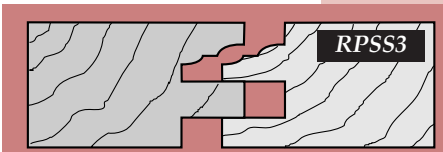
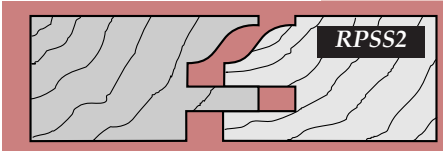
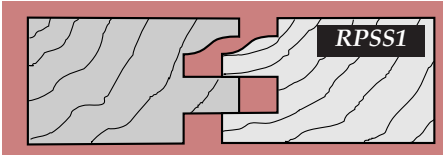
Cutter undermounted for Profiling

When producing rails, work out your overall door width from the bottom of the groove (groove depth is 12mm).

For example

- Width of Stile is 70mm
- Less 12mm = 58mm
- Twice the the stile at 58mm = 116mm
- + rail at 300mm = 416mm

See 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, care must be taken. 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.

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



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