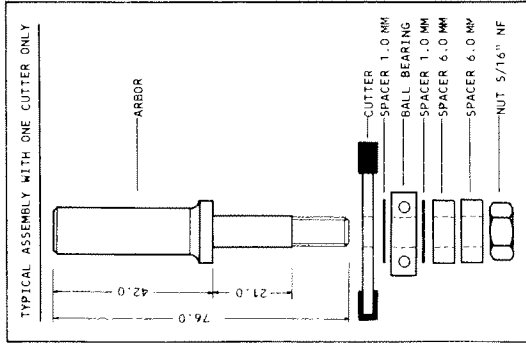


GROOVING WITH SINGLE CUTTER

WHEN USING ONE CUTTER ONLY, FOLLOWING FIXED WIDTHS CAN BE EXECUTED:

- 3.2 MM (1/8") WITH CUTTER A
- 4.0 MM (5/32") WITH CUTTER B
- 4.8 MM (3/16") WITH CUTTER C
- 6.35 MM (1/4") WITH CUTTER D

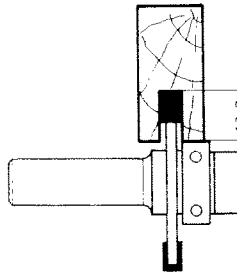


ENSURE THAT CUTTER WAS ASSEMBLED FOR CORRECT DIRECTION OF ROTATION (MARKING OF THICKNESS IS FACING ARBOR SHAFT)

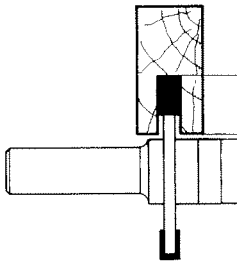
THE BALL BEARING MAY BE ABOVE OR BELOW THE CUTTER, BUT WASHERS MUST ALWAYS BE ON BOTH SIDES OF THE BALL BEARING TO ENABLE ITS FREE MOTION.

THE OVERALL LENGTH OF THE ASSEMBLY MUST BE AT LEAST 22 MM IN ORDER TO BE PROPERLY TIGHTENED BY THE NUT.

WORKING WITH BALL BEARING
NORMAL USE WITH BALL BEARING WILL GIVE A CONSTANT DEPTH OF 12.7 MM (1/2").



WORKING WITHOUT BALL BEARING
IF DEPTH OTHER THAN 12.7 MM IS REQUIRED, REMOVE BALL BEARING AND USE THE FENCE. MAXIMUM DEPTH WILL BE 15.5 MM. THE WOOD SHOULD NOT TOUCH THE SPACERS OR SHIMS.



GROOVING WITH COMBINED ASSEMBLIES

BY ASSEMBLING TWO CUTTERS OR MORE, EVERY WIDTH OF GROOVE OR DADO CAN BE ACHIEVED FROM 5.7 MM TO 18.0 MM IN INCREMENTS OF 0.1 MM. THE CUTTERS SHOULD BE ASSEMBLED SQUARE TO EACH OTHER TO FACILITATE CUTTING AND TO ENABLE OVERLAPPING OF WIDTHS.

TABLE 1
TOTAL THICKNESS OF SHIMS REQUIRED TO ACHIEVE FULL CUTTING WIDTH FOR COMBINED ASSEMBLY

ASSEMBLY	SHIMS MAXIMUM	SHIMS MAXIMUM
A	0.8 MM	3.2
B	0.7 MM	4.0
C	1.1 MM	4.8
D	1.4 MM	6.35

COMBINATION OF CUTTERS	WIDTH OF CUT (MM)
A + B	5.6 - 7.1
A + C	6.0 - 8.0
A + D	7.3 - 9.5
B + C	6.8 - 8.7
B + D	8.1 - 10.2
C + D	9.6 - 11.1
A + B + C	8.5 - 11.9
A + B + D	9.8 - 13.4
B + C + D	10.6 - 15.0
A + B + C + D	12.3 - 18.0

TABLE 3

RECOMMENDED COMBINATIONS FOR VARYING CUTTING WIDTHS. IF INTERMEDIATE CUTTING WIDTHS ARE REQUIRED, REMOVE OR ADD SHIMS ACCORDINGLY.

CUTTER	WIDTH MM																
	5.7	6	7	8	9	10	11	12	13	14	15	16	17	18			
SHIMS	A	A	A	A	C	C	C	B	B	A	A	A	A	A			
CUTTER	D	C	1.0	0.7	0.4	1.4	2.4	0.4	1.0	0.4	0.4	1.4	1.4	1.5			
SHIMS	B	B	C	D	0	0	0	C	C	B	B	B	B	B			
CUTTER								1.0	1.4	0.3	1.3	1.3	1.3	1.8			
								0	0	C	C	C	C	C			