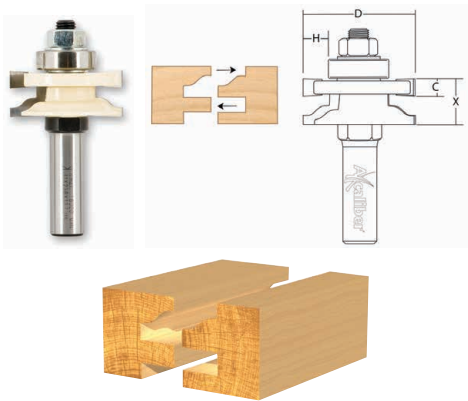


Reversible Stile & Rail Cutters

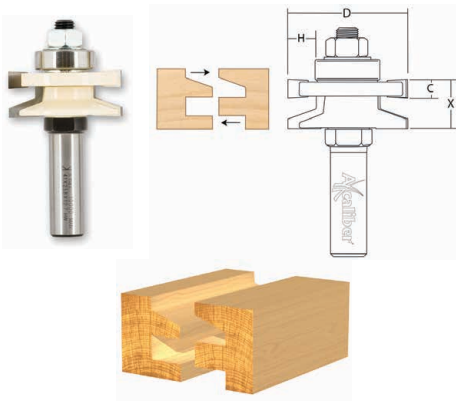
Instructions



Axcaliber Reversible Stile & Rail Cutter (Ogee)

Code: 666216

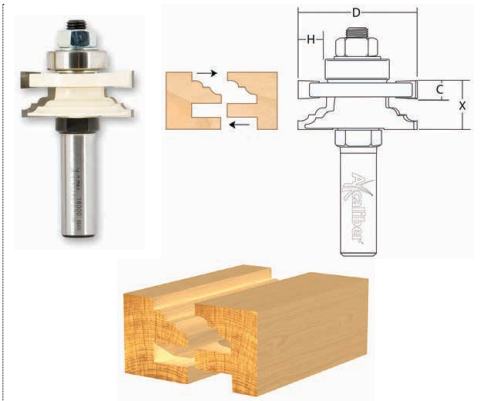
- Two-piece cutter set
- Produces profile and scribe cuts
- 1/2" shank



Axcaliber Reversible Stile & Rail Cutter (Bevel)

Code: 666217

- Two-piece cutter set used for the making of items like kitchen doors, bath panels or even display cabinets
- Allows for accurate repeat setting up and the machining of curved components
- Produces profile and scribe cuts
- 1/2" shank
- Suitable for use within a router table only
- Recommended timber thickness: 18-22mm



Axcaliber Reversible Stile & Rail Cutter (Classic)

Code: 666219

- Two-piece cutter set
- Produces profile and scribe cuts
- 1/2" shank

Safety Note

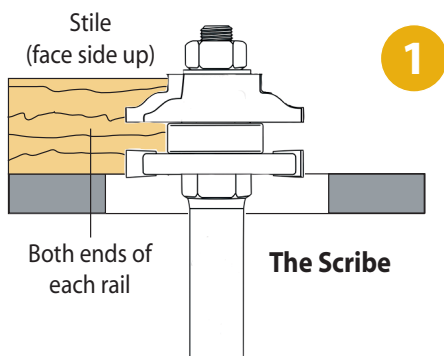
- Use only in a table mounted router. adjust the speed at reduced recommended 16,000rpm.
- Use a push block and featherboard for safe, accurate cutting.
- Test cuts are recommended so that a snug fit is achieved.

How to set up Profile and Scribe cuts from the single router cutter

The profile cuts can be made first but it is recommended to make the scribe cuts first (allowing for backer board to limit breakout on the profile edge)

Scribe cut cutter configuration

1. The cutters and guide bearing need to be arranged as shown in Fig. 1. If they're not already in that order remove the nut at the top of the bit and arrange as follows; starting from the shank end, straight cutter, bearing, profile cutter. Install the washer and use a spanner to tighten the nut at the top of the bit, taking care to maintain alignment of the cutting edges.

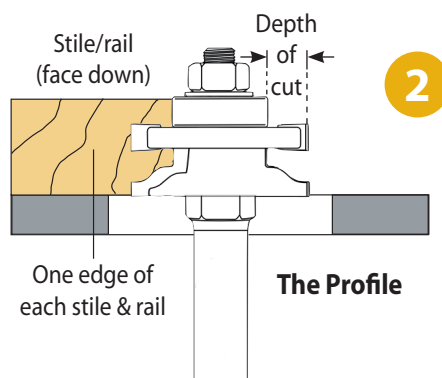


Do not invert any of the cutters, and make sure the cutting edges are facing as shown.

2. Install the bit securely in a table-mounted router and adjust router speed accordingly.
3. Using a piece of your stock as a reference, adjust the bit cutting height until you achieve the desired profile (taking into account the thickness of your centre panel).
4. Position the fence so that it aligns with the bearing guide on the bit and lock in position.
5. Position a sliding table/mitre fence with a backing board to support the workpiece and limit breakout.
6. Secure a test piece that's the same thickness as your workpiece and make a test cut.
7. Adjust the bit height as necessary and make additional test cuts until you're happy with the profile.
8. Then, with the front face oriented up, make the scribe cuts on the ends of your rails.

Profile cut cutter configuration

1. The cutters and guide bearing need to be arranged as shown in Fig. 2 remove the bit from the router and remove the large hex nut at the top.



2. Starting from the shank end, stack the bit in this order: profile cutter, straight cutter, bearing as Fig. 2. and use a spanner to tighten the nut. Taking care to maintain alignment of the cutting edges.



Do not invert any of the cutters, and make sure the cutting edges are facing as shown.

3. Install the bit securely in a table-mounted router (adjust speed as before)
4. Using one of your rail ends as a reference, adjust the bit cutting height so the bit profile lines up with the scribe profile on the rail.
5. Make sure the fence aligns with the bearing guide on the bit and lock in position
6. Using a scrap piece that's the same thickness as your workpiece, make a test cut. Bring the stile and the scribe end of the rail together to test the fit. Adjust the bit height as necessary and make additional test cuts until the rail and stile pieces form a flush joint. Changes in tightness can be achieved by adding or removing the supplied shims between the cutters as required. This is most important after resharpening.
7. With the front face down, against the table, rout the profiles/grooves on the inside edges of your rails and stiles.