

Please read
all
instructions
before use.

Adjustable Tenon Cutter

Instructions for Operation and Care

☛ **Note:** This product has been factory-tested and comes to you properly adjusted for optimum cutting. Please do not make any further adjustments until you are familiar with this design.

☛ **Cutting Length Adjustment** – the $\frac{1}{4}$ Allen wrench (supplied) is used to adjust the driveshaft length (A), which also serves as the stop to control tenon length. **CAUTION:** do not use excessive force on any screws in this design – hand-tighten only with wrench provided.

☛ **Cutting Diameter Adjustment** – loosen the bottom ‘leg’ screws (B) with Allen wrench, about $\frac{1}{2}$ turn each. With screws loosened, rotate bottom plate (C), allowing blade holder and guides to move in and out in unison. Use the scribe lines on the bottom plate (beside blade holder) as a reference for gauging amount of setting change. Tighten leg screws and the cutter is ready for use.

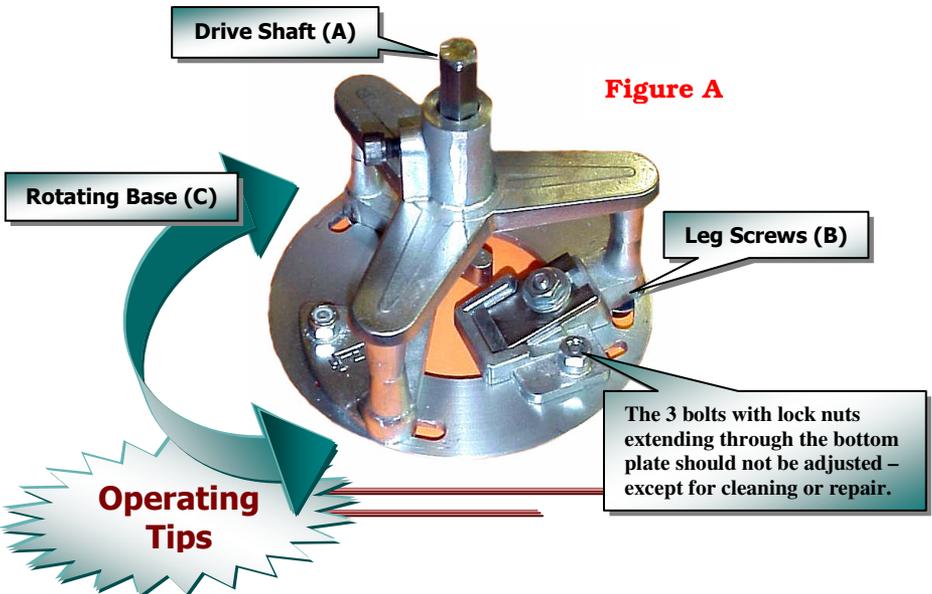


Figure A

- ☛ Set drill speed for **400 RPM**; feed work in slowly and steadily.
- ☛ Very little force is required for cutting with a properly sharpened blade.
- ☛ Always use a Spoke Pointer (**#270, #275**) to find the center of the spoke. Turn the spoke tip small enough that it will start into the Tenon Cutter.
- ☛ To produce clean, splinter-free edges on spoke shoulders, put two wraps of $\frac{3}{4}$ " masking tape around the shoulder before turning and then turn, removing about half the tape.

Blade Adjustment & Sharpening

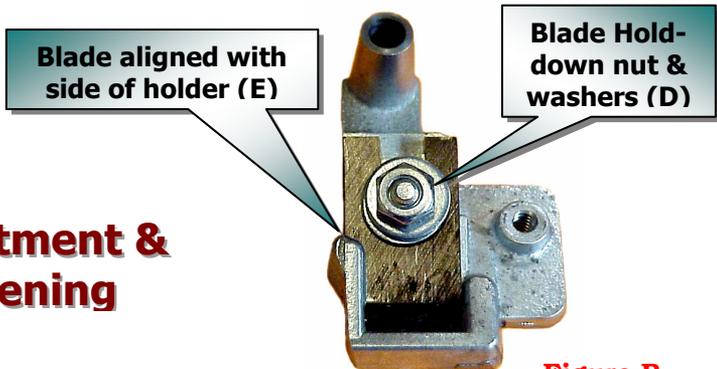


Figure B

- ☛ To remove the blade – first remove the Blade Hold-down nut (D) and washers. These washers help keep light tension on the blade when adjusting the depth of cut.
- ☛ Blade sharpening should first be done with a fine grinding stone and finished by honing with a very fine oilstone.
- ☛ The blade must be ground square (at **90 degrees**) to cut properly and leave a square shoulder on the spoke.

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- ☛ Grind, and then hone the top of the blade at 30 degrees (**FIGURE C**), then hone any burr from the bottom at less than a 20-degree angle. (This removes the featheredge and helps the blade to stay sharp longer.)

Examine your new blade before using to see the proper angle.

- ☛ Holding the hone at 30-degrees to the top of the blade, carefully remove the inside corner (about 1/32") to prevent overheating and faster dulling.

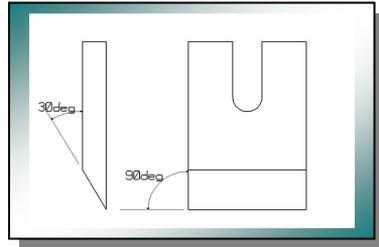


Figure C

- ☛ Installing the blade – be certain the blade is realigned with the side of the blade holder (See **Figure B, section E**). The blade should extend out the bottom of the blade holder a few thousandths of an inch (similar to how you would adjust a hand plane).
- ☛ A properly adjusted blade depth removes a very fine shaving. A shallow setting will not cut, and a deep setting will cause excess splintering.

Maintenance:

- ☛ This blade is made of tool steel and will hold a cutting edge for several cuts. Eventually though, it must be sharpened or replaced. (Spare blades are available from your dealer.)
- ☛ The blade should be kept sharp to protect it from

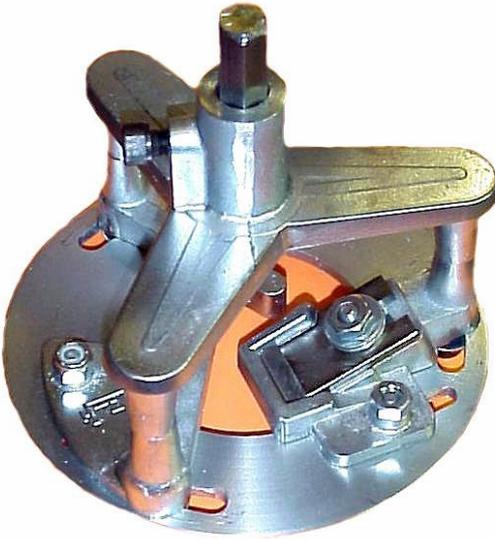
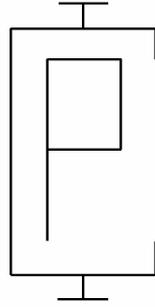
excessive friction and heat, which can shorten blade life.



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Adjustable Tenon Cutter



Part # 262

Operating & Maintenance