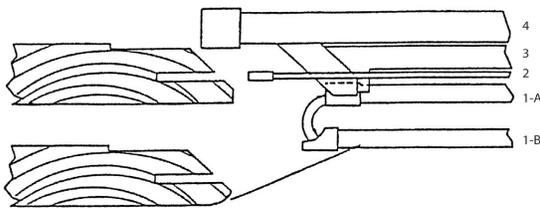


# ALUMINUM OUTSIDE CORNERS CUTTER

This five piece cutter head (Part No. CW-TOOLS) is the key to the unique cut used in the CW System. Excellent for use in a high volume manufacturing shop with minimal floor space. Works with pre-laminated stock to speed production process

Blade #1-A is used in the stack for all corner shapes currently in our stock.



## TOOL CARE AND SHARPENING

The cutter head stack, as shimed, is ready for installation. Sets are unique and blades from different sets should not be mixed.

The CW System cutter head set is a balanced set. Cutters should only be sharpened by a carbide shop familiar with this type of miter lock set.

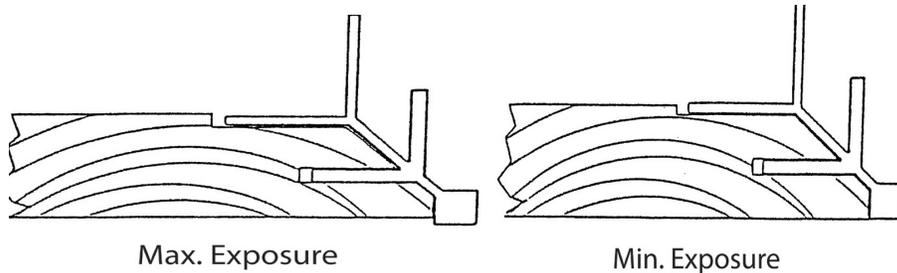
## SET-UP

The cutter head is designed to fit a 1 1/4" spindle on a standard wood shaper. Bushings are available to adapt the cutter head to a 1" or a 1 1/8" spindle if required.

Suggested minimum spindle RPM: 5000. We recommend 7000 to 10000 RPM. Suggested rate of feed: 15 to 18 feet per minute.

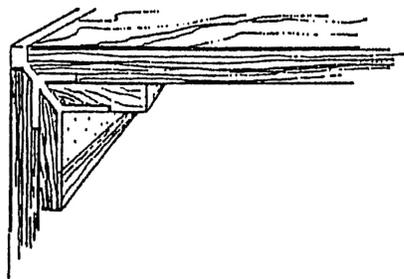
The cutter head set is designed for a shaper using a minimum 5 HP motor, though other power ratings have been used successfully.

**All cuts are done on a shaper with the finish side down. This allows one set up regardless of the thickness of the panel being shaped. You can adjust the exposure on the extrusion by adjusting the height of the cutters on the shaper (see below).**



**If a panel thickness of less than .688 (5/8" plus 1/16" laminate) is used, simply glue a wood strip or cleat board along the edge prior to running the panel through the shaper.**

Illustration A



See note in "Material Differences" below.

## **FIT / ADJUSTMENTS**

**We recommend a snug fit of the extrusion into the cut in the panel. Minor shim adjustment may be required from time to time due to normal tolerances allowed in the extrusions and your fit requirements.**

**\*NOTE\* For explanation purposes, it would be helpful to view the aluminum extrusion as a "stick man".**

**When attaching the extrusion to the panel, the fasteners are normally angled (when possible) to tighten or draw the extrusion to the edge of the panel. If the extrusion fits too loose in the cut, this**

practice may result in some inconsistency in the reveal of the extrusion because the fasteners installed in the first leg of the extrusion may be at a different angle than those installed in the second leg.

We recommend a #6 X 9/16" truss head screw for attaching extrusions to most panels.

## **MATERIAL DIFFERENCES**

Different panel materials may make some difference in the set up, assembly and the time between sharpening of the cutters. The finer the grain (or particles) of the material, the cleaner and more consistent the cut. For example, MDF (medium density fiberboard) will cut with less flaking and may be easier to hold straight as it is fed through the shaper than would a more coarse grain wood product. Plywood works well on smaller panels, i.e. toe kicks, but will be more difficult to fit the extrusions into, on larger panels due to its flexibility and flaking.

## **FREQUENTLY ASKED QUESTIONS ABOUT THE CW SYSTEM EXTRUSIONS**

**Q:** What are the minimum and maximum thickness of material that work with the system?

**A:** The extrusion is designed for use on 3/4" material but can be used on 1/8" to 1 1/8" stock. If you are using stock that is less than .688 (5/8" plus 1/16" laminate), you must add a cleat to the back side of the stock to allow for the cut in the wood to hold the extrusion. (see *illustration A*)

**Q: What allowances do I make for the extrusion when sizing my panels?**

**A: If using P/N's ALU5116-S, ALU5272-S, you allow 1/4" for one corner and 1/2" if you are using the corner on both ends of the panel.**

**If using P/N's ALU5162-S, ALU5164-S, you allow 1/8" for one corner and 1/4" if you are using the corner on both ends of the panel.**

**If using the ALU5163-S extrusion, you allow 3/4" for one corner and 1 1/2" if using the corner on both ends of the panel.**

**Q: How tight should the extrusion fit into the cut?**

**A: Most extrusions will have a slip fit into the cut in the wood. There is one exception: The ALU5272-S is designed to fit fairly snug and is normally stapled into place through the thin flange on the back. The ALU5299-S is designed to fit tight since it is held in place by gripping teeth in the extrusion. These may be installed with a rubber mallet.**

**Q: How often will my cutter head need sharpening?**

**A: We estimate a new (or properly sharpened) cutter will cut approximately 15,000 to 20,000 lineal feet of panel edge in good grade particle board. Expect less footage on "dirty" or abrasive materials.**

**OUTWATER PLASTICS INDUSTRIES, INC.**