

3-in-1 Shaper Sets

MLCS Items #1008, #1009,
#1108 & #1009
KATANA Items #11008, #11009

***NOTE: These cutters do not utilize a rub collar to control the depth of cut. Please use these with a fence or optional rub collar #9126 for cathedral doors.*

***Always make the end grain cuts first to avoid tearing out additional material on the long grain cuts.*

MAKING PANELED DOORS

1) Install the Shaper Cutters stacked as shown in **Figure 12A** for the cuts on the ends of the rails (this will create the tongue on the rails).

2) Set the cutter height so that you have at least 1/8" to 3/16" above the tongue. Set your fence so that the carbide protrudes exactly 3/8" from the fence (if it is less than 3/8" you will not get the full cut, and, if it is more than 3/8", you will shorten your rail length). For narrow rails, use a miter gauge or a Coping Safety Sled (MLCS Item #9544, #9546 or #9548). Cut your rails.

3) Leaving the fence at the same position, change the shaper cutter stacked as shown in **Figure 12B** for the long cuts on all pieces (both rails and stiles). Using the rail ends that you have already cut, adjust cutter height so that the 1/4" slot cutter is lined up at exactly the same height as the 1/4" tongue on the rail end. Run a piece of scrap and check for fit. Adjust cutter height as needed to get a flush fit. Cut the stiles and long cuts on the rails.

Figure 12A

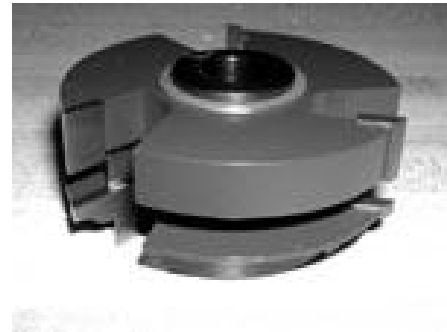


Figure 12B



3-in-1 Shaper Sets

MAKING GLASS DOORS

1) Follow the same directions as making paneled doors above, with the exception of how the shaper cutter will be stacked. Please refer to **Figure 13A** (long cut) and **Figure 13B** (rail/cope cut) for proper stacking order.

MAKING TONGUE and GROOVE JOINTS

1) Refer to **Figure 13C** for proper stacking order of the cutters.

2) It will be easier to set up if you make the tongue cut first.

3) Set the cutter height so that the large 1/4" slot cutter is at the top of your stock. This will center the tongue in 3/4" stock and place the tongue 1/4" from the top of the stock.

4) Set the fence so that 3/8" of the carbide protrudes from the fence. Run your first piece of stock. When properly set, just the tongue will touch the outfeed fence.

5) To cut the groove, leave the fence set and remove all but the larger diameter 1/4" slot cutter. Use the tongue to set the cutter height, as the slot cutter should be exactly at the same height as the tongue on the piece of stock cut previously. Run a scrap piece and check for fit. Adjust as necessary to get a flush fit and then run the remaining piece.

Figure 13A



Figure 13B



Figure 13C

