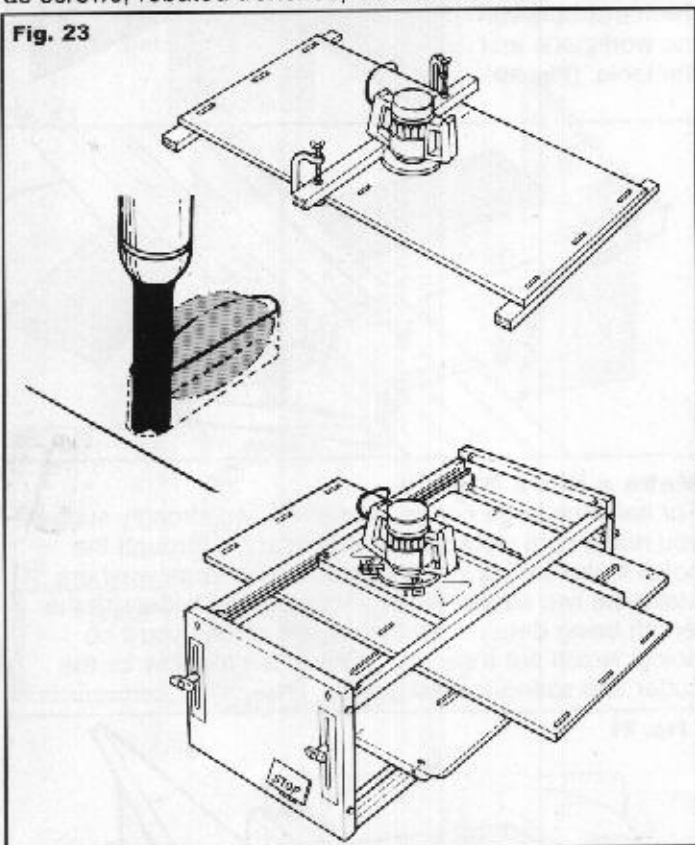


Mid-panel Joinery

The Biscuit Joiner cannot be used for cutting slots more than 25mm from an end or an edge of a panel. For certain jobs (eg. sides of a bookcase or cabinet), consider using another method of fixing shelves or dividers, such as screws, rebated trenches, cleats or dowels.

Fig. 23



If you prefer to use biscuits throughout you can purchase from Triton a straight carbide cutter with a 4mm cut width (part no. BJA045).

This cutter can be used for cutting mid-panel slots using the router hand-held against a clamped batten. Alternatively it can be done in the overhead mode on your Workcentre using the optional Router Mounting Plate (AJA150).

With a plunge router, and some practice, you can produce slots with a curved bottom. However flat-bottomed slots 13mm deep by 40mm long are acceptable, and much easier.

Biscuit Spacing

The number of biscuits required for particular joints will depend on the type of material being joined and the loads which the joint has to carry. As a rule of thumb, use one biscuit (or row of biscuits) in material up to 20mm thick, and two biscuits (or rows) in thicker materials, spaced equally about 1/3rd the way in from either face.

The spacing between the biscuits along edge-to-face panel joints and bevel joints should be around 150-200mm. For long edge-to-edge joints, such as for a table-top in natural timber, around 300mm between biscuits is generally adequate.

Test Assembly

Test assemble your work before applying the glue to check alignment and fit. Because the biscuits can move lengthways in their slots, you can usually true up joints easily.

The glue faces and the slots should be clean and dry prior to gluing. Remove any sawdust or shavings by brushing or blowing.

REPLACEMENT BISCUITS

Triton biscuits are specially shaped to suit the cutter supplied. Replacement Triton biscuits are available from your Triton stockist in packs of 50 (BJA050), or 500 (BJA056).

You can use other brands of biscuits, but they are a different size. These biscuits, commonly called #10 and #20 biscuits, require elongated slots. Use the reference lines printed on top of the main body on either side of the central line. Start at the line marked "20" and move the wood towards the outside line, in the direction of the arrow.

The #10 biscuit slots require the depth stops to be adjusted to reduce the travel of the sliding insert.

GLUES AND GLUE APPLICATION

Good quality water-based adhesives, such as PVA glues, are the most suitable for biscuit joining because they have good quality wetting properties, and the moisture makes the biscuits swell up evenly to tighten the joint. Epoxy and resorcinol-type adhesives can be used, but we do not recommend the use of highly viscous glues such as construction adhesives.

Triton brand Premium Woodworking Adhesive offers superior bond strength and better sanding and staining characteristics than most commonly available PVA glues. Available in 250ml, 500ml and 2.5 litre bottles.

Apply the glue sensibly. It is unnecessary and wasteful to fill the slots with glue. On the other hand you need enough glue to fully "wet-out" the sides of the biscuits. Coat the biscuits with glue and/or paint glue on the walls of the slots, using a thin spatula, a cotton bud, or a small paint brush (a #6 artists size is ideal).

The best way to tell if you're using the right amount of glue is when you clamp the joint. A fine line of glue should be squeezed out. Glue liberally dripping out indicates an excess, and no glue visible means a starved joint.

CARE OF THE CUTTER

Inspect the cutter teeth regularly for chips or bluntness, and remove accumulated resins from the tips. Have the cutter professionally sharpened when blunt. When not fitted to your router the cutter should be stored in its special housing at the end of the main body to prevent accidental tooth chipping.

Replacement cutters (BJA038) or cutting discs (BJA039) can be ordered through your Triton stockist

Due to our company policy of continuous product improvement, specifications may change without prior notice.

Made in Australia by: Triton Manufacturing & Design Co. Pty. Ltd. ACN 000 195 951 ABN 43 000 195 951
14-18 Mills St, Cheltenham, Vic. 3192 Ph: (03) 9584 6977 Fax: (03) 9584 5510
E-mail: tools@triton.net.au Web Site: <http://triton.net.au>

International Offices:

Canada - Toll Free: 1 888 874 8661
Japan - Free Call: 0120 171 079
New Zealand - Ph: (09) 262 3052

South Africa - Free Call: 0800 600 432
United Kingdom - Free Call: 0800 856 7600
USA - Toll Free: 1 888 874 8661