

No. 223

## Profiling table and furniture plates with a professional design

**A**

### Description

The industry often sets design and function standards which are then often implemented in trade also. What can be provided simply with CNC routers can be manufactured manually but requires a great deal of time and money.

We try to pick up on such trends and implement them simply and quickly using standard machines and reasonably priced tools.

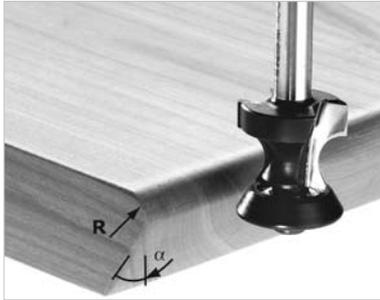
It is now possible to produce more attractive aesthetic features for modern counters and plates with minimal time and effort involved.



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This application example describes the profiling of a wooden plate edge with a radius of 6 mm at the top and then merging into a 30° chamfer without an offset.

A chamfer cutter with a ball bearing and a special roundover-chamfer cutter with a cone-shaped ball bearing are offered in different models for this purpose. The cutters are used consecutively to create the profile shown here.

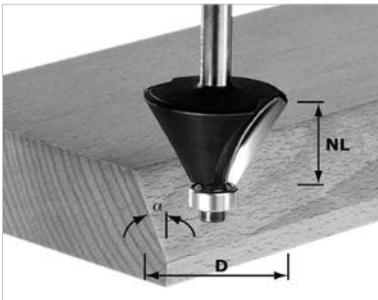


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In the application example the roundover-chamfer cutter with a radius **R** of 6 mm at a chamfer angle of  $\alpha$  15° is used.

Cutters with a ball bearing guide allow different plate contours, straight, rolling or corner, thanks to the punctual cutter guide (ball bearing).

It is recommended to perform a test cut on a reject piece to set the cutter. This can be dispensed with for experienced users of routers.



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For the angle cuts a 15° chamfer cutter with a ball bearing guide is used.

## B

### Tools/Accessories

The following tools are required to create such plate profiles:



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Designation	Order No.
Router OF 1010 EBQ	574233
Multifunction table (MFT)	495315
Lever clamps Alternative: fastening clamps, fixed clamps or a vacuum clamping system for fixing the workpiece at the multifunction table (MFT)	491594
Chamfer cutter with ball bearing 15° and	491132
Roundover-chamfer cutter with ball bearing 15° The chamfer angle of both tools must be the same.	491134
A mobile dust extractor from the CT series and an extraction hood for the router are recommended for a clean working environment.	



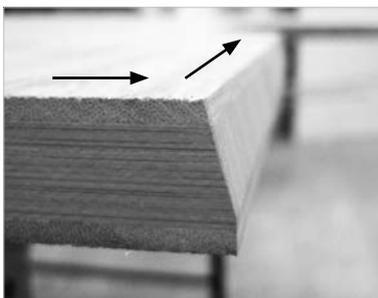
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## C

### Preparation/Set-up

Please carry out the following preparation work to route the new profile:

- First of all, the side of the plate with the more attractive visible side must be identified. This is marked.
- Set up the MFT so that you can securely fix the plate. If the plate is too big for the MFT, you must select another type of fixing, e.g. a rack as a support or also the Festool vacuum clamping system. The plate must be fixed securely in each case.
- Firstly position the bottom side of the plate facing up as the chamfer is cut at the plate first.
- Clamp the chamfer cutter in its router. Ensure that the cutter is inserted up to the marking for minimum clamping length (  $\checkmark$  ) on the cutter shaft and is secured.
- Now adjust the routing depth by initially placing the router on the plate and then moving the cutter down until the ball bearing is touching the bottom edge of the plate. The router is then clamped at the rotary knob.
- Then the depth stop is moved down and the routing depth fixed.
- Secure the chip deflector found in the scope of delivery of the router. This guarantees optimal extraction results.

## D

### Procedure

Proceed as follows when routing:

- Position the router on the workpiece, move the router down as far as the stop and secure the locking device of the router.

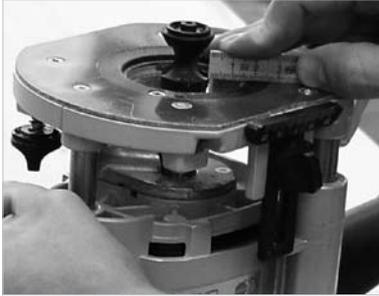
Ensure that the cutter does not touch the workpiece when the router is turned on. After switching on approach the workpiece slowly and move along the workpiece in the counter direction.

For corner plates start working on the front side (traverse to the wood fibre) first and then the side grain so that any chippings can still be cut away on the side grain.

## E

### Preparation/Set-up

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Carry out the following preparation work for the second cut:

- Now turn the plate over so that the visible side is facing up.
- Secure the plate again as for the first cut.
- Now clamp the respective roundover cutter in the chuck of the router.
- Adjust the depth of the cutter so that the upper edge of the blade is on the plate.

This is particularly easy to do if a small piece of wood or a ruler is positioned on the router table.

Position the router on the head and move the router table down until the radius outlet of the router rubs against the ruler, which you have positioned on the router table.

## F

### Procedure

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When routing proceed as per instructions for the first procedure.

The routed edge can then be finished by gentle grinding.



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The perfect look can also be created for free-standing shapes easily and without much reworking.



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Tip:

If the corner chamfered on both sides is rounded using sandpaper, this rounding is copied for the second process "Chamfering a radius" (Fig. 223/13).



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A perfect corner is created!

**FESTOOL**

Our example for use is a recommendation tried and tested in practice. However the actual conditions pertaining in each situation are completely outside of our control. We therefore do not provide any form of guarantee. Any legal claims arising out of this are not to be made against Festool. Please observe without fail the safety and operating instructions included with the product.

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