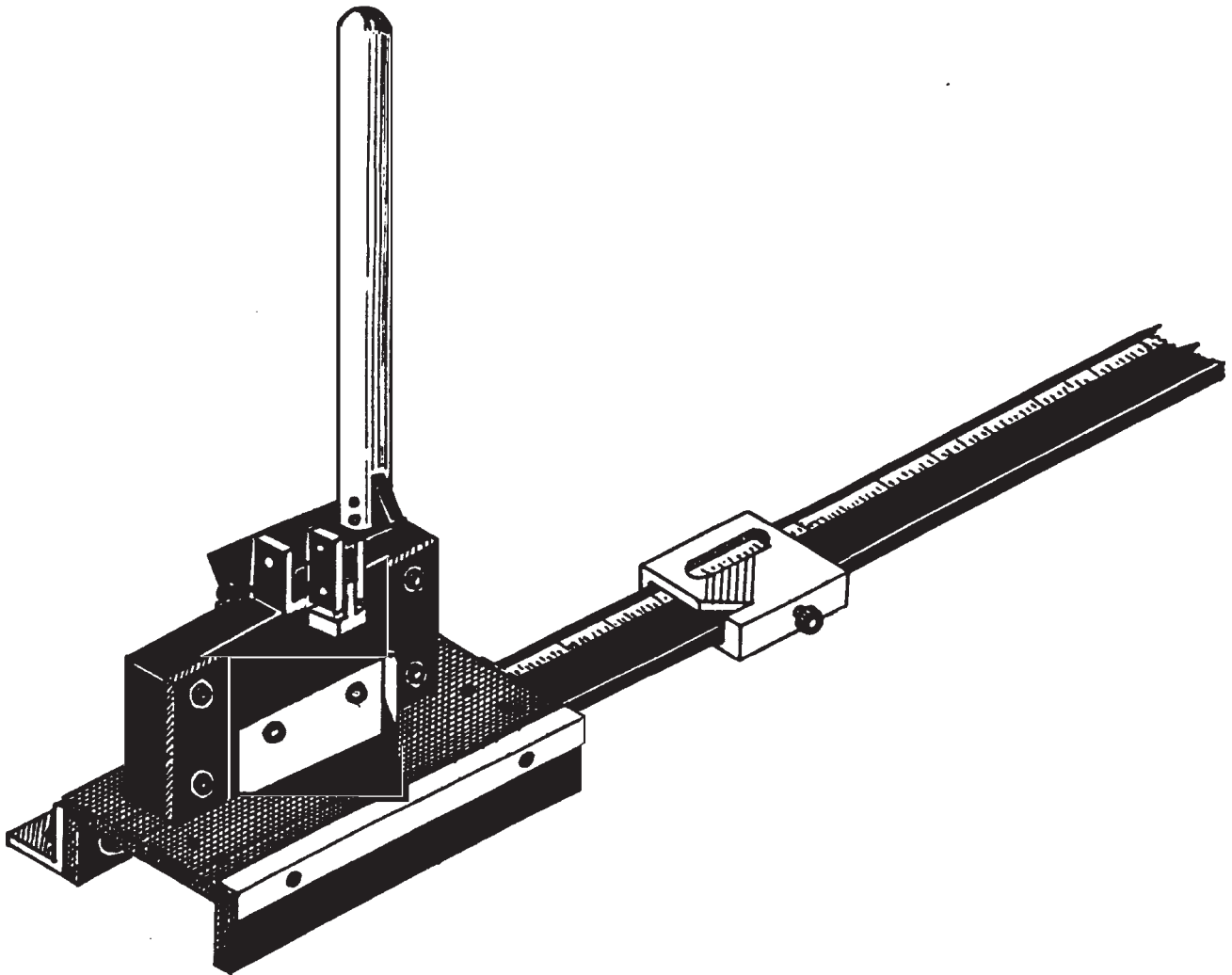


Instruction & Operation Manual

For The

Mitre-Mite® Fillet Cutter

Hand Operated Fillet Chopper



TWAMP

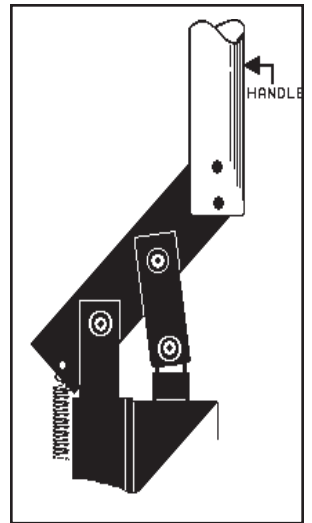
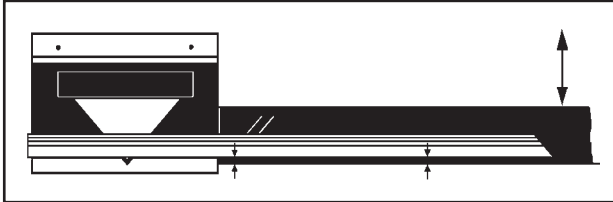
Technology for Frame Assembly

100 Fairway Drive, Suite 114 • Vernon Hills, IL 60061

1. Install Handle & Measuring Arm:

Remove the Fillet Cutter unit & handle from the box. Unwrap the handle with the 2 screws attached. Use the larger allen wrench to attach the handle to the top lever of the machine. See illustration at right. Mount the measuring arm to the side bracket of the Fillet Cutter now, before mounting the entire unit to a board or bench.

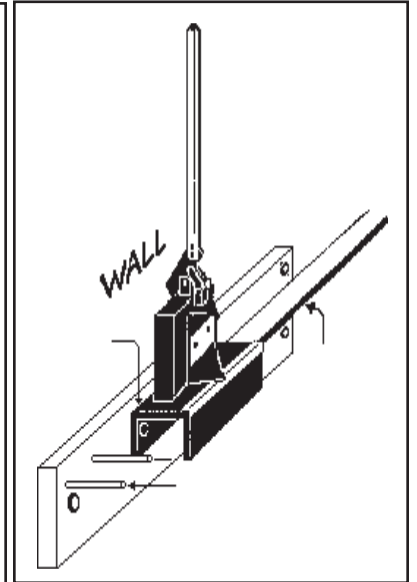
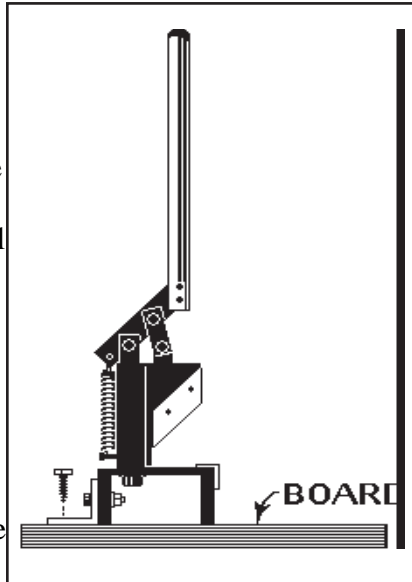
Be sure to *align* the measuring arm with the front angle guide before tightening all the screws. Use either a piece of fillet at least 36" long or a yardstick for this task



2. Mounting The Unit:

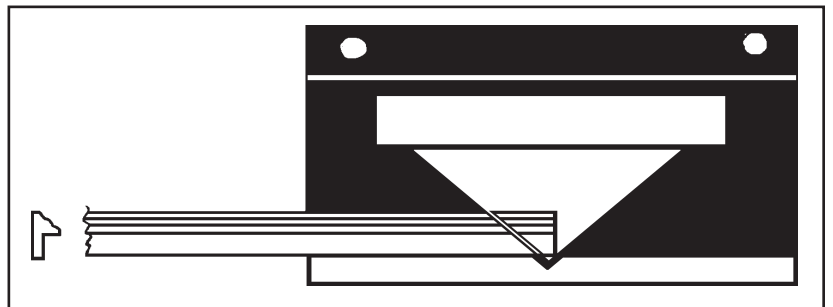
The Fillet Cutter can be mounted directly to a work bench or attached to a small board for portability. When mounting to a board, position the unit to the back of the board so that most of the wood is in front of the unit. This will eliminate tipping. A board measuring 6" x 8" x 1/2" thick, is large enough. You can also mount the unit to a wall provided there are studs handy to use. It's best to first mount the unit to a 1"x4" board long enough to span at least 2 studs in your wall. Using a longer board will allow you to build in some support for the fillet on the infeed side of the unit as well. Small dowels work well for this.

NOTE: When mounting to a wall, first remove the back angle bracket. Mount through the holes in the base channel to the board, then lag bolt the board and unit to the studs.

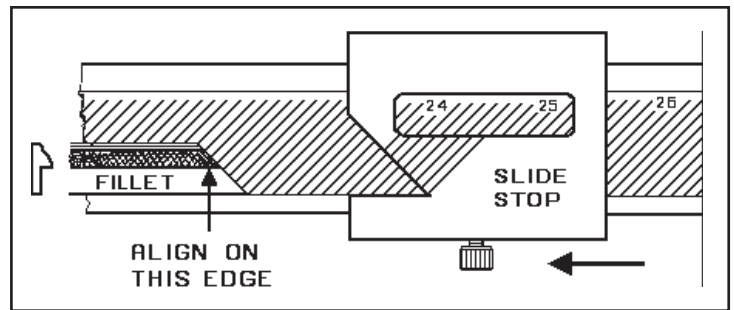


3. Measuring & Cutting Fillet To Length:

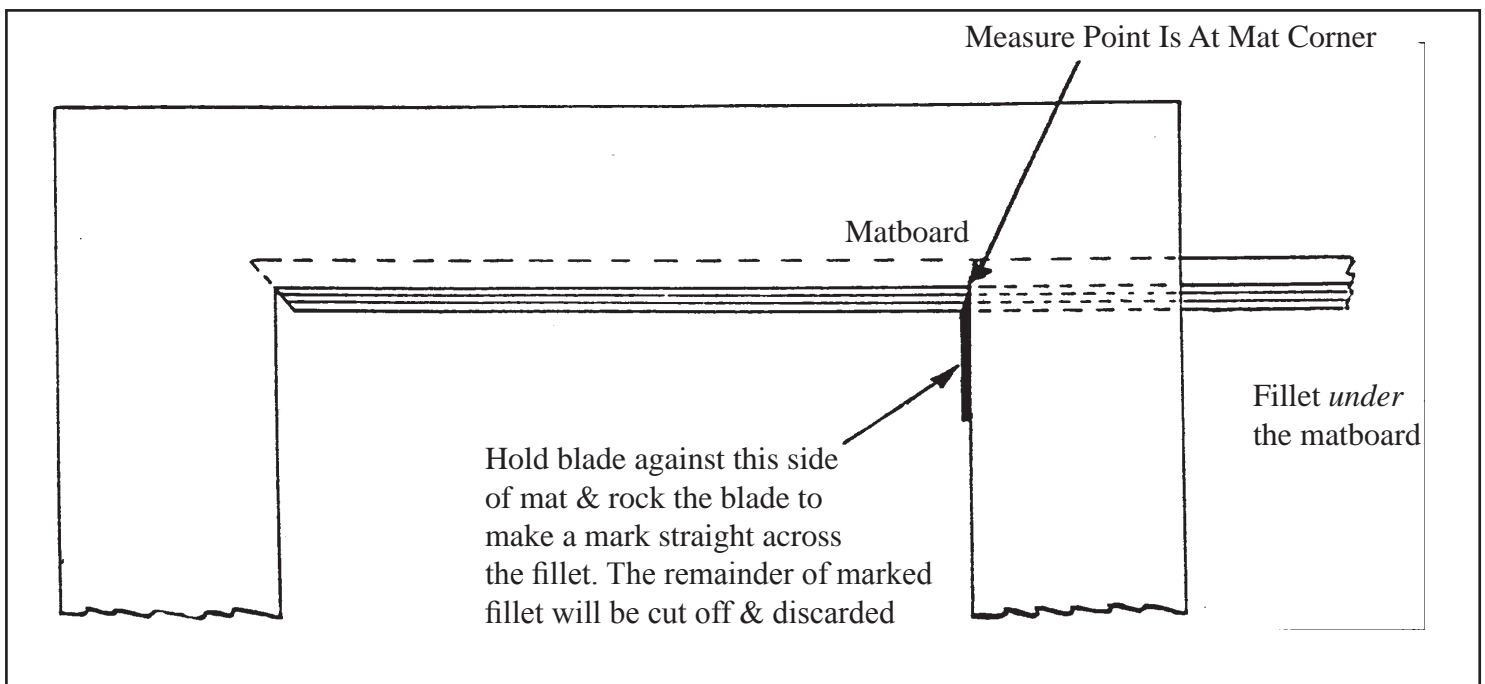
STEP 1: Place the fillet on the Fillet Cutter with the flat flange portion against the front guide. Cut off one end to create the first 45° corner



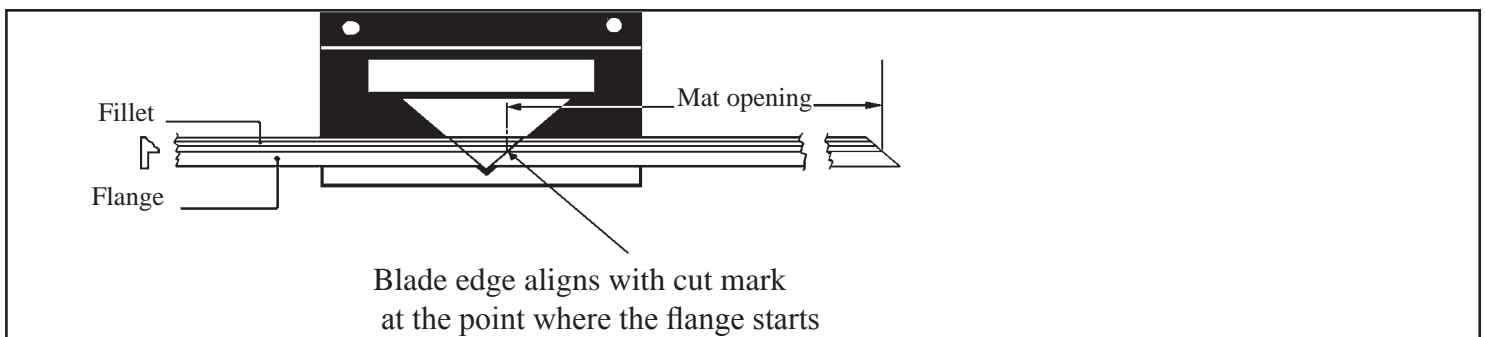
STEP 2 a: If you're using the measuring arm, after making your first edge cut, slide the fillet over to the 45° *ANGLED* line that matches the dimension you want to cut. (Use the vertical step in the fillet to measure.) Bring the Slide Stop over to touch the fillet edge. Fingertighten the screw on the stop. Check the cut piece of fillet in the mat opening for trimming to **exact** size.



STEP 2 b: If you're measuring by hand, place the cut fillet under the mat so that the cut end will fit into one corner of the opening. Hold the fillet in place with one hand and use the other hand to mark the fillet with an exacto knife or a used mat cutter blade. Make the mark straight across the fillet. Remove the fillet from under the mat and continue the mark using the blade to make it easy to see.

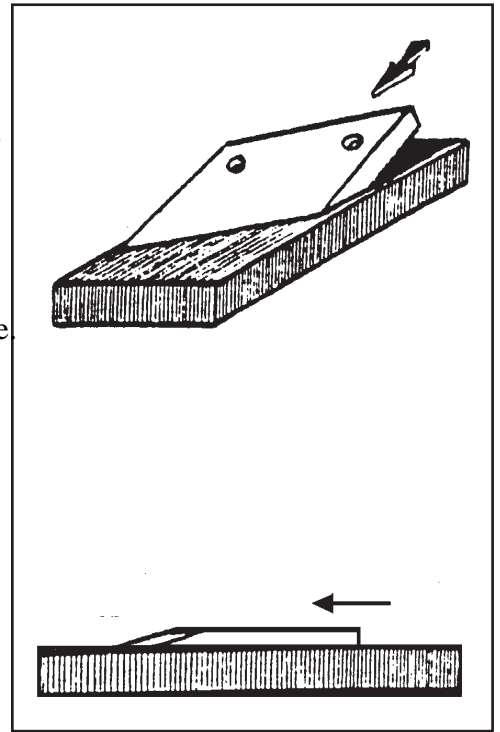


STEP 3 b: Place the marked fillet onto the Fillet Cutter so the flange is against the front guide. Slide the fillet over, so that the mark is under the blade. Sight down onto the blade to align the mark with the blade edge. Cut through the fillet with a smooth motion. Check the cut rail in the mat opening for fit. It should be cut so there is a small amount of play in the opening. 1/64" to 1/32" is about right, since the other pieces will eventually tighten the fit in the opening. The Fillet Cutter is designed to shave very small amounts from the cut edge so you can get a perfect fit. A little practice will make you an expert in a short time.



4. Sharpening or Replacing Blades:

The two cutter blades are made from tool steel and can be sharpened easily with an oil stone. (The kind used for sharpening jack knives, etc. and available at K-Mart or similar stores.) It's best to use a stone that is 1-1/4" to 1-1/2" wide x 3" to 4" in length. Both blades can be removed using the small allen wrench supplied with the unit. Please be **extremely** careful when handling the blades. The sharp edges can cut easily. Hold the blade with the bevel against the stone and push forward as shown in the drawing. Lift the blade slightly on the backstroke and bear down on the forward stroke. After 10-15 passes on the stone, you can lay the flat side against the stone and gently stroke it forward several times to remove the burr that forms. DO NOT tip the flat side of the blade UP on the stone. This surface must remain flat for an accurate cut. When you're finished, it's good practice to strop the blade edge backwards against a piece of leather, heavy cloth, or matboard, several times to remove the rolled edge that forms when sharpening. Remount the blades using the original screws. If your blades become nicked or damaged beyond repair, replacement sets are available from your supplier.



5. Adjustments

Although the Fillet Cutter unit comes from the factory fully adjusted, wear on some parts could require that adjustments be made in the future. If the vee-block, which moves in the dovetail slide, becomes loose, simply loosen the screws on one side just a little and tap the guide bar towards the vee-block. Snug the two screws and check for binding through the entire movement. If it is too tight, tap the vee-block in the opposite direction slightly, and recheck. If replacement blades do not fit exactly the same as the original blades, the vertical block (item #2 in parts drawing) can be moved by loosening the two bolts under the base channel. Retighten after the correct alignment is achieved. NOTE: All nuts and bolts are metric.

6. Precautions

The aluminum handle provides for a 10 to 1 mechanical advantage. DO NOT try to *increase* the length of the handle with a piece of pipe or other device. Damage to the unit could result from overstressing components in this way, and will VOID THE WARRANTY! Do NOT cut small wood or aluminum mouldings with this cutter. Aluminum wrapped wood fillets or aluminum core plastic fillets can be cut, but will require a second clean-up cut to get the 45° angle correct.

LIMITED WARRANTY

The manufacturer warrants this equipment to the original Purchaser to be free from defects in material or workmanship for a period of one (1) year from the date of purchase on the complete machine. This Limited Warranty shall be limited to the repair or replacement, at the sole discretion of the Manufacturer, of any defective part or parts. In the event of a defect in material or workmanship within the period of this Limited Warranty, Purchaser shall return to Manufacturer's Warranty Service Center, TRANSPORTATION PREPAID, the defective equipment.

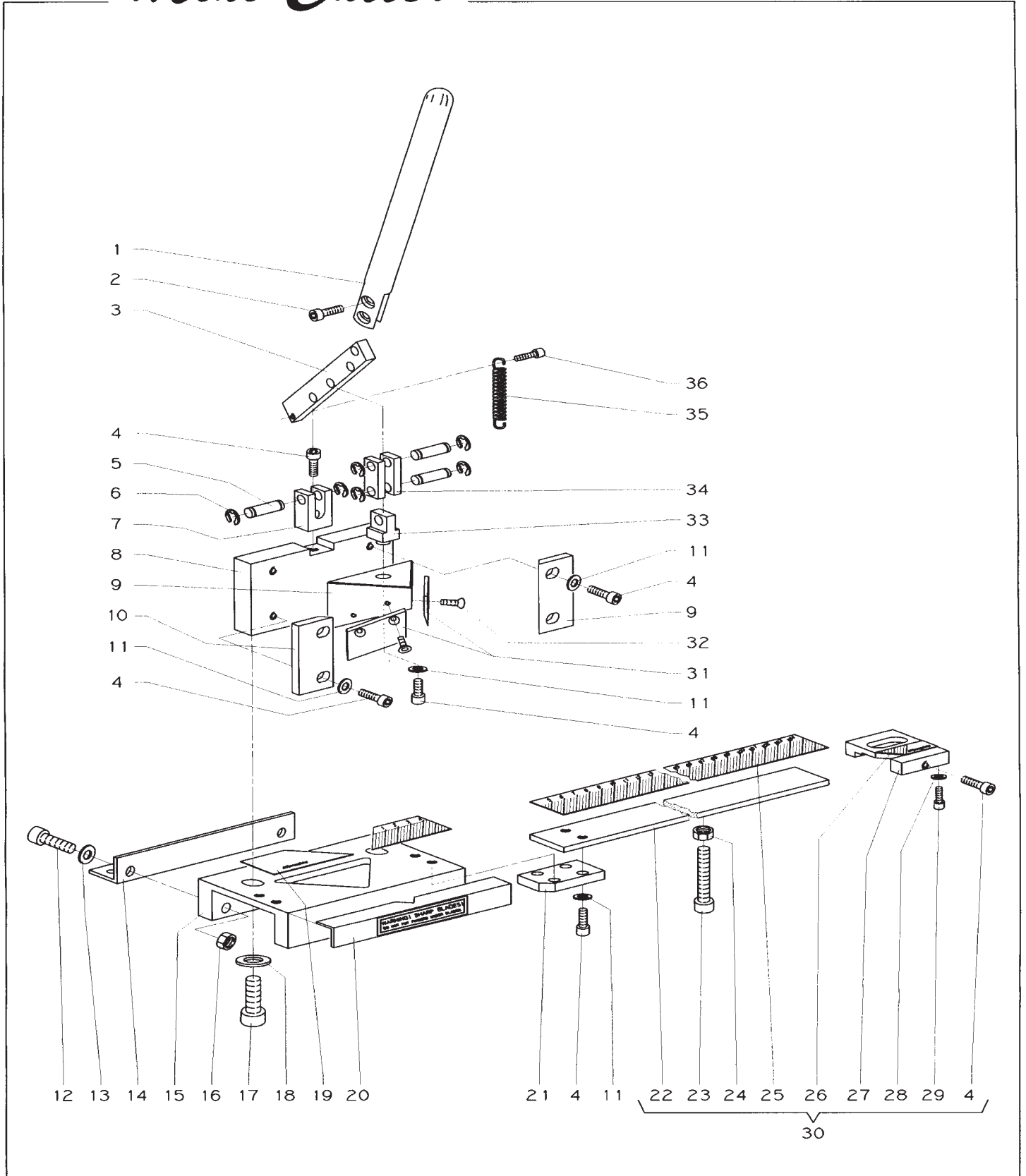
PROOF AND DATE OF PURCHASE WILL BE REQUIRED ON ANY PRODUCT SO ASSOCIATED WITH ANY WARRANTY CLAIM. Failure of this equipment caused by accident, corrosion, misuse or abuse of the equipment including but not limited to, damages or defects resulting from improper packaging of returned equipment or improper repairs made by others, is not covered by this Limited Warranty. Manufacturer reserves the right to determine whether the defect is covered by this Limited Warranty. If Manufacturer determines that the returned equipment is not covered by this Limited Warranty, then at Purchaser's option, such equipment shall be either: 1) returned to Purchaser, TRANSPORTATION COLLECT, or 2) repaired or replaced on the basis of Manufacturer's regular repair, replacement, or reconditioning charges, which charges shall be payable by Purchaser, C.O.D.

This Limited Warranty extends only to the initial Purchaser and may not be transferred to subsequent owners.

THIS LIMITED WARRANTY IS IN LIEU OF ALL OTHER WARRANTIES, EXPRESS OR IMPLIED INCLUDING ALL IMPLIED WARRANTIES OF MERCHANTABILITY AND FITNESS FOR A PARTICULAR USE AND PURPOSE. PURCHASER AGREES THAT THE SOLE AND EXCLUSIVE REMEDY AGAINST MANUFACTURER SHALL BE LIMITED TO THE REPAIR OR REPLACEMENT OF DEFECTIVE PARTS. PURCHASER FURTHER AGREES THAT NO OTHER REMEDY, INCLUDING BUT NOT LIMITED TO INCIDENTAL OR CONSEQUENTIAL DAMAGES FOR LOST PROFITS, LOST SALES, INJURY TO PERSON OR PROPERTY, OR ANY OTHER INCIDENTAL OR CONSEQUENTIAL LOSS, SHALL BE AVAILABLE TO IT, AND, IN ANY EVENT, THE LIABILITY OF MANUFACTURER FOR ANY DAMAGES SHALL BE LIMITED TO THE PURCHASE PRICE OF THE EQUIPMENT.

Mini Cutter

DWG Nr. MC 203



Mini Cutter

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Ref.	Code Number	Q.ty	Descrizione	Description
1	392350040	1	Leva	Lever
2	710100045	2	Vite TCEI 5x16	Screw 5x16
3	381300730	1	Supporto	Support
4	710100049	11	Vite TCEI 5x14	Screw 5x14
5	334500120	3	Perno	Pin
6	705050003	6	Seeger	Seeger
7	395150030	1	Forcella	Fork
8	373400430	1	Supporto	Support
9	381300740	1	Supporto	Support
10	372900080	2	Piastra	Plate
11	718100002	2	Rondella	Washer
12	710100079	2	Vite TCEI 6x25	Screw 6x25
13	718100003	2	Rondella	Washer
14	384200120	1	Supporto	Support
15	211250200	1	Base	Base
16	715650003	2	Dado	Nut
17	710100137	2	Vite TCEI 8x20	Screw 8x20
18	718100004	2	Rondella	Washer
19	366810080	1	Piano neutro	Plane
20	384200130	1	Supporto	Support
21	381300750	1	Supporto	Support
22	391650520	1	Prolunga	Extension
23	710100099	1	Vite TCEI 6x30	Screw 6x30
24	715650003	1	Dado	Nut
25	366710120	1	Riga millimetrata	Inch rule
26	366810090	1	Piano neutro	Plane
27	384400090	1	Supporto	Support
28	718100001	2	Rondella	Washer
29	710100023	2	Vite TCEI 4x8	Screw 4x8
30	291650020	1	STG prolunga	Complete extension
31	297050010	1	Set di lame	Set of cutter blades
32	710200020	4	Vite TSPEI 4x8	Screw 4x8
33	337000080	1	Boccola	Bushing
34	372900090	2	Piastrina	Plate
35	765800002	1	Molla	Spring
36	710100026	2	Vite TCEI 4x10	Screw 4x10