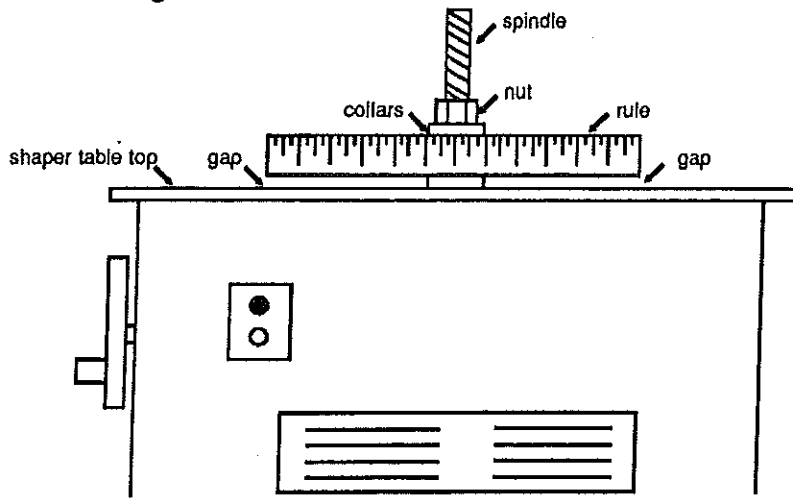


# COPE AND PATTERN STACKING INSTRUCTIONS

**BEFORE** you start, check the alignment of your spindle. **REMEMBER:** for a proper fit, your shaper must be aligned.



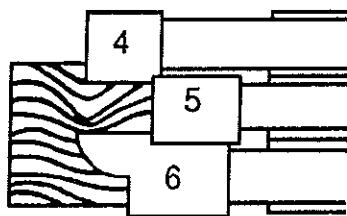
Before using any shaper cutter always check your spindle to be sure it is square with the shaper table. Misalignment here causes off pattern and fitting problems.

To check spindle alignment:

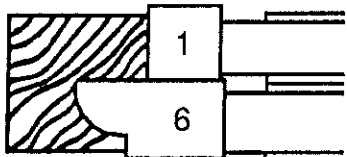
1. Unplug the machine. Remove the fence and cutter.
2. Raise the spindle to its highest position and clamp a 12" - 18" steel straight edge between the collars of the spindle.
3. Lower the spindle until the straight edge almost touches the table top.
4. Rotate the spindle by hand, observing the gap between the table top and the straight edge. If this gap is not uniform, indicating shaft misalignment, shim the spindle cartridge as needed to correct.

Each function requires a different cutter configuration. For desired results use the following guide to set up each operation.

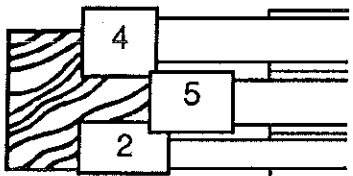
## COPE



GLASS (cope)

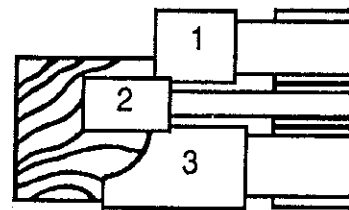


TONGUE

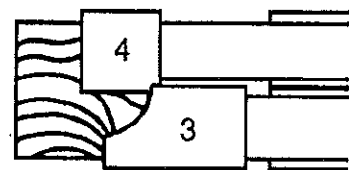


(#010 Profile used as example)

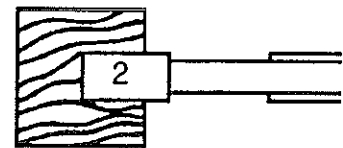
## PATTERN



PANEL (pattern)



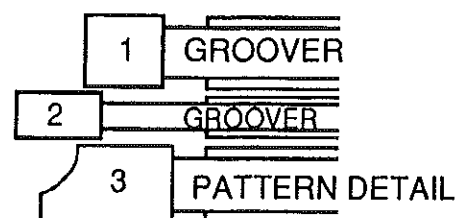
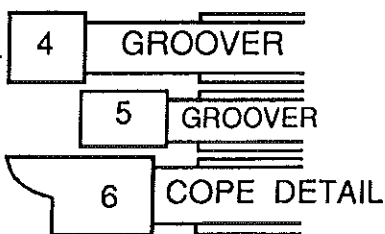
GROOVE



## COPE

## Cutter Numbering

## PATTERN



All cutters run Counterclockwise rotation with the wood running Face Down or Clockwise rotation with the wood running Face Up.