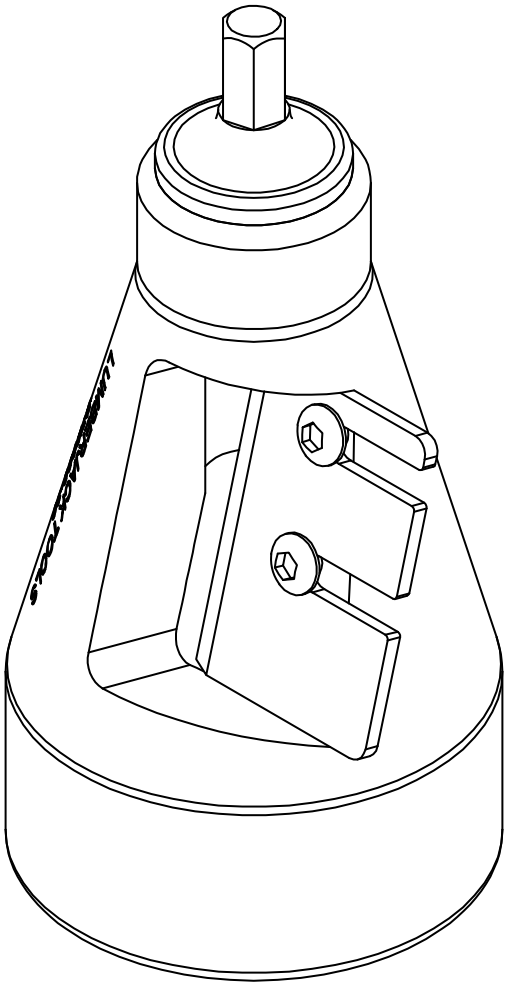
LUMBERJACK TOOLS

made in usa



USER MANUAL

Staking Tool (30° Shoulder Profile)

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Phone: 715-720-4719
Rev: 05/17

MODEL: ST2000-15

About Your Product

Thank you for purchasing our 30° Stake-Making Tool!

Lumberjack engineers along with our craftsmen have designed the safest, easiest to-use stake cutter in the market. By combining old-world skills along with DFMA principles and CNC technology, we've created a simple yet effective way to cut stakes at will.

The dual-bladed stake tool will cut a 30° point on a log or square timber in seconds. The body of the tool is CNC machined from a solid aluminum billet to ensure each cut is precise. The blades are stamped, heat treated and ground to provide years of service if properly maintained.

Our lifetime guarantee covers the tool body and shank. The blades are covered for 90 days from the date of purchase for breakage under normal working conditions. Blades will dull faster cutting hardwoods vs softwoods (peeled or unpeeled). Soil and other abrasive substances will reduce blade life and is not covered under this warranty. When making a claim, you must show proof of purchase from an authorized distributor. This is valid only to the original buyer, and not for tools sold secondhand, used, or sold "as is" to a second party.

What Voids Warranty

In order to keep our lifetime and 90 day warranty you must **AVOID** the following actions:

- Operating the tool in a drill press or lathe (or any system other than a hand-held drill)
- Running the tool into a nail or foreign object
- Altering or misusing the tool

SAFETY

Before beginning any project, carefully read and follow ALL safety and operational instructions for any tools or devices you will be using. Failure to do so may cause physical harm to yourself or those around you. If you feel uncomfortable using our stake-maker or any other tool, STOP immediately. Lumberjack Tools assumes no responsibility for injury caused to the operator, bystander, or tools used in conjunction with the use or misuse of our tools.

NEVER OPERATE POWER TOOLS UNDER THE INFLUENCE OF DRUGS, ALCOHOL, OR ANY MEDICATIONS

ALWAYS WEAR SAFETY GLASSES, DUST MASK, AND ANY OTHER PERSONAL PROTECTION ITEMS AS NEEDED

NEVER WEAR LOOSE ITEMS THAT COULD BE CAUGHT IN MOVING PARTS. SECURE LOOSE OR LONG HAIR AWAY FROM AREA

WE STRONGLY RECOMMEND A SINGLE-SPEED, GEAR DRIVEN DRILL WITH RPMS OF 500 OR LESS. EXCEEDING THESE RPMS MAY RESULT IN DAMAGE TO THE TOOL

ALWAYS DISCONNECT POWER AND ALLOW DRILL TO COME TO A COMPLETE STOP BEFORE INSTALLING, REMOVING, OR ADJUSTING THE TOOL

NEVER APPLY BENDING FORCE (SIDE LOADING) TO THE TOOL. SIDE LOADING COULD CAUSE THE SHANK TO FAIL, OR MAY RESULT IN BLADE DAMAGE

ALWAYS SECURE THE LOG IN A VISE OR CLAMP PRIOR TO STARTING YOUR DRILL. FAILURE TO DO SO MAY RESULT IN INJURY

ALWAYS HANDLE THE BLADES WITH EXTREME CARE! FAILURE TO DO SO MAY RESULT IN SERIOUS INJURY

NEVER PUT HANDS OR ANY BODY PART INSIDE THE TOOL WHILE THE BLADES ARE ATTACHED! DOING SO MAY CAUSE SERIOUS INJURY

WHEN EXCESSIVE FORCE IS REQUIRED TO CUT, RE-SHARPEN OR REPLACE THE BLADES. A SHARP TOOL IS A SAFE TOOL!

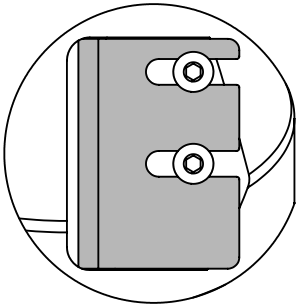
Assembly Parts Included:

- Allen wrench
- Button Head Cap Screws (Qty: 4)
- TB2500 Blades (Qty: 2)
- TB2500 Blade Shims (Qty:2)

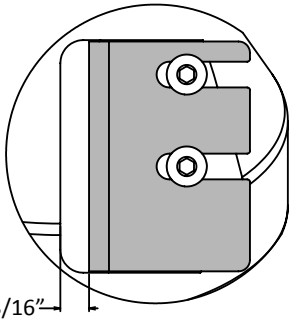
Setting the Blades

Install and secure the blades using the allen wrench to tighten the button head cap screws. Take care to keep the blade offset of both blades equal (see below).

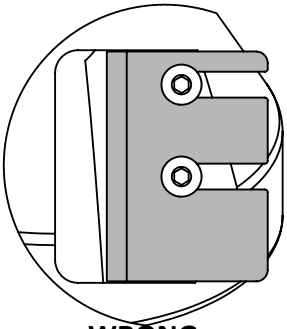
Blade Offset



WRONG
(Blades too far forward)



CORRECT

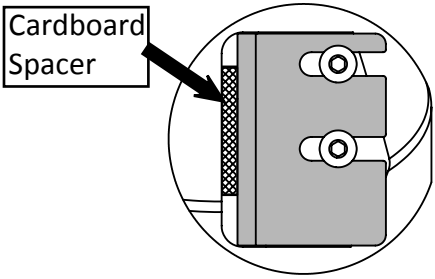


WRONG
(Blades too far back)

DO NOT set the blades closer than 1/8” or the staking tool will not be able to cut a pointed stake.

TIP

- The cardboard box that the tool comes in is about 1/8” thick
- Remove a piece of box to use as a quick spacer for blade setting



Would you like to cut smoother stakes?

Included with your tool are the TB2500 Blade Shims.

Pros of using shims

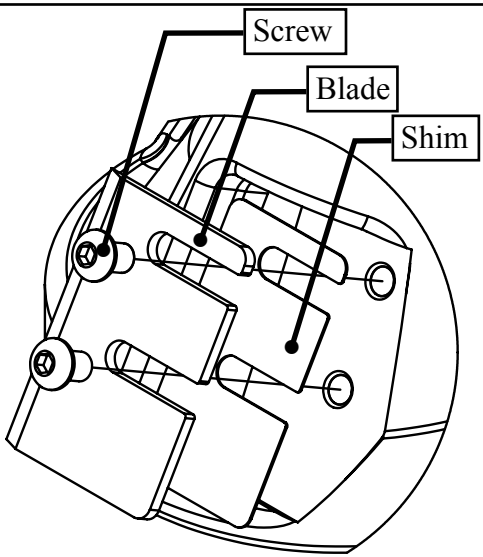
- Smoother stake
- Reduced drill torque
- Less aggressive blade bite

Cons of using shims

- Increased time to cut

Installing Shims

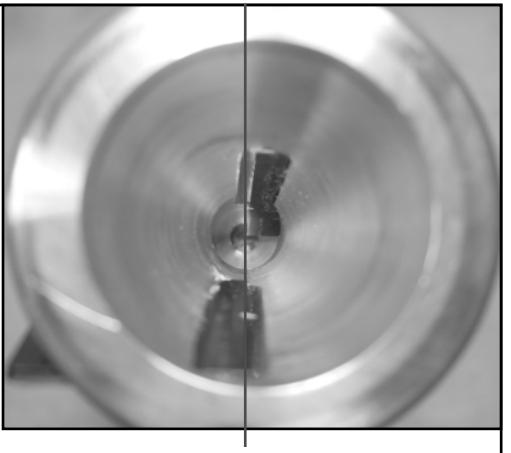
- Place a shim underneath a TB2500 blade and secure both with screws as shown
- The shim should **NOT** extend into cutting area or cover the sharp edge of the blade
- If installed properly the right edge of the shim will be flush with the right edge of the blade (the non-cutting edge)



Cutting Stakes

1

- Set the blades in the tool without crossing over the centerline
- Refer to the previous page for information on blade setting and offset



Centerline

2

- Begin by clamping the stock
- The **Log Lock** is great for holding stock steady and is available on our website

3

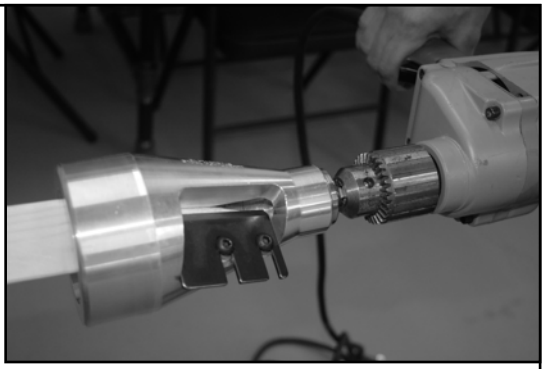
- When cutting stakes on a log if the diameter is greater than the tool can accept use a draw knife to taper down the end

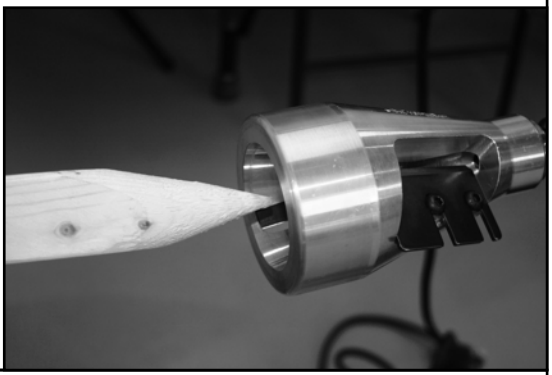
Cutting Stakes (cont.)

ALWAYS unplug the drill before adjusting the blades or adjusting the chuck

4

- Carefully install the staking tool into an unplugged 1/2” drill, and tighten it firmly. Use the tee handle to tighten the chuck
- Square up to the log so that the cutter is flush against the flat face of the stock
- Apply body pressure by leaning into the drill
- Pull the trigger to cut a stake
- Wait until the drill comes to a stop before removing the cutter from the stock





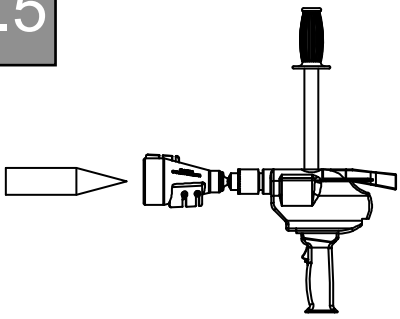
- This tool can easily put a stake on square, round or rectangular wood

Max	Capacity
Round	2.00” DIA
Square	1.50” x 1.50”

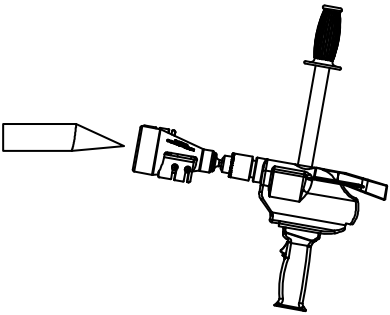
**NOTE: A standard 2.0” x 2.0” lumber measures 1.5” x 1.5”

- **Make sure the tool is square against the end of the log before cutting**
- **If the tool is held at an angle the tenon will be cut angled**

4.5



CORRECT
Drill in-line with log



WRONG
Drill not in-line with log (crooked)

(Optional) Adaptation to Motor Mount

- If desired the ST2000 can be mounted to a motor for production stake cutting
- Remove the shank that comes pre-installed to the tool
- The threading for the top of the Tool is 1” - 12 UNF
- Contact Lumberjack Tools or visit our website for more information
- **NEVER** exceed more than 1750 RPM when operating the tool

Maintenance

- **Body**
  - Cleaning
    - Keep the staking tool body clear of sap and other build-up
    - Always remove the blades before cleaning
    - Clean the tool with a solvent (such as mineral spirits)

WARNING: ALWAYS HANDLE THE BLADES WITH EXTREME CARE! FAILURE TO DO SO MAY RESULT IN SERIOUS INJURY

- **Blades**
  - Care
    - Always wipe blades with a thin film of oil at the end of the day to help prevent oxidation
  - Cleaning
    - Clean the blades with a solvent (such as mineral spirits) and **immediately** apply a thin film of oil to prevent oxidation
  - Sharpening
    - Use a sharpening stone or file to re-sharpen the blades, then clean the blades and apply a thin film of oil
- **Shank**
  - Replacement
    - If your shank breaks, we offer replacement shanks (see first page for contact information)
    - Turn the shank counter-clockwise to remove
    - Turn the shank clockwise to install

TASK	EACH USE	MONTHLY
Clean blade pockets	X	
Clean cutter bore	X	
Clean blades	X	
Inspect blades	X	
Oil blades	X	
Oil shank & screws		X

Troubleshooting

PROBLEM	CAUSE	SOLUTION
• Tool Skips off to one side or bounces around	• Stock is larger than tool will accept	• Taper down the end of the stock with a draw knife
	• Not enough pressure is being applied	• Lean into drill with body
• Not cutting stock	• Stock is larger than tool will accept	• Taper down the end of the log with a draw knife
	• Blades are slid too close	• Position blades so they are back no closer than 1/8"
	• Blades are dull • Not applying enough pressure	• Sharpen blades • Purchase new blades • Lean into drill with body
• Takes too much of a "bite"	• Aggressive cutting from dual blades	• Use the TB2500 Blade Shims
• Crooked Stake	• Holding drill crooked while cutting	• Position the drill square against the stock before cutting
• Drill stops or cuts on small diameter stock but not larger	• Using a variable speed drill	• Make sure you are using a single-speed drill with low RPMs
	• Using a non-Milwaukee brand drill	• We recommend purchasing a Milwaukee brand hole hog drill
• Spiral grooves on the tenon Stake	• Lateral wobbling of the drill	• Hold the drill as steady as you can while cutting
	• Removing the cutter while drill is still spinning	• DO NOT remove the cutter until the drill has come to a complete stop

Additional Tips

As with any new hobby or project, it will take time to master using our tool(s), and building furniture. You must first have a plan or a sketch of what you want to build, along with a tools and materials list before you begin.

Another important issue is reading the natural twist, stress or other deformities in the logs and using these skills to your advantage, allowing your pieces to become more unique as your abilities grow. Also as important, is to not over complicate your first few pieces, so you can have a “positive” experience.

Before starting your first project, use some scrap material and “practice” cutting tenons and using tools. Make sure you are comfortable operating the drill and cutters before you begin the project.

Unexpected Occurrences

Engineers and Quality Control staff at Lumberjack Tools have provided you with one of the easiest to use and safest stake maker in the market. However, there is always the unexpected chance of failure.

- Please contact our customer support for a replacement if a failure ever occurs to the tool body, shank or blades

Thank you again for purchasing our tools!