



Insert-Pro™ Interior and Exterior Door System

Setup Guide for Rail and Stile Operations (84-05X)

Congratulations on your purchase of the Infinity Cutting Tools Insert-Pro™ Interior and Exterior Door making System. We're confident that you will find the versatility and exceptional performance of this customizable woodworking system creates a value that no other shaper cutter system on earth can offer.

Please read through these easy to follow instructions for setting up your new Insert-Pro™ Interior and Exterior Door Making System before beginning operations. If you have any questions whatsoever about setup or use of the system at any time, contact us directly and one of our experienced technicians will be able to assist you. Take special notice of any

Notes: highlighted in these instructions as they contain important information about the setup of your system, and please take all necessary precautions to ensure that you are working in a safe environment and manner.

Rail and Stile Cutter Instructions for COUNTER-CLOCKWISE rotation

- Setup for **Rail (Cope)** cut
 1. Knife Installation
 1. Install (2) knife CIK-05X* **B** into aluminum cutter head RSB-003 **A**
 2. Install (2) knife CIK-05X **A** into aluminum cutter head RSB-003 **B**
 2. Spindle Installation
 - A. For **Interior** door **Rail (Cope)** cut (1-1/4" to 1-1/2" thick stock)
 1. Install Head RSB-003 **B** FIRST
 2. Install Head RSB-003 **A** SECOND
 - Ensure that all components interlock properly
 3. Lock spindle as normal
 - B. For **Exterior** doors **Rail (Cope)** cut (1-5/8" to 1-7/8" stock)

**Item numbers that may contain multiple profile variations, such as the Insert-Pro™ replaceable knives, may be denoted in these instructions with an 'X' in place of the final profile-designating number. Apply the appropriate item number for your intended setup as necessary.*

Note: Exterior Door Kit 84-058 is required for this configuration

1. Install Head RSB-003 **B** FIRST
2. Install Spacer 84-058 **F** from the Exterior Door Kit SECOND
3. Install Head RSB-003 **A** THIRD
 - Ensure that all components interlock properly
4. Lock spindle as normal

- Setup for **Stile** (Stick) cut
 1. Knife Installation
 - A. Install (2) knife CIK-05X **D** into aluminum cutter head RSB-003 **A**
 - B. Install (2) knife CIK-05X **C** into aluminum cutter head RSB-003 **B**

Note: If no CIK-05X **C** or **D** knife is offered, the **A** and **B** knives used for the rail cut are interchangeable and do not need to be changed. Simply install the heads as noted below. (No **C** and **D** knives are needed for **Ogee** or **Chamfer** profiles.)

2. Spindle Installation
 - A. For **Interior** doors **Stile (Stick)** cut (1-1/4" to 1-1/2" stock)
 1. Install Head RSB-003 **A** FIRST
 2. Install Slot Cutter RSB-003 **E1** SECOND
 3. Install Head RSB-003 **B** THIRD
 - Ensure that all components interlock properly
 4. Lock Spindle as normal
 - B. For **Exterior** door **Stile** (Stick) cut (1-5/8" to 1-7/8" stock)

Note: Exterior Door Kit 84-058 is required for this configuration

1. Install Head RSB-003 **A** FIRST
2. Install Slot Cutter 84-058 **E2** from Exterior Door Kit SECOND
3. Install Head RSB-003 **B** THIRD
 - a. Ensure that all components interlock properly
4. Lock Spindle as normal

Note on item 84-058 E2: Because there is no stop for the grooving knife on the 84-058 **E2** head, it is necessary to set the knife to the proper spec manually when rotating or replacing the knife.

Infinity Cutting Tools recommends using a caliper or feeler gauge for this operation. The knife should be set to achieve .035" +/- .003" projection from the side of the head to produce a proper fitting joint. After replacing or rotating the knives, a test cut is recommended to ensure that the knives are set properly and produce the desired width groove.