

## FIELD KERFING GUIDELINES

### Field Kerfing Required Equipment

1. FREUD - 9/16" Depth Slotting Cutter Set (*figure a*) or equivalent
  
2. Hand Router (*figure b*) - minimum of 1hp or equivalent tool such as 3 wing slotting cutter (*figure c*)



*figure a*



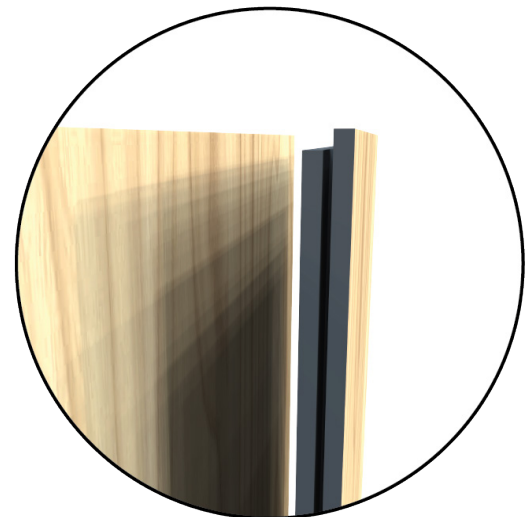
*figure b*



*figure c*

### Best Practice Field Kerfing Guidelines

1. Insert slotting cutter tool into the hand router
  - a. Use a manufactured kerf plank (*figure d*) as a set up guide to confirm tool height
  - b. Place the blade in the kerf
  - c. Set tool height
2. Perform a test run on a scrap plank
  - a. Speed rate for hand router: 1400-1800 RPMs
  - b. Feed rate for hand router: 8-12 ft/min
3. Kerf planks as required
  - a. Maintain tolerances - planks arrive with a .415" kerf and field cut edges must be re-kerfed to 0.500"



*figure d*

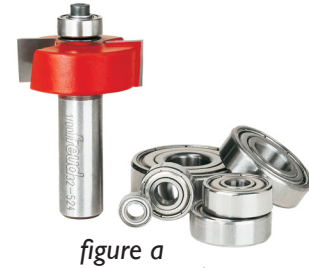
### Additional Requirements

1. Minimum width of finished plank is 3"
2. Maximum width of finished plank is 16"
3. Minimum plank length is 4"

## FIELD RABBETING GUIDELINES

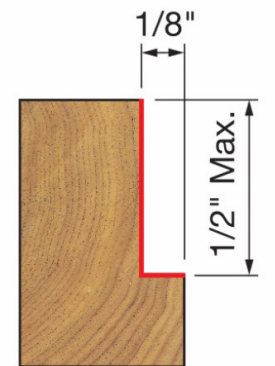
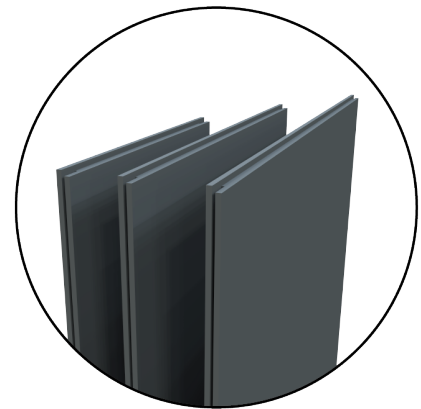
### Required Equipment Rabbeting

1. FREUD - 1/8", 1/4", 5/16", 3/8", 7/16", 1/2" Depth Rabbeting Bit Set with interchangeable bearings (figure a) with 1/2" Shank or equivalent tool
  
2. Hand Router (figure b) - minimum of 1hp or equivalent tool



### Best Practice Field Rabbeting Guidelines

1. Insert rabbet cutter tool into the hand router
  - a. Use a manufactured rabbet plank (figure c) as a set up guide to confirm tool height
  - b. Use bearing designed to cut a 1/8" depth rabbet (figure d)
  
2. Perform a test run on a scrap plank, once height is set
  - a. Speed rate for hand router:  
1400-1800 RPMs
  - b. Feed rate for hand router:  
8-12 ft/min
  
3. Rabbet as required
  - a. Tolerances - planks will arrive with a 1/8" x 0.157" rabbet cut and the field cut planks must be re-rabbeted to 1/8" x 0.157"



# 32-524 figure d

### Additional Requirements

1. Minimum width of finished plank is 3"
2. Maximum width of finished plank is 16"
3. Minimum plank length is 4"