

Tip #38 Molding

Molding operations are performed with the Mark V in the table saw mode. The molder head accessory enables you to add professional detail to almost any project. With it you can shape edges and surfaces, form cabinet door lips, make sash moldings, produce strong glue joints, and do many other operations. Once you become acquainted with the tool, you'll find that you can reproduce many standard wood patterns and also create virtually unlimited original molding designs. In a sense, it allows you to do decorative edging on the table saw.

The molder head (Figure 5-1) is a heavy steel disc that is mounted on the 5/8" molder/dado arbor, then onto the Mark V's main spindle.

Use speed setting Q (3250 RPM) for hardwood and R (3500 RPM) for softwood.

Molding Safety

Warning: Before using the molder head accessory, read and understand these important safety instructions:

Danger Zone—The danger zone extends 3" out from the knives on all sides, 2' in back of the knives, and 8' in front of the knives. The reason for the extended danger zone in front and back of the knives is because of the danger of kickback.

- **Read and understand your Table Saw Safety.**
- **When the molder head accessory is used, it is necessary to remove the upper saw guard. Whenever the upper saw guard is removed, keep the lower saw guard in place and work with extreme caution.**
- **Never use the molder head accessory without the molder insert installed. After installing the molder insert, turn the upper auxiliary spindle by hand to be sure the knives clear the insert.**
- **Make sure the setscrew in the molder/dado arbor is tightened against the flat of the main spindle, the tongue washer is installed next to the hex nut, the threaded shaft of the arbor is flush with or extends past the end of the hex nut, and the hex nut is securely tightened.**

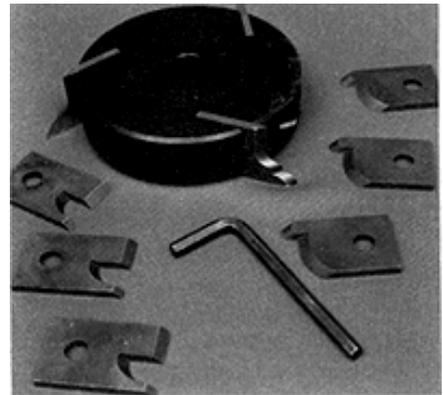


Figure 5-1. The molder head is a thick, heavy steel disc that has equally spaced slots around its perimeter to receive sets of molder knives. A special 5/8" molder/dado arbor (not shown) mounts the molder head to the MARK V main spindle.

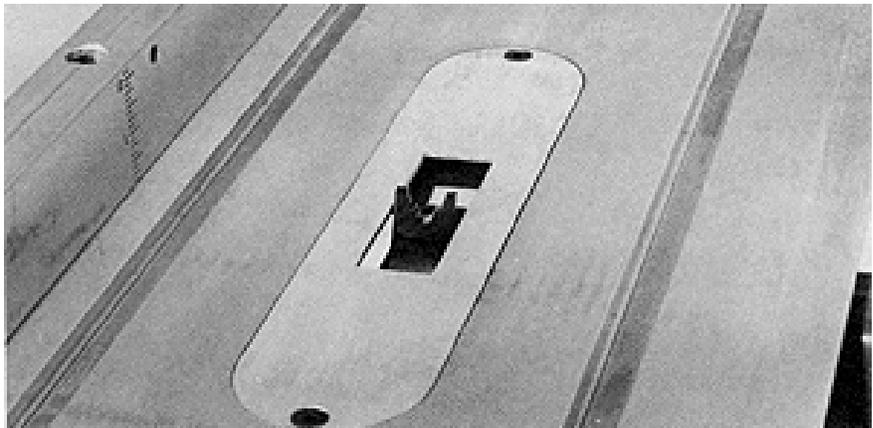


Figure 5-2. The molder head must always be used with the special molder insert (Model 500 insert shown).

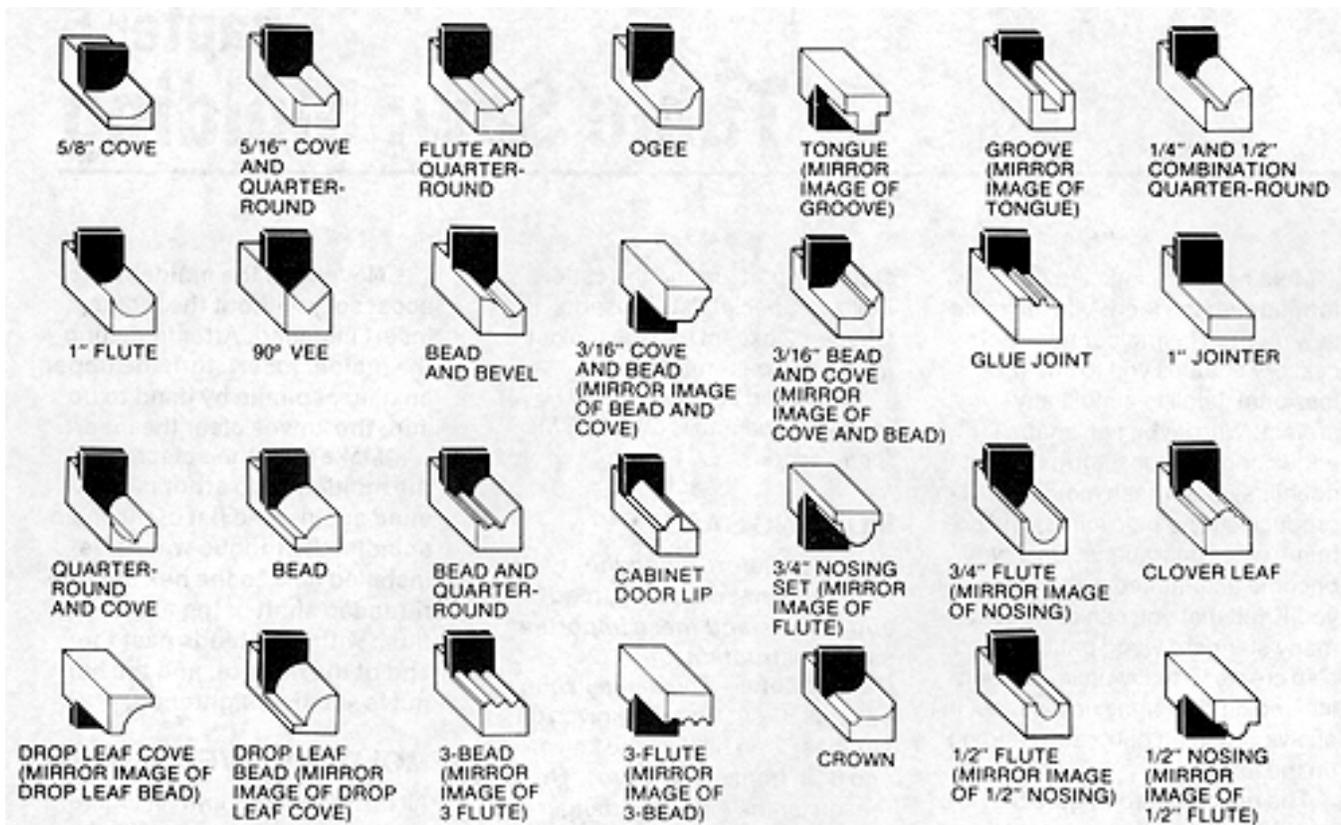


Figure 5-3. All of these knives are available for use with the molder head. Buy a few that you can use now; acquire more as you become proficient and your work scope increases.

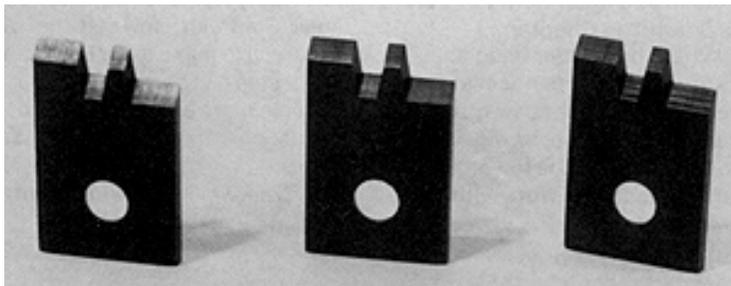


Figure 5-4. This set of glue joint knives is typical of those which are designed for a special purpose. you can even use part of the profile.

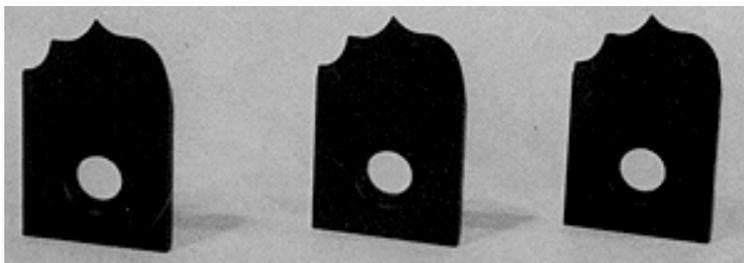


Figure 5-5. This is a sample set of combination knives. Part of the profile is used to form flutes or quarter-round shapes. You can opt to use the full profile if the form pleases you.

Molder Knives

All of the knives shown in Figure 5-3 are available for use with the molder head. This is quite an extensive assortment, but it isn't necessary to acquire all of them at once. Start with a few sets that will allow you to make a few basic cuts. Other sets can be added as you become more experienced with molder operations and as the need arises.

Knives, which come in sets of three matched cutters, are designed like the glue joint set in Figure 5-4 for full profile cuts; that is, the entire width of the knife is used to cut the shape in the wood. The set shown in Figure 5-5 is designed so only part of the edge is used to cut, in this case, flute and quarter-round shapes. However, the full profile may be used if the shape pleases you.