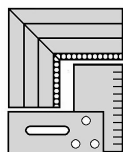
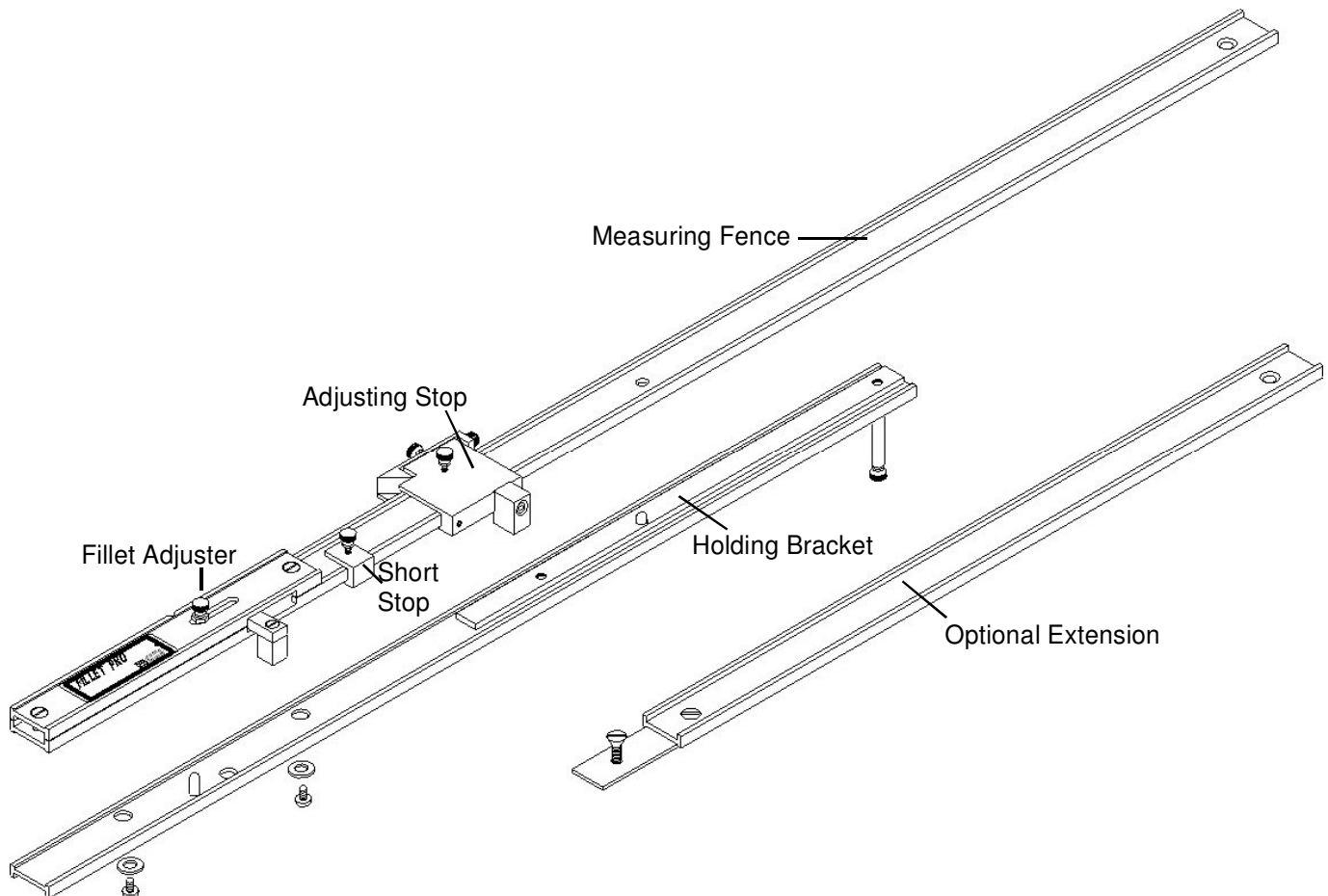


ASSEMBLY & PARTS MANUAL  
WITH OPERATING INSTRUCTIONS  
FOR THE

***Fillet Pro***<sup>TM</sup> ***Measuring System***

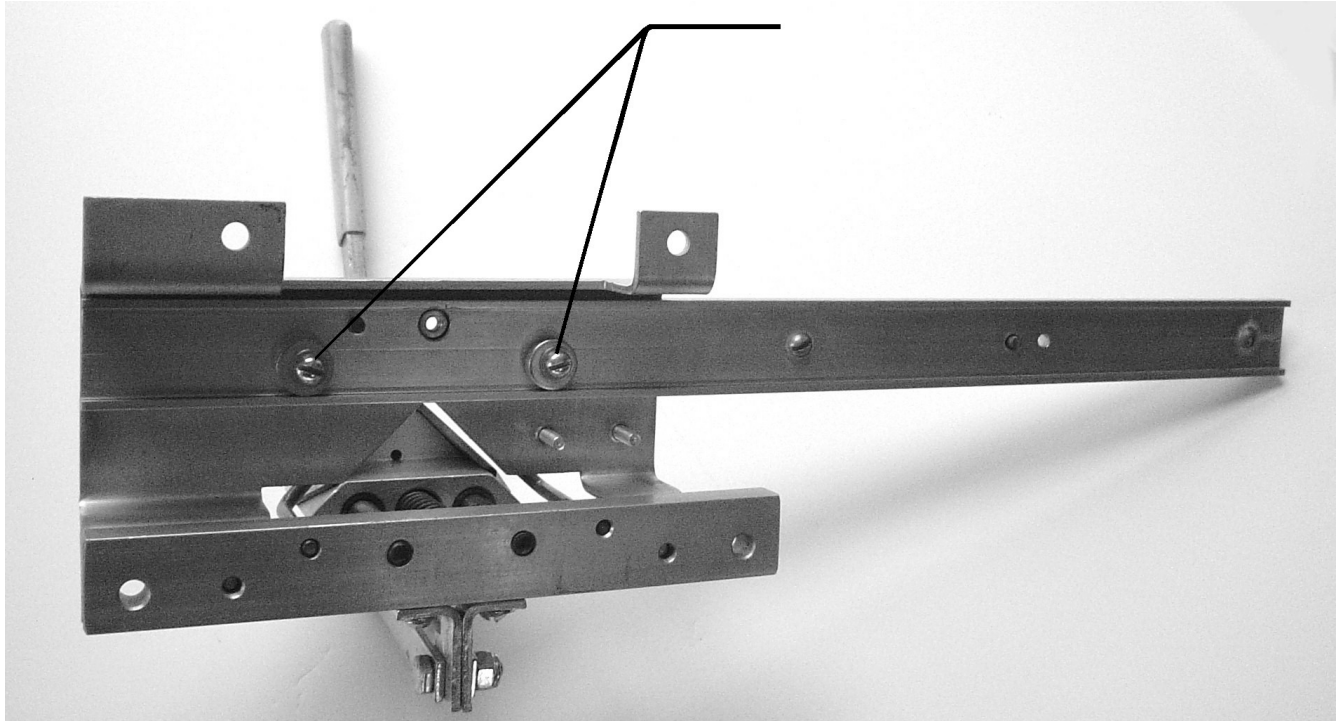
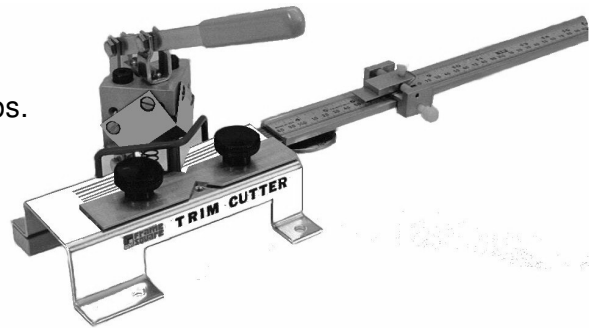


**Frame  
Square**  
the 4th corner solution

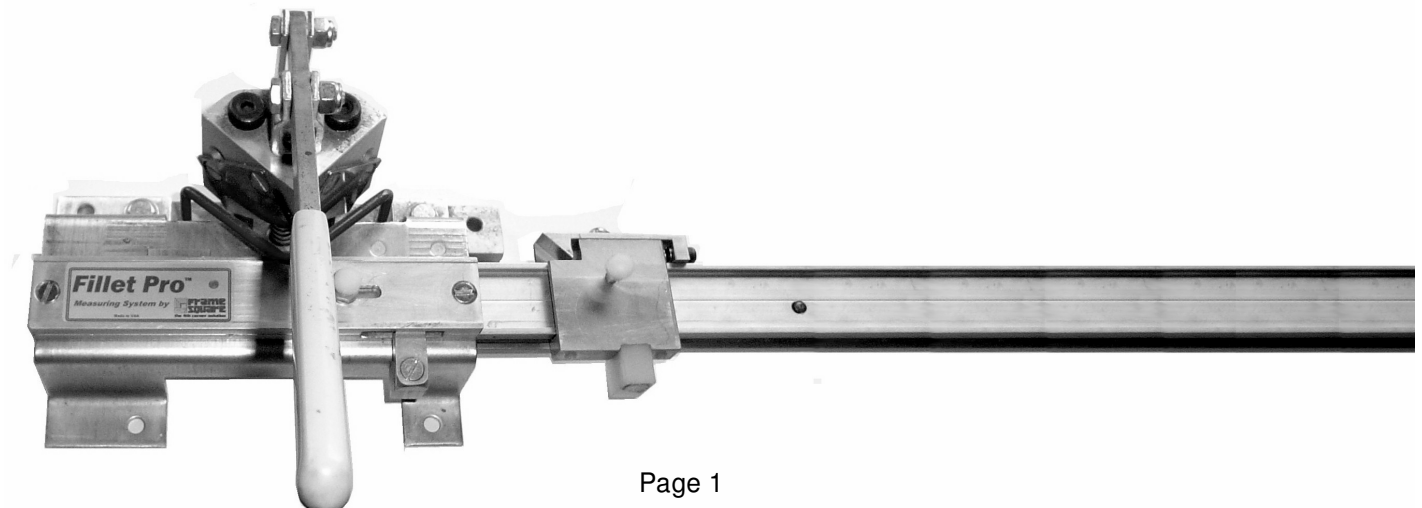
**FRAME SQUARE MANUFACTURING**  
PO Box 2065 (28111)  
314-A Depot Street  
Monroe, NC 28112  
(704) 289-8760 FAX (704) 289-9206

## Mounting your *Fillet Pro*

1. First remove the top V-Fence by removing the two thumb knobs. Set these aside.
2. Lay the Trim Cutter onto its back and remove the two nuts and washers that hold the scale onto the machine bottom.
3. Place the Holding Bracket upside down under the Trim Cutter. The three larger holes will fit over the thread inserts in the Trim Cutter. Secure the Holding Bracket with the two special short screws and washers provided.



4. Your Fillet Pro should now look like this after you set the Measuring Fence onto the Holding Bracket.



## Calibrating your *Fillet Pro*

Because not all Trim Cutters have the blades at the same exact position, your Fillet Pro needs to be calibrated one time for your machine. The Adjusting Stop has a sliding adjustment at the top to allow for the 1/32" or less difference in machines. It will also adjust for your personal fit of fillets to mat openings. Once calibrated, you will be able to measure any mat opening and get the same fit each time, without using a yardstick or ruler.

1. Loosen the fillet adjuster knob and slide it to the right until the flag edge touches the fillet rabbet. Tighten the fillet adjuster knob.

2. Remove the Measuring Fence and loosen the thumbscrew on the Adjusting Stop to position the Fillet Pro into a small mat opening. Tighten the thumbscrew for this position. *Use a small opening so you don't waste fillet.*

3. Set the Measuring Fence onto the Trim Cutter with the Holding Bracket and cut the fillet used to adjust for the rabbet.

4. Position the cut fillet into the mat opening. If all is perfect in the world it will fit exactly the way you want. Chances are it will fit a little loose or a little tight.

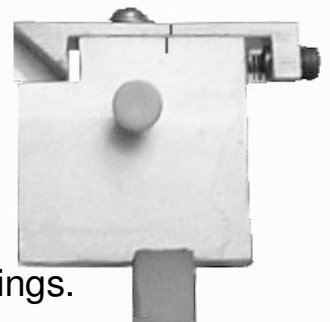
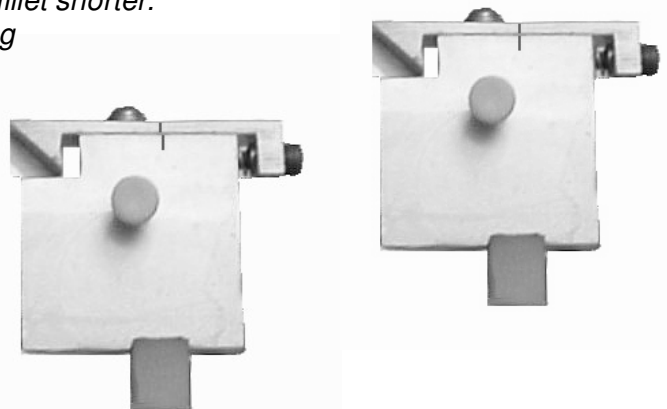
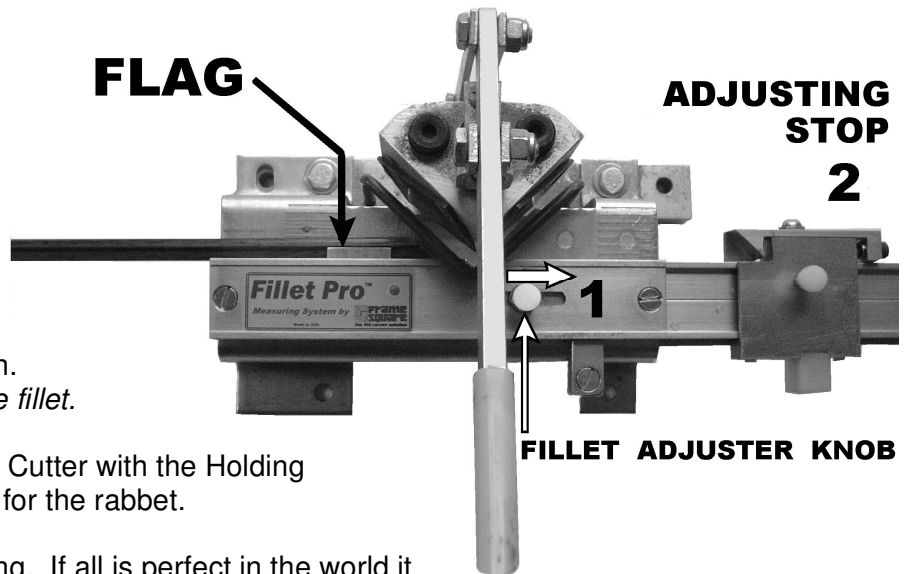
5. **Leave the Adjusting Stop (# 2) exactly where it is.** Do the next steps with the stop in place.

6. If it's a little **tight** do the following... to move the top angled flag to the left slightly....  
*First make a small pencil mark across both pieces (up & down) See illustration at the far right. Loosen the top screw on the Adjusting Stop and turn the allen screw on the right side, clockwise enough to adjust for the difference to make the fillet shorter. The allen screw can be turned by hand if you press the flag section to the left against the spring tension.*

- 6a. *Re-cut the same fillet piece with the new adjustment. If it fits exactly the way you want, then tighten the top screw.*

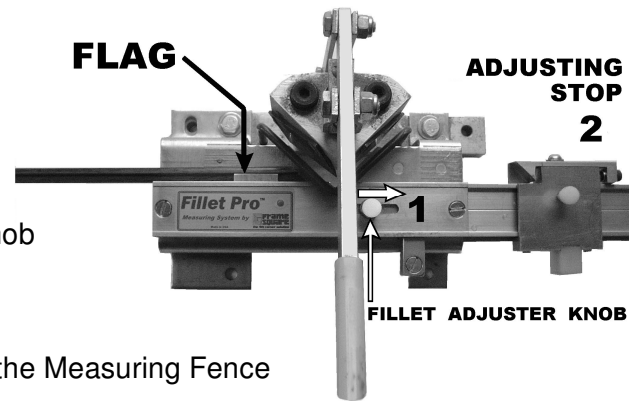
7. If it's a little **loose** do the following... to move the top angled flag to the right slightly ...  
*Loosen the top screw and turn the allen screw counterclockwise until the pencil mark on the flag section is the same amount to the right of the other pencil mark, as the amount you need to make it fit correctly. Place the Measuring Fence back onto the Trim Cutter and cut a new piece of fillet. Check the newly cut piece in the mat opening. If it fits the way you want, then tighten the top screw. If not, then repeat this operation until the fillet piece fits exactly the way you want.*

Once calibrated you can go to the next steps of measuring mat openings.

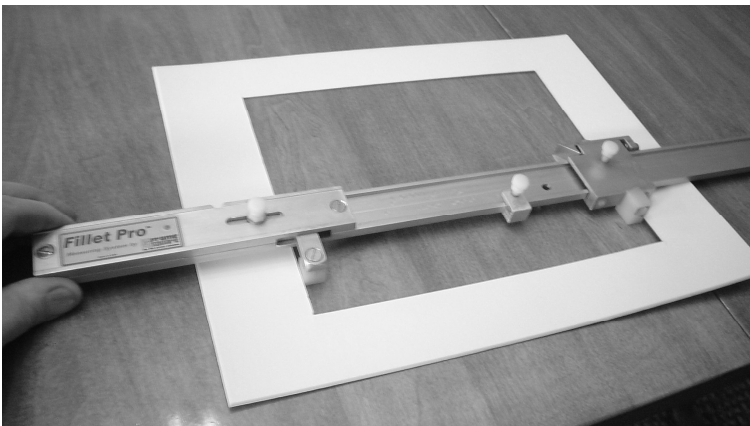
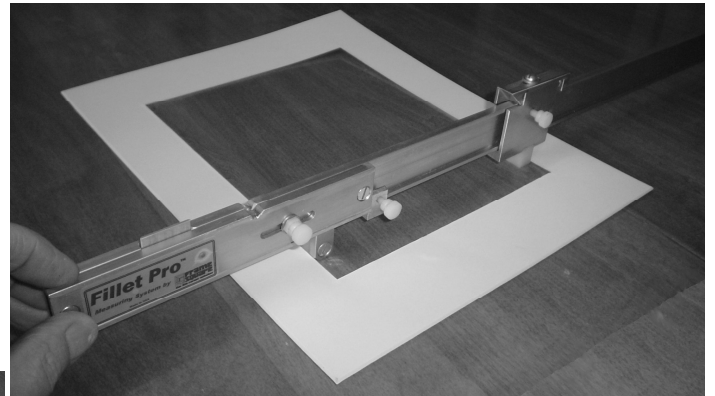


## Operation of the *Fillet Pro* measuring system

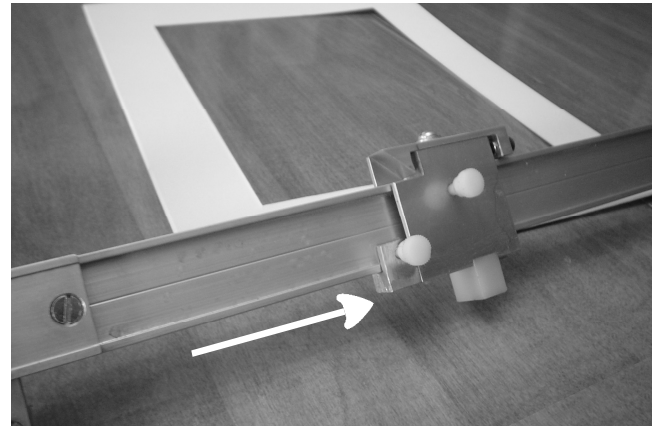
1. Set the fillet to be used against the left side of the measuring fence. Loosen the fillet adjuster knob and slide it to the right. Note the flag above the fillet will rise to meet the step in the fillet shape. Tighten the adjuster knob when the flag height is correct. Hold the fillet *against* the fence while doing this.



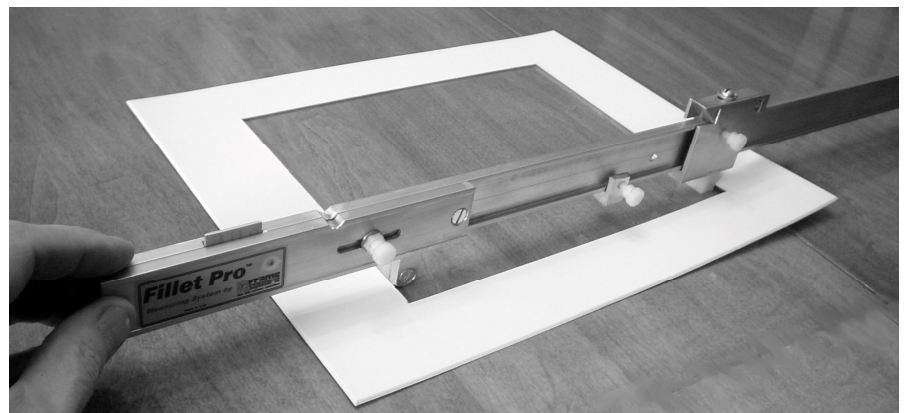
2. Loosen the nylon knob on the Adjusting Stop and remove the Measuring Fence from the Holding Bracket.
3. Position the two nylon measuring blocks between the **short** sides of the mat opening. Tighten the Adjusting Stop knob when the nylon block on the stop is just touching the mat opening, without crushing the edge of the reverse bevel. **Note** that the fence can be held as shown to the right in an upright position, or it can be laid down in a horizontal position as shown below. Whichever way is preferable to you is okay.



4. Loosen the Short Stop knob and slide the stop to the right until it touches the left side of the Adjusting Stop. Tighten the Short Stop knob. This will hold the position for the short side fillet dimension.

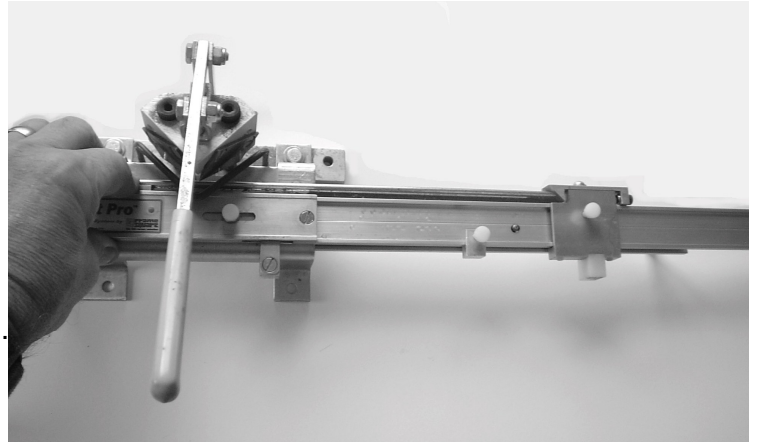


5. Now loosen the Adjusting Stop knob and position the two nylon measuring blocks between the **long** sides of the mat opening. Tighten the Adjusting Stop knob when the nylon block is just touching the mat opening.



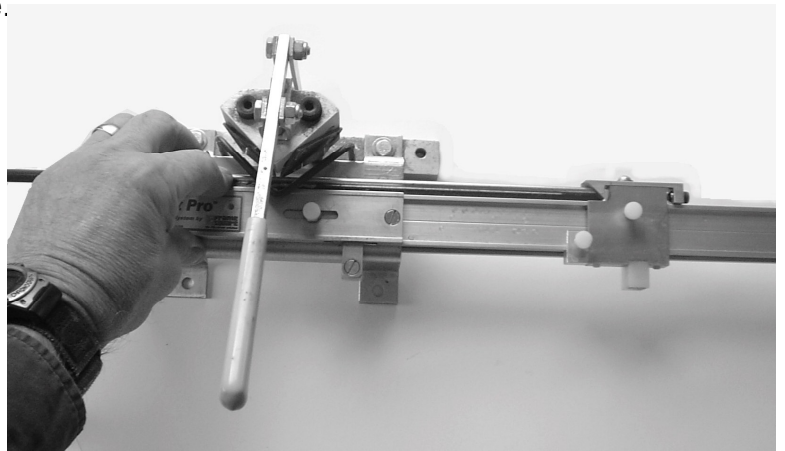
## Operations (continued)

6. Position the Measuring Fence back onto the Trim Cutter aligning it with the locator pins. Slide the fillet to be cut into the machine and cut the first 45° on one end. Slide the fillet to the right until it engages the notch in the Adjusting Stop. Cut the first **long** opening piece. Slide the fillet again and cut the second long piece.



7. Loosen the Adjusting Stop knob and slide the stop back until it touches the Short Stop. Slide the fillet to the right and cut the first **short** opening piece. Slide the fillet to the right again and cut the second short piece. You are now finished with that fillet frame.

No rulers or yardsticks needed for a perfect fit!



Notes: The Fillet Pro Measuring Fence can measure up to 28" long, as is. It will handle openings down to 3" without the Short Stop in place. With the Short Stop on the **left** of the Adjusting Stop the minimum size is 3-1/2". The Short Stop can be used to the **right** side of the Adjusting stop when working with very small openings. It would then hold the long dimension position, and you would take the long dimension first, set the Short Stop on the right, and then move the Adjusting Stop to the short dimension. You would also cut the short side first, then cut the long sides afterwards.

A 28" extension will be available for a very low price. Custom extensions can be requested for mat openings beyond 56"

# PARTS LIST

ITEM	DESCRIPTION	PART #	ITEM	DESCRIPTION	PART #
1	HOLDING BRKT BASE		21	SMALL STOP PIN	
2	SPACER BAR		22	FOOT ASSEMBLY	
3	MEASURING FENCE BASE		23	OPTIONAL EXTENSION BASE	
4	FENCE COVER		24	CONNECTOR BAR W/THREADS	
5	FILLET SLIDE BAR				
6	FLAG PLATE				
7	NYLON FIXED BLOCK				
8	NYLON ADJUSTER BLOCK				
9	ADJUSTING STOP BLOCK				
10	ADJUSTING SLIDE TOP				
11	SHORT STOP				
12	COVER SCREW				
13	FIXED BLOCK SCREW				
14	ADJUSTING BLOCK SCREW				
15	NYLON THUMBSCREW				
16	ADJ SCREW				
17	ADJ SPRING				
18	SPACER MOUNT SCREW				
19	BRKT MOUNT SCREW				
20	LOCATOR PIN				

