

EN

ORIGINAL INSTRUCTIONS
ROUTING MACHINE



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Notes regarding the instructions


Symbols

-  **Warning of electrical voltage**
This symbol indicates dangers to the life and health of persons due to electrical voltage.
-  **Warning of explosive substances**
This symbol indicates dangers to the life and health of persons due to potentially explosive substances.
-  **Warning of hot surface**
This symbol indicates dangers to the life and health of persons due to hot surface.
-  **Warning of sharp object**
This symbol indicates dangers to the life and health of persons due to pointed objects.
-  **Warning of hand injuries**
This symbol indicates dangers to the health of persons due to hand injuries.
-  **Warning**
This signal word indicates a hazard with an average risk level which, if not avoided, can result in serious injury or death.


 **Caution**
This signal word indicates a hazard with a low risk level which, if not avoided, can result in minor or moderate injury.


Note
This signal word indicates important information (e.g. material damage), but does not indicate hazards.


 **Info**
Information marked with this symbol helps you to carry out your tasks quickly and safely.


 **Follow the manual**
Information marked with this symbol indicates that the instructions must be observed.

 **Wear hearing protection**
Information marked with this symbol indicates that you should wear hearing protection.

 **Wear safety glasses**
Information marked with this symbol indicates that you should wear eye protection.

 **Wear a protective mask**
Information marked with this symbol indicates that you should wear a protective mask.

 **Wear protective clothing**
Information marked with this symbol indicates that you should wear protective clothing.

 **Wear protective gloves**
Information marked with this symbol indicates that you should wear protective gloves.

You can download the current version of the instructions via the following link:



PRTS 10-1200



<https://hub.trotec.com/?id=46397>

Safety

General Power Tool Safety Warnings



Warning

Read all safety warnings, instructions, illustrations and specifications provided with this power tool.

Failure to follow all instructions listed below may result in electric shock, fire and/or serious injury.

Save all warnings and instructions for future reference.



Warning

This device must not be used by children and persons under 16 years of age.

Children shall not play with the appliance. Cleaning and user maintenance shall not be made by children under 16 years.

The term *power tool* in the warnings refers to your mains-operated (corded) power tool or battery-operated (cordless) power tool.



General Power Tool Safety Warnings – Work area safety

- **Keep work area clean and well lit.** Clutter or dark areas invite accidents.
- **Do not operate power tools in explosive atmosphere, such as in the presence of flammable liquids, gases or dust.** Power tools create sparks which may ignite the dust or fumes.
- **Keep children and bystanders away while operating a power tool.** Distractions can cause you to lose control.



General Power Tool Safety Warnings – Electrical safety

- **Power tool plugs must match the outlet. Never modify the plug in any way. Do not use any adapter plugs with earthed (grounded) power tools.** Unmodified plugs and matching outlets will reduce risk of electric shock.
- **Avoid body contact with earthed or grounded surfaces, such as pipes, radiators, ranges and refrigerators.** There is an increased risk of electric shock if your body is earthed or grounded.
- **Do not expose power tools to rain or wet conditions.** Water entering a power tool will increase the risk of electric shock.
- **Do not abuse the cord. Never use the cord for carrying, pulling or unplugging the power tool. Keep cord away from heat, oil, sharp edges or moving parts.** Damaged or entangled cords increase the risk of electric shock.

- **When operating a power tool outdoors, use an extension cord suitable for outdoor use.** Use of a cord suitable for outdoor use reduces the risk of electric shock.
- **If operating a power tool in a damp location is unavoidable, use a residual current device (RCD) protected supply.** Use of an RCD reduces the risk of electric shock.



General Power Tool Safety Warnings – Personal safety

- **Stay alert, watch what you are doing and use common sense when operating a power tool. Do not use a power tool while you are tired or under the influence of drugs, alcohol or medication.** A moment of inattention while operating power tools may result in serious personal injury.
- **Use personal protective equipment. Always wear eye protection.** Protective equipment such as a dust mask, non-skid safety shoes, hard hat or hearing protection used for appropriate conditions will reduce personal injuries.
- **Prevent unintentional starting. Ensure the switch is in the off-position before connecting to power source and/or battery pack, picking up or carrying the tool.** Carrying power tools with your finger on the switch or energising power tools that have the switch on invites accidents.
- **Remove any adjusting key or wrench before turning the power tool on.** A wrench or a key left attached to a rotating part of the power tool may result in personal injury.
- **Do not overreach. Keep proper footing and balance at all times.** This enables better control of the power tool in unexpected situations.
- **Dress properly. Do not wear loose clothing or jewellery. Keep your hair and clothing away from moving parts.** Loose clothes, jewellery or long hair can be caught in moving parts.
- **Do not let familiarity gained from frequent use of tools allow you to become complacent and ignore tool safety principles.** A careless action can cause severe injury within a fraction of a second.



General Power Tool Safety Warnings – Power tool use and care

- **Do not force the power tool. Use the correct power tool for your application.** The correct power tool will do the job better and safer at the rate for which it was designed.
- **Do not use the power tool if the switch does not turn it on and off.** Any power tool that cannot be controlled with the switch is dangerous and must be repaired.

- **Disconnect the plug from the power source and/or remove the battery pack, if detachable, from the power tool before making any adjustments, changing accessories, or storing power tools.** Such preventive safety measures reduce the risk of starting the power tool accidentally.
- **Store idle power tools out of the reach of children and do not allow persons unfamiliar with the power tool or these instructions to operate the power tool.** Power tools are dangerous in the hands of untrained users.
- **Maintain power tools and accessories. Check for misalignment or binding of moving parts, breakage of parts and any other condition that may affect the power tool's operation. If damaged, have the power tool repaired before use.** Many accidents are caused by poorly maintained power tools.
- **Keep cutting tools sharp and clean.** Properly maintained cutting tools with sharp cutting edges are less likely to bind and are easier to control.
- **Use the power tool, accessories and tool bits etc. in accordance with these instructions, taking into account the working conditions and the work to be performed.** Use of the power tool for operations different from those intended could result in a hazardous situation.
- **Keep handles and grasping surfaces dry, clean and free from oil and grease.** Slippery handles and grasping surfaces do not allow for safe handling and control of the tool in unexpected situations.



General Power Tool Safety Warnings – Service

- **Have your power tool serviced by a qualified repair person using only identical replacement parts.** This will ensure that the safety of the power tool is maintained.



Safety warnings for routing machines

- **Only hold the power tool by insulated gripping surfaces, as the milling cutter may contact its own cord.** Cutting accessory contacting a "live" wire may make exposed metal parts of the power tool "live" and may give the operator an electric shock.
- **Use clamps or another practical way to secure and support the workpiece to a stable platform.** Holding the workpiece by your hand or against the body leaves it unstable and may lead to loss of control.



Additional safety warnings for routing machines



Wear protective gloves when changing the insertion tools. The applied tools heat up during longer operation.

- **During operation hold onto the power tool with both hands and make sure you stand firmly on the ground.** It is safer to handle the power tool with two hands.
- **Wait until the device has come to a standstill, before putting it down.**
- **The rated speed of the milling tools must be at least equal to the maximum speed marked on the power tool.** Accessories running faster than their rated speed may be destroyed.
- **Milling cutters or other accessories must fit exactly into the collet chuck (shank diameter 6/8 mm) of your power tool.** Milling tools that do not precisely match the collet chuck of the power tool will run out of balance, vibrate excessively and may cause loss of control.
- **Only hold the power tool against the workpiece when the tool is switched on and running.** Otherwise there is a risk of kickback if the tool bit gets caught in the workpiece.
- **Keep your hands away from the milling area and the milling cutter.** Keep your second hand on auxiliary handle, or motor housing. If both hands are holding the milling cutter, they cannot be cut by the milling cutter.
- **Never mill over metal objects, nails or screws.** The milling cutter can be damaged and cause increased vibrations.
- **Use suitable detectors to determine if utility lines are hidden in the work area or call the local utility company for assistance. Contact with electrical lines may result in fire and electric shock.** Damaging a gas line may lead to an explosion. Damaging a water line causes property damage.
- **The maximum speed indicated on the tool must not be exceeded.**
- **Tools with visible cracks must not be used.**

Intended use

We recommend using the power tool with original Trotec accessories.

Only use the device PRTS 10-1200 for:

- Milling
 - Wood
 - Plastics
 - Free-form milling
 - Profile milling
 - Milling with a centring tip
 - Milling with a rip fence
 - Edge and profile milling

indoors and in compliance with the technical data.

Foreseeable misuse

Do not use the device PRTS 10-1200 for:

- Milling of steel or non-ferrous metals
- Milling ceramics or stone
- Processing workpieces requiring a continuous water supply

The device is not suitable for permanent use in protected outdoor areas.

Any other use than the one described in the chapter "Intended use" is regarded as reasonably foreseeable misuse.

Personnel qualifications

People who use this device must:

- have read and understood the instructions, especially the Safety chapter.

Personal protective equipment



Wear hearing protection.

Excessive noise can lead to hearing loss.



Wear eye protection.

With it you protect your eyes from splintering, falling and flying pieces which could cause injuries.



Wear a protective mask.

It saves you from inhaling harmful dusts generated when processing workpieces.



Wear protective gloves.

They protect your hands from burns, crushing injuries and skin abrasions.



Wear tight-fitting protective clothing.

This protects you from the draw-in and entanglement hazard posed by rotating parts.

Residual risks



Warning of electrical voltage

Electric shock from insufficient insulation.

Check the device for damages and proper functioning before each use.

If you notice damages, no longer use the device.

Do not use the device when the device or your hands are damp or wet!



Warning of electrical voltage

Work on the electrical components must only be carried out by an authorised specialist company!



Warning of electrical voltage

Before any work on the device, remove the mains plug from the mains socket!

Do not touch the mains plug with wet or damp hands.

Hold onto the mains plug while pulling the power cable out of the mains socket.



Warning of electrical voltage

There is a risk of a short-circuit due to liquids penetrating the housing!

Do not immerse the device and the accessories in water. Make sure that no water or other liquids can enter the housing.



Warning of explosive substances

Fine dust produced during milling is highly flammable. Risk of fire and explosion!

Use a dust extraction system for collecting the produced dusts.



Warning of hot surface

The milling cutter might still be hot after use. Burn hazard when touching the milling cutter.

Do not touch the milling cutter bare-handed!

Wear protective gloves!



Warning of sharp object

Milling cutters have sharp cutting edges. Risk of injury from cuts if handled without due care.

Wear protective gloves!



Warning

Toxic dusts!



The harmful / toxic dusts produced during operation pose of risk to the health of the operator and persons in the vicinity.



Wear eye protection and a dust mask!



Warning

Do not process materials containing asbestos. Asbestos is considered carcinogenic.

Warning
Risk of injuries caused by flying parts.
Use a dust or chip bag or a dust extraction system.

Warning
Dangers can occur at the device when it is used by untrained people in an unprofessional or improper way! Observe the personnel qualifications!

Warning
The device is not a toy and does not belong in the hands of children.

Warning
Risk of suffocation!
Do not leave the packaging lying around. Children may use it as a dangerous toy.

Caution
Vibration emissions can cause a health hazard if the device is used for an extended period of time or if it is not properly handled and maintained.

Caution
Keep a sufficient distance from heat sources.

Note
If you store or transport the device improperly, the device may be damaged.
Note the information regarding transport and storage of the device.

Behaviour in the event of an emergency / emergency stop function

Emergency stop:

Removing the mains plug from the mains socket results in the function of the device immediately stopping. In order to secure the device against accidental switch-on, leave the mains plug disconnected.

Behaviour in the event of an emergency:

1. Switch the device off.
2. In an emergency, disconnect the device from the mains feed-in: Hold onto the mains plug while pulling the power cable out of the mains socket.
3. Do not reconnect a defective device to the mains.

Information about the device

Device description

The device PRTS 10-1200 is a routing machine for routing workpiece surfaces and edges in wood, plastic and lightweight construction materials.

The supplied cutter bits allow to create grooves, V-grooves, milling of fillets, rounding and milling of profiles in workpiece edges.

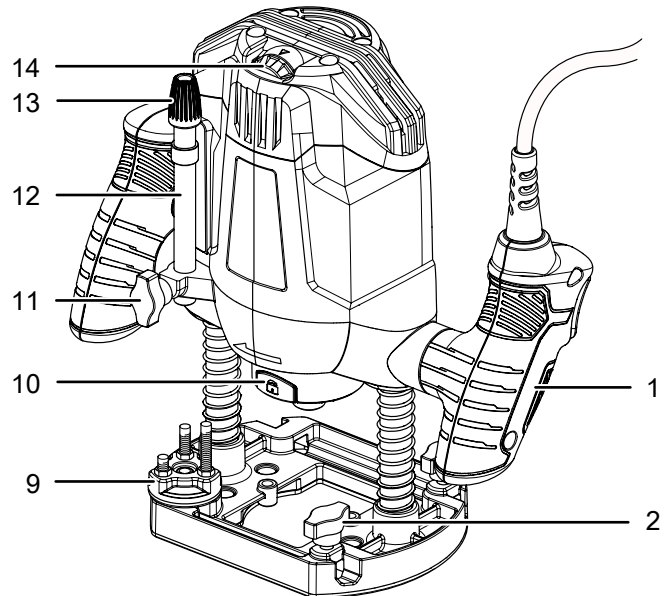
The cutting depth can be infinitely adjusted between 0 mm and 55 mm. The milling depth can be set to within 0.1 mm via the fine adjustment.

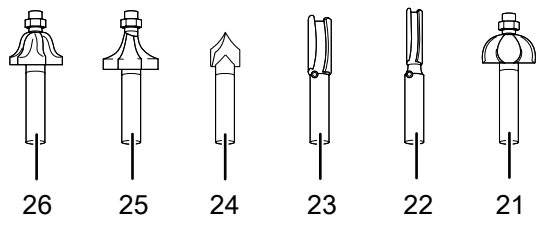
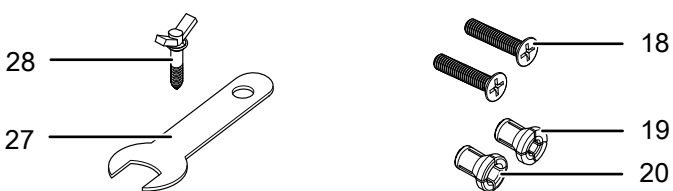
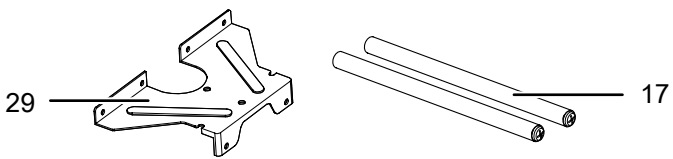
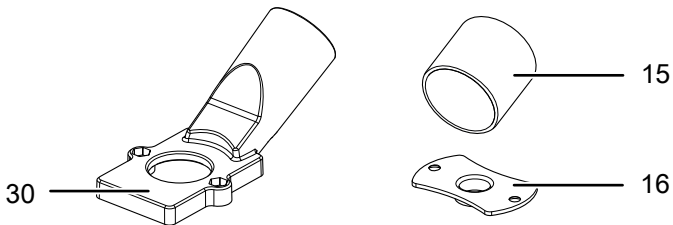
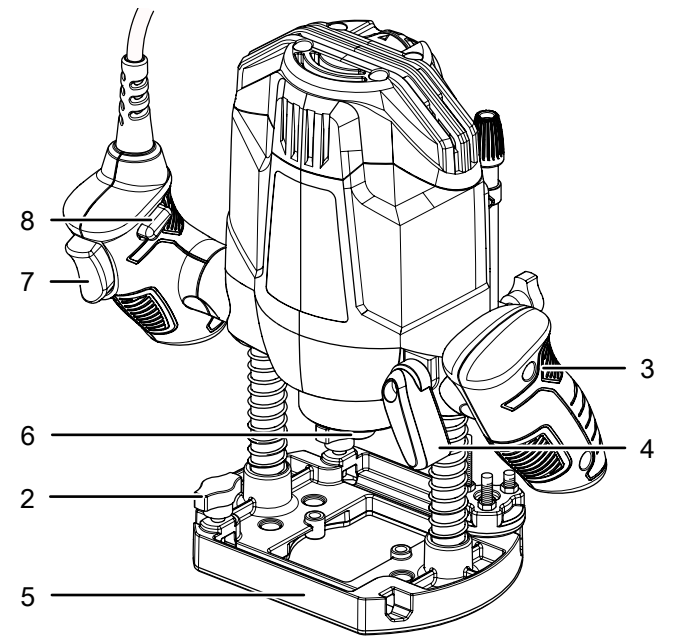
For material-compatible working, the rated speed can be set steplessly within a range of 11,000 rpm to 30,000 rpm at the setting wheel.

The device is equipped with a start lock to prevent the device from being switched on unintentionally, as well as a spindle lock that provides for an easy change of the milling cutter.

The mountable adapter for external dust extraction allows for dust-free and clean working.

Device depiction






No.	Designation
1	Right handle
2	Wing screw for rip fence
3	Left handle
4	Locking lever for milling depth lock
5	Base plate
6	Tool holder
7	On/off switch
8	Start lock
9	Step buffer
10	Spindle lock button
11	Wing screw for depth stop
12	Depth stop
13	Control dial for milling depth setting
14	Setting wheel speed selection
15	Reducer (dust extraction system)
16	Guide bush
17	Guide rods
18	Phillips screws
19	Collet chuck 6 mm
20	Collet chuck 8 mm
21	Semicircular milling cutter
22	6 mm groove cutter
23	12 mm groove cutter
24	V-groove cutter
25	Rounding cutter
26	Profile cutter
27	Open-end wrench
28	Centring tip with wing nut
29	Rip fence
30	Extraction adapter

Scope of delivery

Some of the parts mentioned below have been pre-installed on the device.

- 1 x routing machine PRTS 10-1200
- 1 x rip fence
- 2 x guide rods
- 1 x collet chuck 6 mm
- 1 x collet chuck 8 mm
- 1 x profile cutter
- 1 x 6 mm groove cutter
- 1 x 12 mm groove cutter
- 1 x V-groove cutter
- 1 x rounding cutter
- 1 x semicircular milling cutter
- 1 x adapter for external dust extraction
- 1 x reducer (dust extraction system)
- 2 x Phillips screws
- 1 x guide bush
- 1 x centring tip with wing nut
- 1 x open-end wrench
- 1 x depth stop
- 1 x manual

Technical data

Parameter	Value
Model	PRTS 10-1200
Mains connection	230 V / 50 Hz
Power consumption	1200 W
Rated no-load speed	11,000 – 30,000 rpm
Milling depth setting / milling stroke	55 mm
Tool holder	6 or 8 mm
Cable length	3 m
Type of protection	IP20
Protection class	II (double insulation) / 
Weight	3 kg
Vibration information according to EN 62841-2-17	
Vibration emission value a_h at the right handle	6.437 m/s ²
Vibration emission value a_h at the left handle	5.060 m/s ²
Uncertainty K	1.5 m/s ²
Sound values according to EN 62841-2-17	
Sound pressure level L_{pA}	89 dB (A)
Sound power L_{WA}	100 dB(A)
Uncertainty K	3 dB



Wear hearing protection.

Excessive noise can lead to hearing loss.

Information on noise and vibration:

- The specified total vibration **and noise emission values** were measured by means of a test procedure standardized in EN 62841 and can be consulted for the comparison of one power tool with another.
- The specified total vibration **and noise emission values** can also be used for preliminary load assessment.



Caution

Vibration emissions can cause a health hazard if the device is used for an extended period of time or if it is not properly handled and maintained.

- The actual vibration **and noise emission** may differ from the stated values during operation of the power tool. This depends on how the power tool is used and especially on the type of workpiece being processed. Try to keep the vibration load to a minimum. Exemplary measures for reducing the vibration load include wearing gloves during operation of the tool and the limitation of working hours. All parts of an operating cycle must be considered for this (e.g. times at which the power tool is switched off and times when it is switched on but runs without load).

Transport and storage

Note

If you store or transport the device improperly, the device may be damaged.

Note the information regarding transport and storage of the device.

Transport

Before transporting the device, observe the following:

- Switch off the device.
- Hold onto the mains plug while pulling the power cable out of the mains socket.
- Allow the device to cool down.

Storage

Before storing the device, observe the following:

- Switch off the device.
- Hold onto the mains plug while pulling the power cable out of the mains socket.
- Allow the device to cool down.
- Disconnect the dust extraction system from the device.
- Clean the device as described in the Maintenance chapter.

When the device is not being used, observe the following storage conditions:

- dry and protected from frost and heat
- Ambient temperature below 45 °C
- Protected from dust and direct sunlight

Start-up

Unpacking the device

- Take the device and the accessories out of the packaging.



Warning of electrical voltage

Electric shock from insufficient insulation.

Check the device for damages and proper functioning before each use.

If you notice damages, no longer use the device.

Do not use the device when the device or your hands are damp or wet!

- Check the contents for completeness and look for damages.



Warning

Risk of suffocation!

Do not leave the packaging lying around. Children may use it as a dangerous toy.

- Dispose of the packaging material according to the national regulations.

Observe the following information before start-up:



Warning of hot surface

The milling cutter might still be hot after use. Burn hazard when touching the milling cutter.

Do not touch the milling cutter bare-handed!

Wear protective gloves!



Warning of sharp object

Milling cutters have sharp cutting edges. Risk of injury from cuts if handled without due care.

Wear protective gloves!



Note

Never actuate the spindle lock (10) button while the tool is running! This may damage the tool.

Note

Only use milling cutters with a shank diameter suitable for the respective collet chuck installed.

Tool change

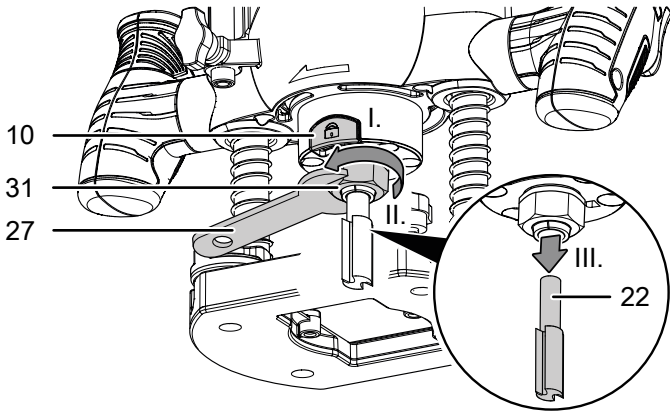


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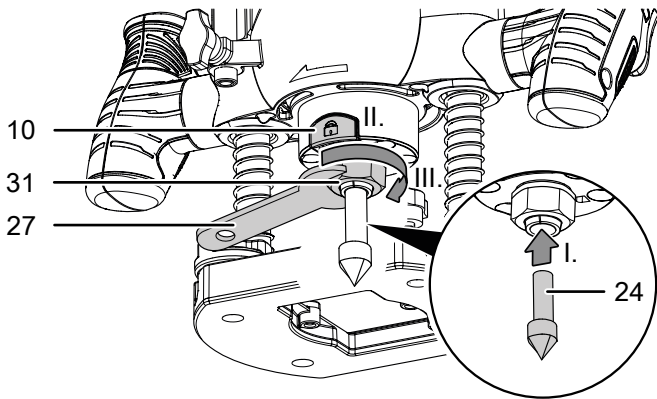
Before changing the tool, check whether the suitable collet chuck is mounted and replace it, if necessary.

In order to change the tool, proceed as follows:

1. Press the spindle lock (10) and keep it pressed.
2. Unscrew the union nut (31) using the open-end wrench (27) by turning it in counter-clockwise direction. It is not necessary to fully unscrew the union nut (31).
3. Remove the tool from the tool holder, if any.



4. Insert the required tool in the tool holder.



5. Tighten the union nut (31) using the open-end wrench (27) and let go of the spindle lock (10).
6. Make sure that the tool is attached securely.

Replacing the collet chuck



Warning of electrical voltage

Before any work on the device, remove the mains plug from the mains socket!

Do not touch the mains plug with wet or damp hands. Hold onto the mains plug while pulling the power cable out of the mains socket.



Wear protective gloves

Wear appropriate protective gloves when inserting or exchanging tools.

Note

Never actuate the spindle lock (10) button while the tool is running! This may damage the tool.

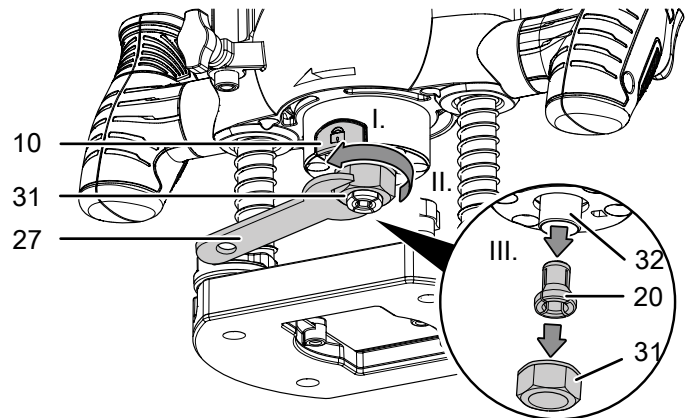
Note

Only tighten the union nut only with the milling cutter inserted to prevent damage to the collet chuck.

All router bits supplied are fitted with an 8 mm router shank. Change the collet chuck for cutters with a 6 mm cutter shank.

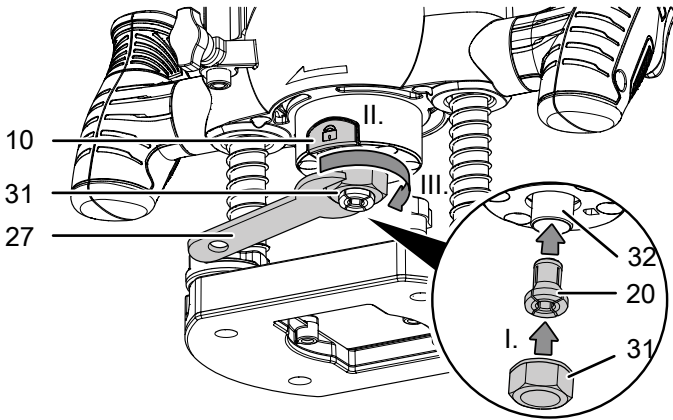
Please proceed as follows:

1. Press the spindle lock (10) button and keep it pressed.
2. Unscrew the union nut (31) in counter-clockwise direction using the open-end wrench (27).
3. Remove the 8 mm collet chuck (20) from the collet chuck holder.



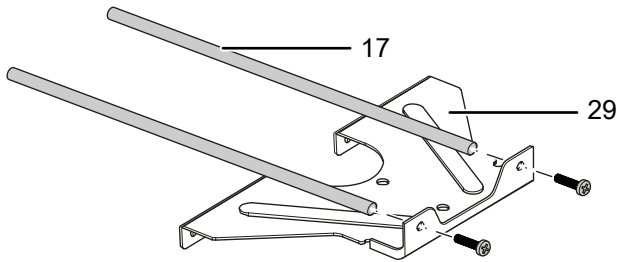
4. Insert the 6 mm collet chuck into the collet chuck holder.

- Screw the union nut (31) onto the collet chuck holder in clockwise direction and tighten the union nut (31) using the open-end wrench (27). Then let go of the spindle lock (10).



Pre-assembling the rip fence

- Unscrew both screws from the guide rods (17).
- Screw the guide rods (17) to the rip fence (29).



Mounting the external dust extraction system

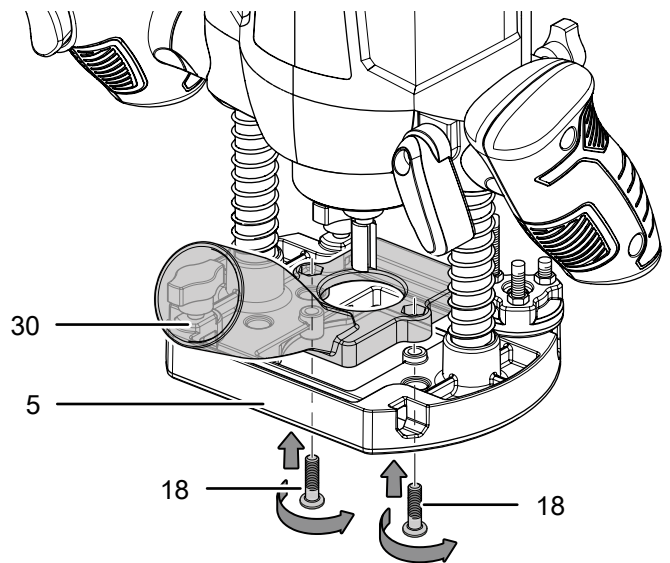


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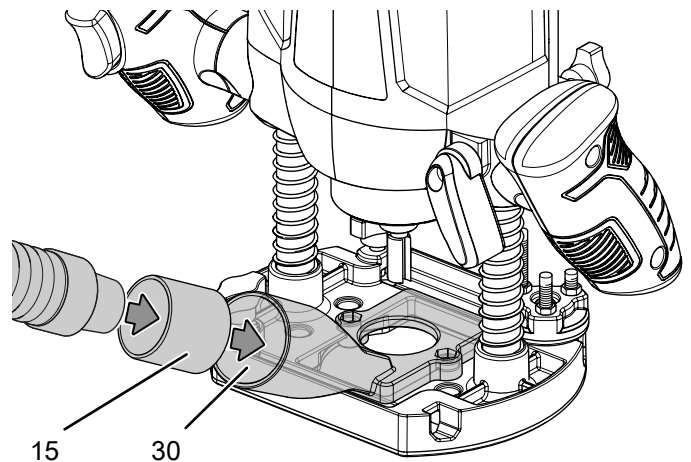
Make sure that the vacuum cleaner is suitable for the material used. Use a special vacuum cleaner if harmful dusts are produced.

By connecting the dust extraction system to the machine, you can reduce the amount of dust produced during working.

- Place the adapter for dust extraction (30) onto the holes provided in the base plate (5).
- Insert and fasten the 2 supplied Phillips screws (18) from the bottom side of the base plate (5).



- Connect a suitable vacuum cleaner (e.g. industrial vacuum cleaner) to the adapter for dust extraction (30). If required, you can first connect the reducer (15) to the adapter for dust extraction (30). If anything is unclear or if you have questions, please contact the manufacturer of your vacuum cleaner.



Setting the milling depth



Info

The step buffer has 3 preset steps.

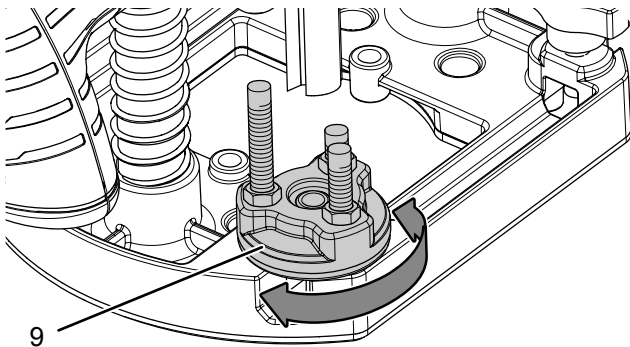


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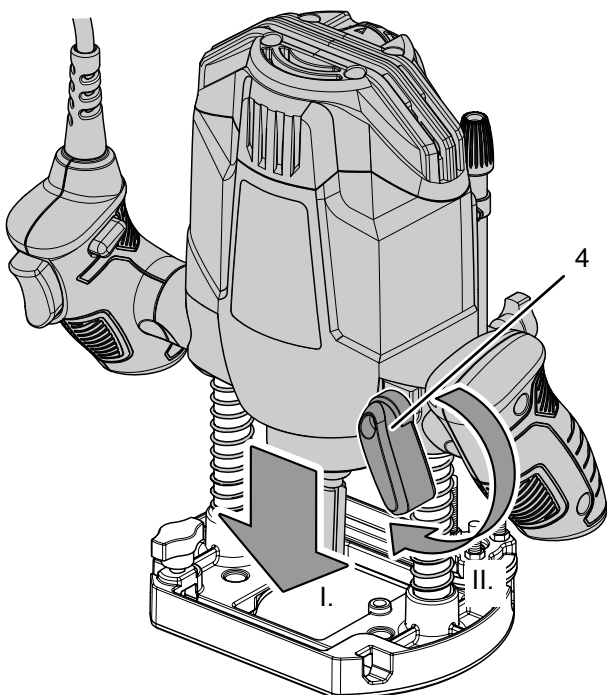
Check the setting of the milling depth before starting the actual milling process by carrying out a milling test on a waste piece.

✓ Make sure that the locking lever (4) is locked.

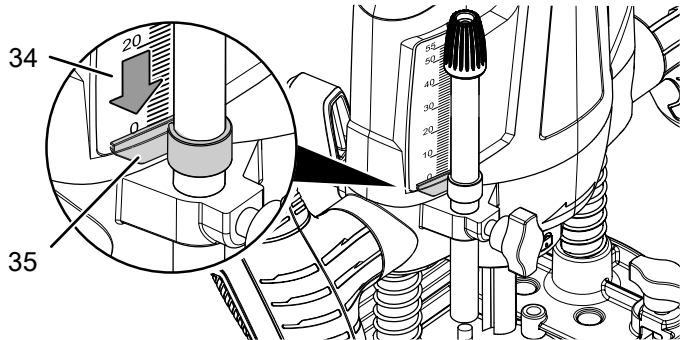
1. Place the device on a flat surface with the milling cutter inserted.
2. Turn the step buffer (9) until it engages with the lowest step below the depth stop (12).



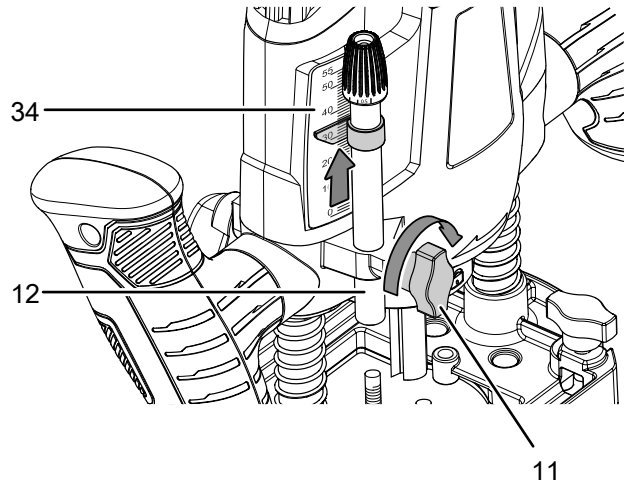
3. Loosen the wing screw (11) on the depth stop (12) and, if required, turn the control dial for the fine adjustment (13) to position 0, with the 0 on the scale pointing towards you.
4. If required, release the locking lever for the milling depth lock (4) by turning it upwards and slowly push the device downwards until the milling cutter touches the workpiece.
5. Lock the locking lever for the milling depth lock (4) by turning it downwards.



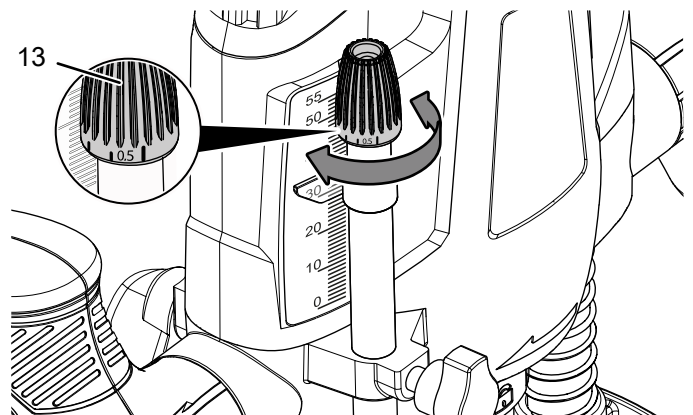
6. Slide the depth stop (12) down until it rests on the step buffer (9).
7. Set the slider with the index marker (35) to position 0 on the milling depth scale (34).



8. Then set the depth stop (12) to the desired milling depth and tighten the wing screw (11).



9. If required, make a fine adjustment by turning the control dial for the fine adjustment (13) in 0.1 mm steps to the desired level, whereby one whole turn corresponds to 1 mm: Turn counter-clockwise to increase the milling depth. Turn clockwise to decrease the milling depth.



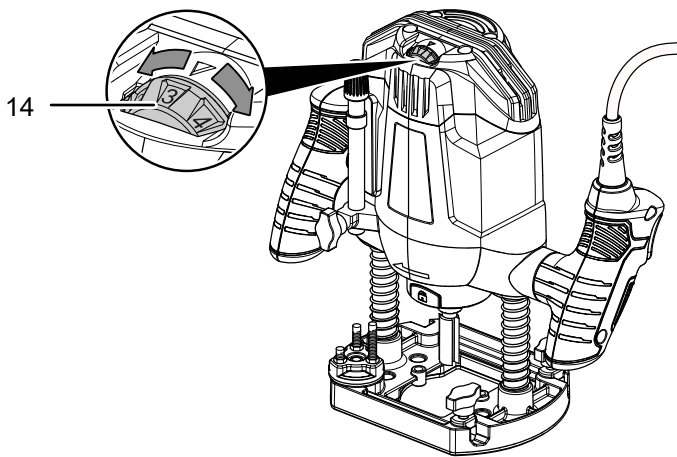
10. After having adapted the fine adjustment, you can set the scale below the control dial (13) to position "0".

Speed selection

The required speed depends on the material and the operating conditions and can be determined by way of field-testing. Work with lower speeds for large milling cutter diameters and hard workpieces, and with higher speeds for small cutter diameters and soft workpieces. The best way to determine the appropriate speed is to carry out a milling test. Some materials (certain plastics), however, may be damaged by the heat generated at a high speed and should therefore be processed at a correspondingly lower speed.

The setting range covers the levels 1 – 7 (11,000 – 30,000 rpm). You can change the preselected speed level at any time.

1. Turn the setting wheel (14) to the desired speed level.



Tips and notes for selecting the correct speed level

- Select a high speed level (level 5-7) for milling wood.
- Select a medium speed level (level 3-4) for milling softwoods and chipboards.
- If you wish to mill plastics or other materials with a low melting point, select a low speed level (level 1-2).

Operation



Wear a protective mask.

It saves you from inhaling harmful dusts generated when processing workpieces.

Tips and notes on handling the routing machine

General information:

- Keep the venting slots clear to prevent the motor from overheating.
- Check the tool in the tool holder for proper fit before every application. The tool must be firmly locked in place in the designated holding fixtures in the tool holder.
- Before every application, make sure that you have selected the correct tool and the correct speed for the intended use. By adapting the speed to the task you have planned and to the m to be machined, better results can be obtained.
- Preferably use excess material to test the feed rate.

Milling:

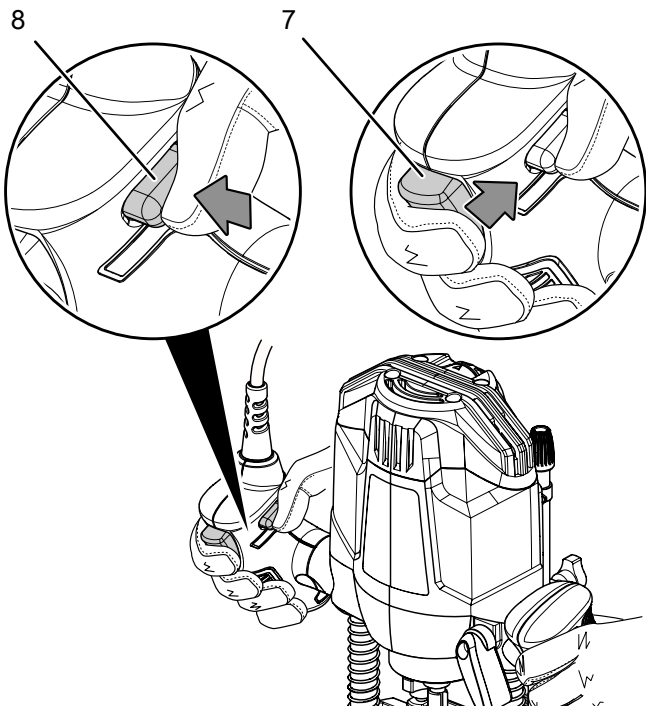
- Provide for an even forward motion to prevent overheating of the milling cutter.
- Hold onto the tool with both hands.
- Always mill with an even forward motion and steady movements.
- Always mill against the direction of rotation of the cutter (reverse rotation). When milling in the direction of rotation (forward rotation), the device can be torn out of your hand.
- Use the V-groove cutter to mill grooves.
- Use the profile cutter to mill edges.

Switching the device on and off

Wear your personal protective equipment when working with the device.

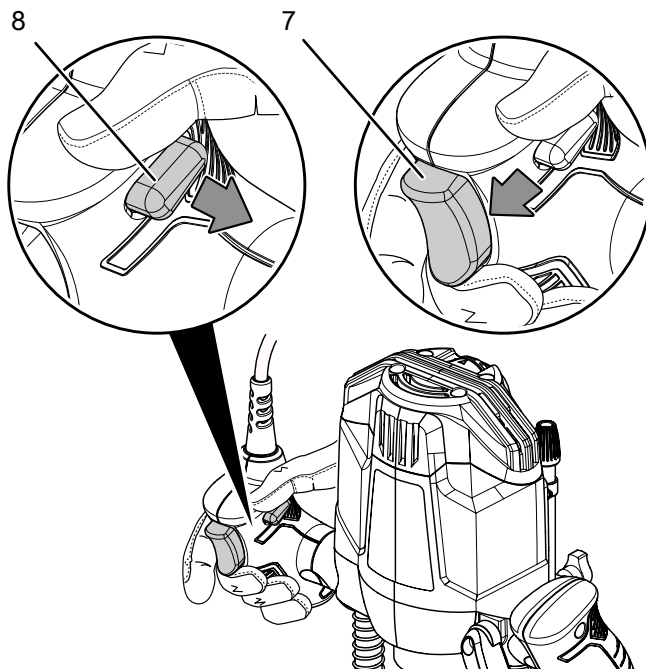
1. Check whether the milling depth set is suitable for the intended application.
2. Check whether the inserted milling cutter is suitable for the intended application.
3. Check whether the workpiece is secured and the worktop prepared correspondingly.
4. Position the device on the workpiece.
5. Press the start lock (8) to be able to actuate the on/off switch (7).

6. Press the on/off switch (7) and hold it during operation.



7. After completion the milling process, release the on/off switch (7) again to switch off the device.

8. Set the device down in a stable position.

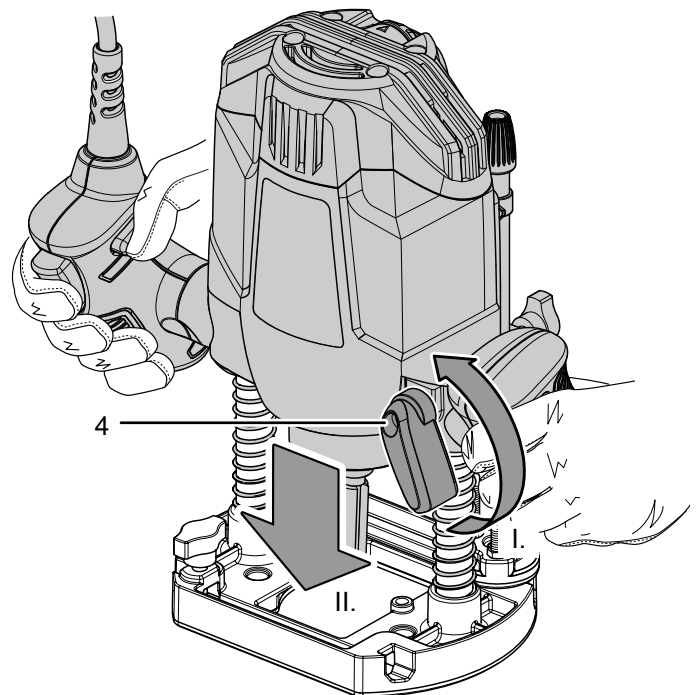


Milling process

Note

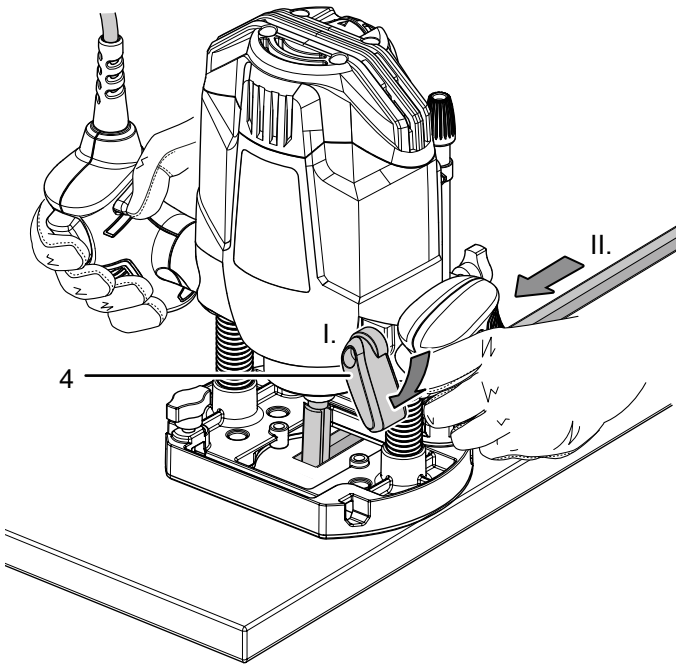
Always mill against the direction of rotation of the cutter (reverse rotation). When milling in the direction of rotation (forward rotation), the device can be torn out of your hand.

1. Set the desired milling depth.
2. Place the device on the workpiece to be machined with the milling cutter that has been already inserted, then switch the device on.
3. If required, release the locking lever for the milling depth lock (4) by turning it upwards and lower the routing machine until the milling cutter enters the workpiece.



4. When you have reached the desired milling depth, lock the position with the locking lever for the milling depth lock (4) by turning it downwards.

5. Guide the device through the workpiece with even pressure.

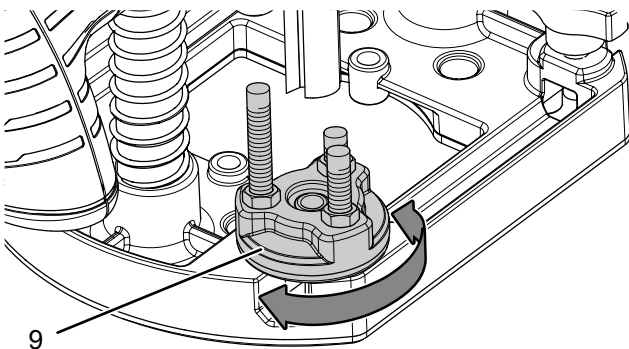


6. To complete the milling process, release the locking lever for the milling depth lock (4) by turning it upwards.
7. Allow the routing machine to return to the uppermost position.
8. Switch the device off.

Progressive milling

For greater milling depths, it is possible to perform stepwise milling by means of the step buffer (9).

1. Turn the step buffer (9) until it audibly engages at the highest step below the depth stop.



2. Set all further milling depths using the lower steps of the step buffer (9).

Edge and profile milling



Info

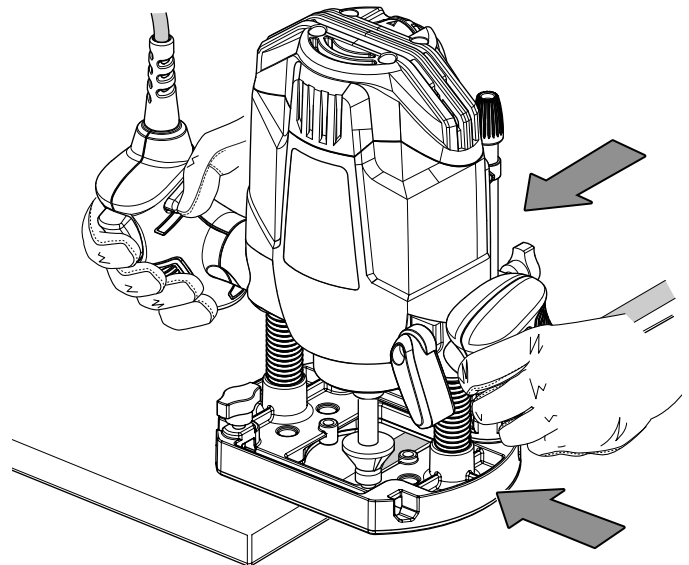
The milling cutter must be equipped with a guide pin or a ball bearing when performing edge or profile milling operations without using a rip fence.

- **Use clamps or another practical way to secure and support the workpiece to a stable platform.** Holding the workpiece by your hand or against the body leaves it unstable and may lead to loss of control.

Note

Excessive pressure when performing edge or profile milling operations can damage the edge of the workpiece.

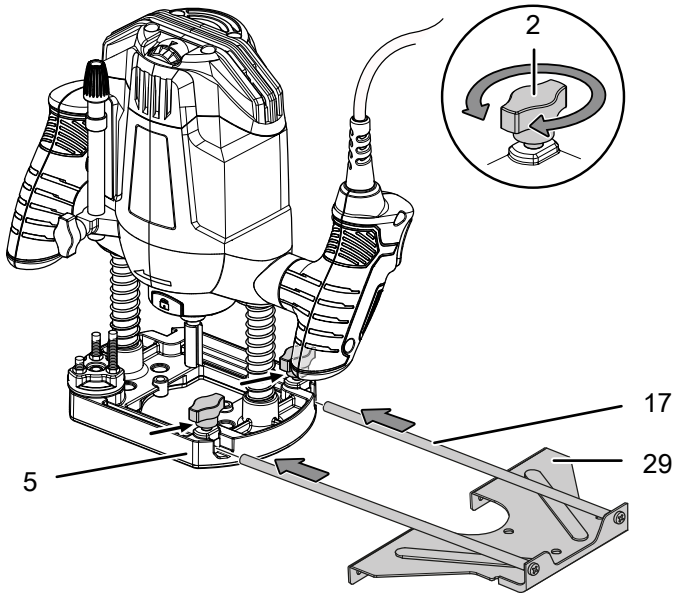
1. Move the activated device towards the workpiece from the side until the ball bearing rests on the edge of the workpiece to be machined.
2. Guide the device along the edge of the workpiece with both hands. Make sure to use a suitable, rectangular support.



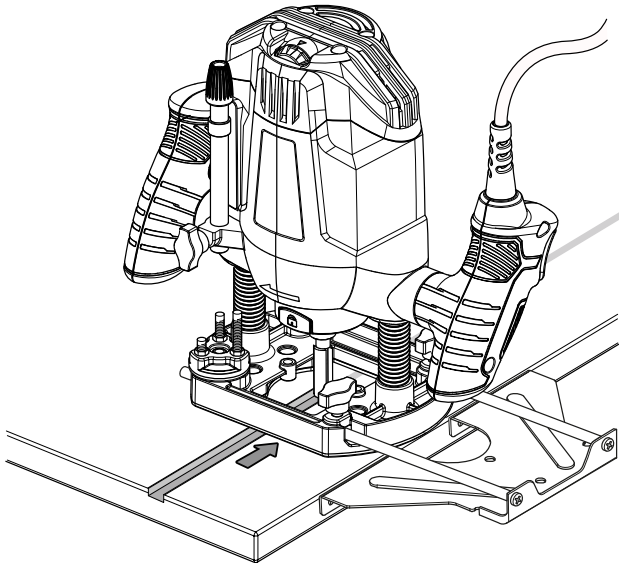
Milling with a rip fence

Use the rip fence for milling grooves or V-grooves as well as for milling and chamfering workpiece edges.

1. Push the rip fence (29) with the guide rods (17) into the base plate (5) and tighten it with the locking screws (2) as required.

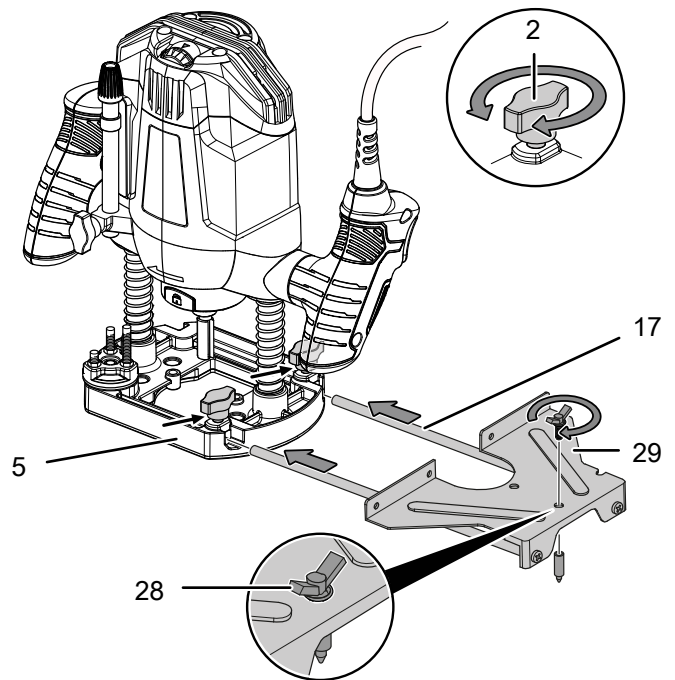


2. Guide the activated device along the edge of the workpiece with an even forward motion and by applying lateral pressure on the rip fence.

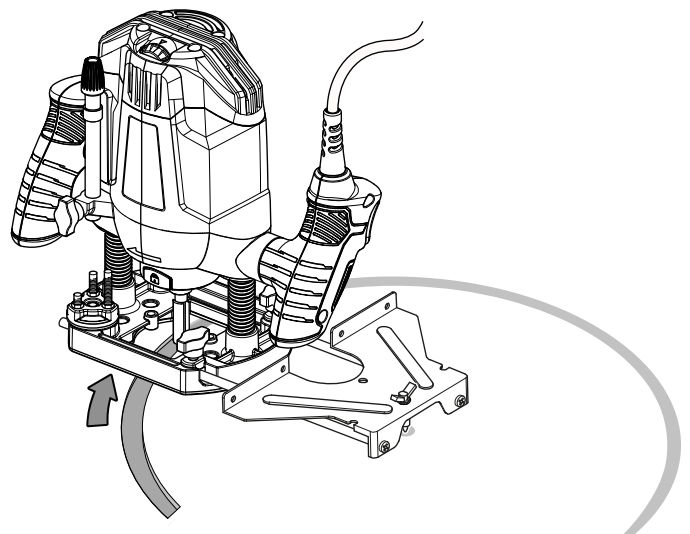


Milling circular arcs

1. Turn the rip fence (29) in a way that the protruding stop parts point upwards.



2. Push the rip fence (29) with the guide rods (17) into the base plate (5) and tighten it with the locking screws (2) as required.
3. Attach the centring tip with the wing nut (28) through the hole on the rip fence (29).
4. Pierce the centring tip (28) into the marked centre of the arc and perform the milling process with an even forward motion.

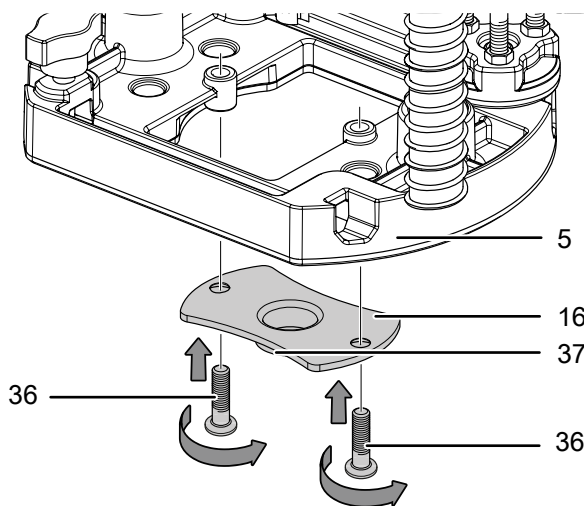


Milling with the guide bush

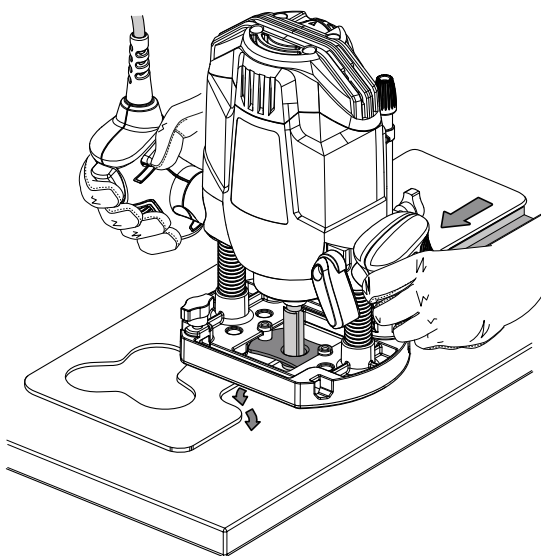
The template must be at least as high as the guide ring (37) of the guide bush (16).

✓ If the extraction adapter (30) is fitted, it must be dismantled beforehand.

1. Insert the guide bush (16) into the base plate (5) from below, with the guide ring (37) pointing downwards.
2. Attach the guide bush (16) using the supplied Phillips screws (36).



3. Insert a milling cutter whose diameter is smaller than the inner diameter of the guide bush (16).
4. Release the locking lever (4) and lower the device until the preset milling depth is reached.
5. Guide the device along the template with the guide ring (37) protruding. Meanwhile, apply slight and even pressure.



Shutdown



Warning of electrical voltage

Do not touch the mains plug with wet or damp hands.

- Switch off the device.
- Hold onto the mains plug while pulling the power cable out of the mains socket.
- If required, allow the device to cool down.
- Clean the device according to the Maintenance chapter.
- Store the device according to the Transport and storage chapter.

Errors and faults

The device has been checked for proper functioning several times during production. If malfunctions occur nonetheless, check the device according to the following list.

Troubleshooting tasks which require the housing to be opened must only be carried out by an authorized specialist electrical company or by Trotec.

Light smoke or odour is emitted during the first use:

- This is not a fault. These phenomena disappear after a brief runtime.

The device does not start:

- Check the power connection.
- Check the power cable and mains plug for damage. If you notice damages, do not try to take the device back into operation.

If the supply cord is damaged, it must be replaced by the manufacturer, its service agent or similarly qualified persons in order to avoid a hazard.

- Check the on-site fusing.



Info

Wait for at least 10 minutes before switching the device back on.

The device becomes hot:

- Make sure not to exert too much pressure on the device during operation.
- Keep the venting slots clear to prevent the motor from overheating.
- Wait for at least 10 minutes before switching the device back on.

The cutter mills very badly and becomes hot:

- Check whether the inserted milling cutter used is suitable for the application. Use a different milling cutter if required.
- Check whether the milling cutter has become blunt. Only use sharp milling cutters.
- Check the milling depth setting. If required, reduce the milling depth and mill through the material in several depth stages. Ideally, use the step buffer to do so.

Note

Wait for at least 10 minutes after maintenance and repair work. Only then switch the device back on.

The device still does not operate correctly after these checks:

Please contact the customer service. If necessary, bring the device to an authorised specialist electrical company or to Trotec for repair.

Maintenance**Activities required before starting maintenance****Warning of electrical voltage**

Do not touch the mains plug with wet or damp hands.

- Switch off the device.
- Hold onto the mains plug while pulling the power cable out of the mains socket.
- Allow the device to cool down completely.

**Warning of electrical voltage**

Maintenance tasks which require the housing to be opened must only be carried out by authorised specialist companies or by Trotec.

Notes on maintenance

Inside the device, there are no parts that need to be lubricated by the user.

Cleaning

The device should be cleaned before and after each use.

**Warning of electrical voltage**

There is a risk of a short-circuit due to liquids penetrating the housing!

Do not immerse the device and the accessories in water. Make sure that no water or other liquids can enter the housing.

- Clean the device with a soft, damp and lint-free cloth. Make sure that no moisture enters the housing. Protect electrical components from moisture. Do not use any aggressive cleaning agents such as cleaning sprays, solvents, alcohol-based or abrasive cleaners to dampen the cloth.
- Dry the device with a soft, lint-free cloth.

Disposal

Always dispose of packing materials in an environmentally friendly manner and in accordance with the applicable local disposal regulations.



The icon with the crossed-out waste bin on waste electrical or electronic equipment stipulates that this equipment must not be disposed of with the household waste at the end of its life. You will find collection points for free return of waste electrical and electronic equipment in your vicinity. The addresses can be obtained from your municipality or local administration. You can also find out about other return options that apply for many EU countries on the website <https://hub.trotec.com/?id=45090>. Otherwise, please contact an official recycling centre for electronic and electrical equipment authorised for your country.

The separate collection of waste electrical and electronic equipment aims to enable the re-use, recycling and other forms of recovery of waste equipment as well as to prevent negative effects for the environment and human health caused by the disposal of hazardous substances potentially contained in the equipment.

Only for United Kingdom

According to Waste Electrical and Electronic Equipment Regulations 2013 (2013/3113) devices that are no longer usable must be collected separately and disposed of in an environmentally friendly manner.

Declaration of conformity

Declaration of conformity in accordance with the EC Machinery Directive 2006/42/EC, Annex II, Part 1, Section A

We – Trotec GmbH – declare in sole responsibility that the product designated below was developed, constructed and produced in compliance with the requirements of the EC Machinery Directive in the version 2006/42/EC.

Product model / Product: PRTS 10-1200
Product type: routing machine
Year of manufacture as of: 2022

Relevant EU directives:

- 2011/65/EU: 01/07/2011
- 2012/19/EU: 24/07/2012
- 2014/30/EU: 29/03/2014
- 2015/863/EU: 31/03/2015

Applied harmonised standards:

- EN 62841-1:2015
- EN 62841-1:2015/AC:2015
- EN 62841-2-17:2017

Applied national standards and technical specifications:

- EN IEC 55014-1:2021
- EN IEC 55014-2:2021
- EN 61000-3-3:2013+A1:2019
- EN IEC 61000-3-2:2019+A1:2021

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Place and date of issue:
Heinsberg, 11.05.2022



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