



IGM GPSR 32 Inch  
Table Edge and  
Handrail Bit



# IGM GPSR 32 Inch Table Edge and Handrail Bit Instructions

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## IGM GPSR 32 Inch Table Edge and Handrail Bit



## Specifications:

- Product: GPSR Router Bits
- Max. Recommended RPM for Router Bits:
  - Diameter 2-25 mm: 24,000 RPM
  - Diameter 25-50 mm: 18,000 RPM
  - Diameter 50-75 mm: 16,000 RPM
  - Diameter 75-90 mm: 12,000 RPM

## Product Usage Instructions

### Cleaning and Maintenance:

It is essential to clean and inspect tools after each use. We recommend using preserving and cleaning emulsion like 'FORMULA 2050' or similar. Regularly checking the tool for cracks or damage is crucial. Any issues found should be rectified before further use.

### Tool Setup:

1. Ensure the tool is properly clamped and cannot move.
2. Securely hold the tool in the spindle.
3. Ensure blades or edges do not touch each other or the clamping part.
4. Keep the tightening parts clean.

### Speed Adjustment:

The maximum RPM for each bit is specified in the tool documentation. Do not exceed the specified values to prevent damage. Observe the recommended RPM range for safe operation.

### FAQ:

- **Q: What should I do if I notice cracks or damage in the tool?**

A: Cracks or damage should be rectified immediately before further use to ensure safe operation.

- **Q: How do I determine the maximum RPM for my router bit?**

A: The maximum RPM for each router bit is etched or stamped on the bit itself or specified in the tool documentation.

- **Q: What is the consequence of exceeding the specified RPM values?**

A: Exceeding the specified RPM values can lead to dangerous damage to the tool and pose a serious risk to your health.

## General instructions for the use of tools and jigs

### ALWAYS

- When handling tools, protect your hands with work gloves, especially when disassembling tools, changing knives and cleaning or maintaining tools.
- Check the tool for cracks or damages before use.
- Wear safety goggles, ear protection and respirators if working in a dusty environment.
- Wear work shoes.
- Read the manufacturer's manual and advice before using the machine or tool.

- Keep your tools sharp and clean and store them safely to prevent damage and accidents and extend their life.

## **NEVER**

- Wear loose clothing and jewelry. They can be pulled into rotating parts of a tool or machine.
- Use dull or damaged tools.

It is absolutely necessary to clean and inspect tools after each use. For maintenance, we recommend the preserving and cleaning emulsion 'FORMULA 2050' or similar. If you check the tool regularly, you will recognize cracks or damage in good time. These must be rectified immediately before further use.

## **Make sure:**

1. That the tool is properly clamped and cannot move.
2. That the tool is securely held in the spindle.
3. That blades or edges do not touch each other or the clamping part.
4. That the tightening parts are clean.

## **For router bits**

## **ALWAYS**

- Check that at least 75% of the shank is securely inserted into the collet of the router.
- Use template guide collars when possible to absorb lateral bit deflection.
- Use a fence when working on the router table.
- Reduce the router speed when working with larger diameter bits (see table).
- Keep your fence adjusted so there is some clearance between the bearing guide and the workpiece.
- Take care to remove large quantities of stock in more than one run.

## **NEVER**

- Force the shank entirely into the collet. Leave about a 3,2 mm space from the bottom.
- Force the bit into your router or overload the router.



## **RPM**

The maximum RPM is etched or stamped on each bit or are specified in the tool documentation (operating instructions, manuals, information in the catalog). When adjusting the tool, pay attention to these speeds. Do not exceed the specified value. It is essential to observe the recommended rpm range.

Max. recommended RPM of router bits:	
Bit Diameter (mm)	Maximum RPM
D 2 – 25	24 000
D 25 – 50	18 000
D 50 – 75	16 000
D 75 – 90	12 000


### For reversible router bits

### When replacing a reversible knife on a router bit, follow the instructions below:

- Unscrew the screws with an appropriate tool (hammers or other methods are prohibited).
- Push the razor blade or, in the case of a wedge mechanism, remove the wedge and the knife. Work carefully, the edges are sharp.
- Thoroughly clean the knife, screws and, if necessary, the wedge.
- Carefully clean the bed.
- Replace or turn the reversible knife.
- Insert the knife into the groove on the correct side and position it so that the clamping holes align with the holes on the bit body. For a wedge mechanism, insert the wedge with the knife into the groove and position the knife correctly in the groove.
- Tighten the screws with a wrench with a torque of max. 15 Nm.
- Use only original screws and parts.
- Routinely check that the screws are properly tightened and that the knife is not damaged.
- In case damage should occur, replace the knife immediately.

Before using your tools or jigs, read the safety instructions for safe work! Misuse, unauthorized use of the tool or ignoring these instructions can lead to dangerous damage to the tool and serious danger to your health! IGM tools and machinery assumes no responsibility for improper use of our products.

## Documents / Resources

	<p><b><a href="#">IGM GPSR 32 Inch Table Edge and Handrail Bit</a> [pdf] Instructions</b>  GPSR 32 Inch Table Edge and Handrail Bit, 32 Inch Table Edge and Handrail Bit, Table Edge and Handrail Bit, Edge and Handrail Bit, Handrail Bit, Bit</p>
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## References

- [User Manual](#)

