

No. 541

## Rack joints with DOMINO



A

### Description

The DOMINO wood jointing system can be used easily and quickly to create rack joints frequently required by joiners and carpenters. The DOMINO combines the properties of a biscuit dowel (flexible and non-twisting) with those of a regular round dowel (can be fixed, high strength).



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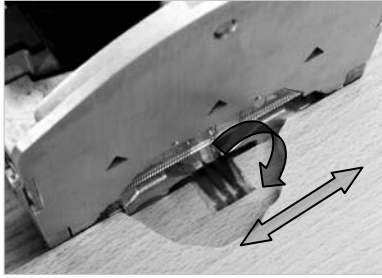


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The DOMINO wood jointing system is a unique new jointing system. It consists of the DOMINO jointer DF 500 Q developed by Festool and a loose spigot in the shape of the oval DOMINO (see Fig. 541/2).

The DOMINO is available in 6 sizes:

- 4 x 20 mm
- 6 x 40 mm
- 8 x 40 mm
- 8 x 50 mm
- 10 x 50 mm



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The routing movement of the DOMINO jointer DF 500 Q is unique among hand-held machines. The special feature is the simultaneous rotary and swinging movement of the cutter. This feature guarantees kickback-free and thus safe work (see Fig. 541/3).



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In this application example, the DOMINO wood jointing system is used to build a stool frame made of beech (see Fig. 541/4).

DOMINOs of size 5 x 30 mm and 8 x 40 mm are used.



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## B

### Tools/accessories

Basic equipment:

Denomination	Order no.
DOMINO jointer DF 500 Q GB 240V (see Fig. 541/5)	574 256
DOMINO 5x30 mm	493 296
DOMINO 8x40 mm	493 298
DOMINO cutter D 5 mm	493 490
DOMINO cutter D 8 mm	493 492
DOMINO trim stop LA-DF 500 (see Fig. 541/6)	493 487

The following Festool accessories can help you make a frame joint:

Multifunction table MFT 1080	490 888
Clamps MFT-SP	488 030
Suction hose plug it D 27	456 746

CTM series mobile dust extractor



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Changing cutters:

Selection and assembly of the necessary cutter:

In our example, cutter diameters of 5 mm and 8 mm are used.

Important: Prior to changing the tool, the Plug it cable must be removed from the machine!

1. Raise the release lever until the machine disengages using the size 8 open-ended spanner provided for this purpose (see Fig. 541/9).
2. Disconnect the motor unit from the guide frame (see Fig. 541/10).
3. Hold in the spindle lock (see Fig. 541/9, red arrow) and use the size 8 open-ended spanner to screw the cutter onto the cutter spindle and tighten it.
4. Release the spindle lock.
5. Slide on guide frame and motor unit until they audibly engage.
6. Connect the Plug it cable and extractor hose.



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Adjusting dowel hole width:

At the DOMINO jointer, the dowel hole width can be adjusted easily (see Fig. 541/11).

With a frame joint, the elongated hole is cut to fit the DOMINO exactly. As with a round dowel, alignment to the front edge is exact.

Additional DOMINO holes can be routed with the next larger hole width. The DOMINOs then have play in the cut.

The hole width can be set with the rotary switch while the machine is running!

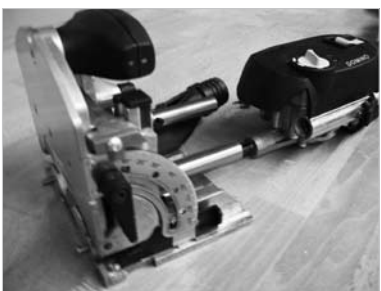
DOMINO hole widths:

Setting 1: 14 mm plus cutter diameter

Setting 2: 20 mm plus cutter diameter

Setting 3: 24 mm plus cutter diameter

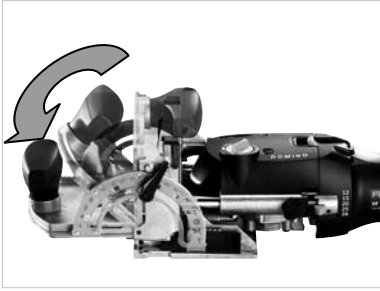
The D6 cutter and setting 1 for the DOMINO hole width (see Fig. 541/11) are used to create an elongated hole with a width of 20 mm; setting 2 then produces a displacement path of 4 mm.



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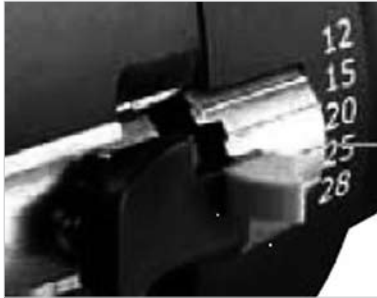
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## C Preparation/set-up

Set the router table to 90° (see Fig. 541/12).



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Set the routing depth of the dowel length accordingly (see Fig. 541/13).

DOMINOs of size 5 x 30 mm and 8 x 40 mm are used in the example.

Set the routing depth to 20 mm (corresponds to half of the dowel length 8 x 40 mm).



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Set the routing height at the quick selection to correspond to the material thickness (see Fig. 541/14).

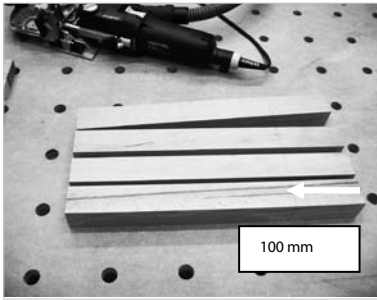


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## E Procedure

The parts are arranged in the pairs in which they are subsequently assembled.

Tip: Making a mark (joiner's triangle, see Fig. 542/15) helps to find the place for routing.



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The position of the support height is marked out on the stool legs (see Fig. 541/16). In the example, the lower supports are 100 mm high; the upper support is attached via the stop pins (see Fig. 541/18) of the DOMINO jointer.

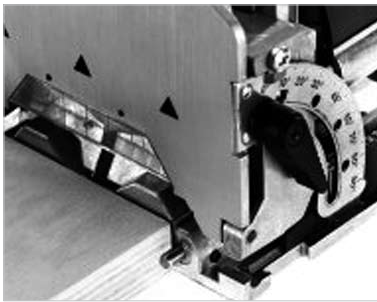


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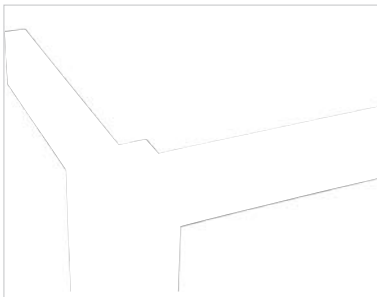
The stool leg is attached securely with clamping elements on the multifunction table (see Fig. 541/17).

Select setting 1 for the dowel hole size (see Fig. 541/11).

Position the DOMINO jointer DF 500 Q with the help of the stop pins and cut the first DOMINO hole (see Fig. 541/17).



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With the help of the trim stop, the DOMINOs are cut on the face centrally into the supports (see Fig. 541/19).



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General:

The trim stop (see Fig. 541/20) can be used for fast and easy face-side processing of narrow strips. Simply set the trim stop to the strip width to do this. Then you can cut the strips quickly and easily. The trim stop is particularly useful when you have to cut several identical strips.

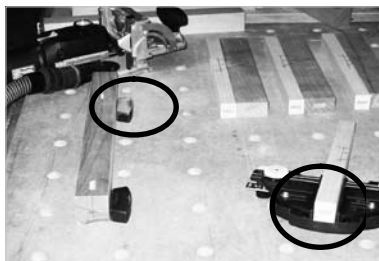


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In the example of the stool frame, the DOMINO 8 x 40 mm is used in the upper support and the DOMINO 5 x 30 mm in the lower narrower support.

Position the supports securely on the multifunction table with the clamping elements (see Fig. 541/21) and then cut with the DOMINO cutter 8 mm.

Select setting 1 for the dowel hole size.



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When all DOMINO holes have been routed, the DOMINO cutter 5 mm must be installed.

After the cutter change, the DOMINO holes are cut in the stool legs and the lower supports with the DOMINO cutter 5 mm (see Fig. 541/22) as described above.

When all parts have been cut, the stool frame is joined together and glued (see Fig. 541/23).



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The DOMINO Assortment Systainer contains a clear arrangement of all DOMINO sizes (see Fig. 541/24).



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Detailed information on the DOMINO joining system is also available on CD-ROM.

**FESTOOL**

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