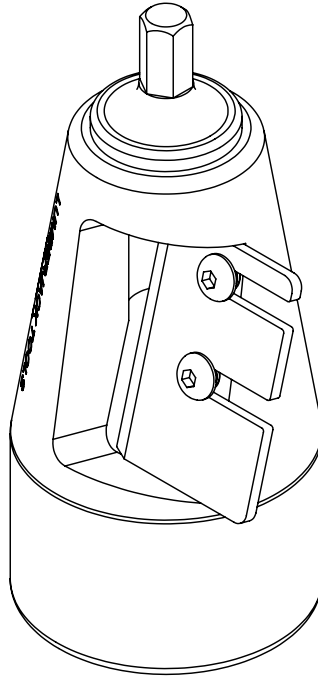


# LUMBERJACK TOOLS™

usa made tenon cutters



## USER MANUAL STAKING TOOL (30° Shoulder Profile)

Due to continuing improvements, actual product may differ slightly from the product described herein.

Lumberjack Tools Inc.  
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Phone: 715-720-4719  
Rev: 02/19



MODEL: ST2000

## About Your Product

Thank you for purchasing our 30° Staking Tool!

The dual-bladed stake tool will cut a 30° point on a log or square timber in seconds. The body of the tool is CNC machined from a solid aluminum billet to ensure each cut is precise. The blades are stamped, heat treated and ground to provide years of service if properly maintained.



Our lifetime guarantee covers the tool body and shank. The blades are covered for 90 days from the date of purchase for breakage under normal working conditions. Blades will dull faster cutting hardwoods vs softwoods (peeled or unpeeled). Soil and other abrasive substances will reduce blade life and is not covered under this warranty. When making a claim, you must show proof of purchase from an authorized distributor. This is valid only to the original buyer, and not for tools sold secondhand, used, or sold “as is” to a second party.

### What Voids Warranty

In order to keep our lifetime and 90 day warranty you must **AVOID** the following actions:

- Operating the tool in a drill press or lathe (or any system other than a hand-held drill)
- Running the tool into a nail or foreign object
- Altering or misusing the tool

# SAFETY

Before beginning any project, carefully read and follow ALL safety and operational instructions for any tools or devices you will be using. Failure to do so may cause physical harm to yourself or those around you. If you feel uncomfortable using our staking tool, STOP immediately. Lumberjack Tools assumes no responsibility for injury caused to the operator, bystander, or tools used in conjunction with the use or misuse of our tools.



NEVER OPERATE POWER TOOLS UNDER THE INFLUENCE OF DRUGS, ALCOHOL, OR ANY MEDICATIONS



ALWAYS WEAR SAFETY GLASSES, DUST MASK, AND ANY OTHER PERSONAL PROTECTION ITEMS AS NEEDED



NEVER WEAR LOOSE ITEMS THAT COULD BE CAUGHT IN MOVING PARTS. SECURE LOOSE OR LONG HAIR AWAY FROM AREA



WE STRONGLY RECOMMEND A SINGLE-SPEED, GEAR DRIVEN DRILL WITH RPMS OF 500 OR LESS. EXCEEDING THESE RPMS MAY RESULT IN DAMAGE TO THE TOOL



ALWAYS DISCONNECT POWER AND ALLOW DRILL TO COME TO A COMPLETE STOP BEFORE INSTALLING, REMOVING, OR ADJUSTING THE TOOL



NEVER APPLY BENDING FORCE (SIDE LOADING) TO THE TOOL. SIDE LOADING COULD CAUSE THE SHANK TO FAIL, OR MAY RESULT IN BLADE DAMAGE



ALWAYS SECURE THE LOG IN A VISE OR CLAMP PRIOR TO STARTING YOUR DRILL. FAILURE TO DO SO MAY RESULT IN INJURY



ALWAYS HANDLE THE BLADES WITH EXTREME CARE! FAILURE TO DO SO MAY RESULT IN SERIOUS INJURY

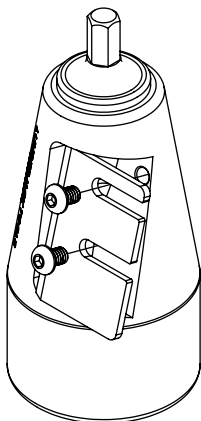


NEVER PUT HANDS OR ANY BODY PART INSIDE THE TOOL WHILE THE BLADES ARE ATTACHED! DOING SO MAY CAUSE SERIOUS INJURY



WHEN EXCESSIVE FORCE IS REQUIRED TO CUT, RE-SHARPEN OR REPLACE THE BLADES. A SHARP TOOL IS A SAFE TOOL!

## Setting the Blades



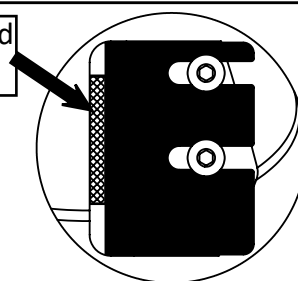
Max	Capacity
Round	2.00" DIA
Square	1.50" x 1.50"

- CAUTION, keep the blade offset of both blades equal (see below)
- Install and secure the blades with the Button Head Cap Screws

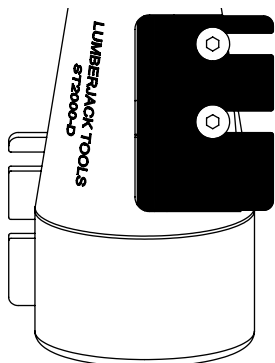
### TIP

- The cardboard box that the tool comes in is about 1/8"
- Remove a piece of box to use as a quick spacer for blade gap setting

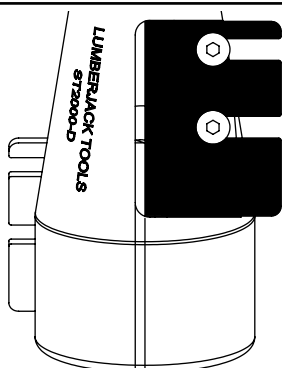
Cardboard Spacer



## Blade Offset

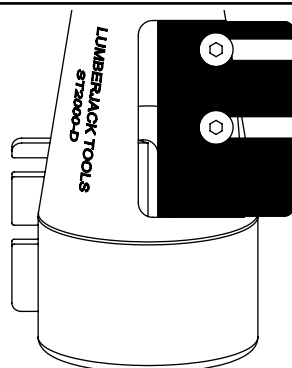


**WRONG** (too close)



1/8" -

**Correct**



**WRONG** (too far)

To cut a stake that comes to a point the blade offset has to be at 1/8". If the blades are set too close the tool will not cut. If the blades are set too far the tool may cut but the stake will not have a point.



## Would you like to cut smoother stakes?

Included with your tool are the TB2500 Blade Shims.

### Pros of using shims

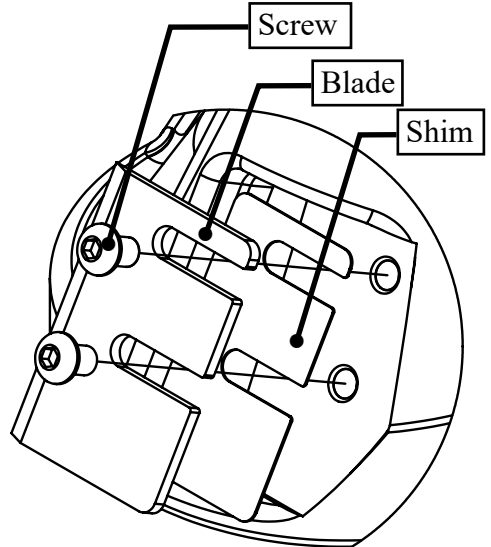
- Smoother stake
- Reduced drill torque
- Less aggressive blade bite

### Cons of using shims

- Increased time to cut

### Installing Shims

- Place a shim underneath a TB2500 blade and secure both with screws as shown
- The shim should **NOT** extend into cutting area or cover the sharp edge of the blade
- If installed properly the right edge of the shim will be flush with the right edge of the blade (the non-cutting edge)



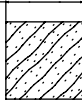
# Cutting Stakes



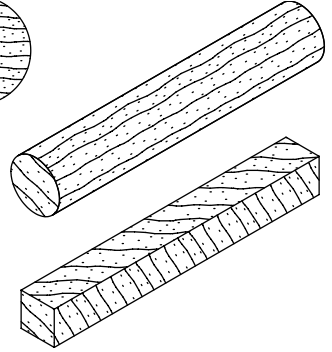
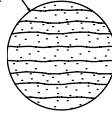
**WARNING:** If the stock comes loose or unclamped while cutting the stake, **DO NOT** drop the drill or try to grab the stock! Stop the drill and remove it from the end of the log. Re-secure the log, and resume

1

1-1/2" Max  
Square

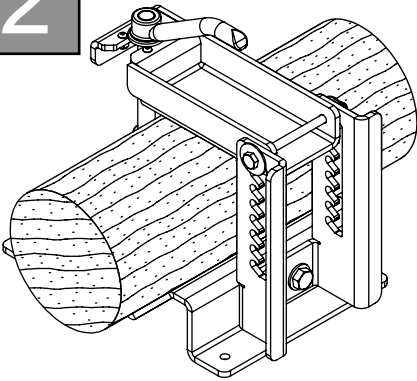


2" Max  
Round



- Obtain the stock you want to point
- Make sure the diameter fits the tool
- Cut it to length and make sure the ends are flat. If the ends are not even/flat, the point will be crooked

2

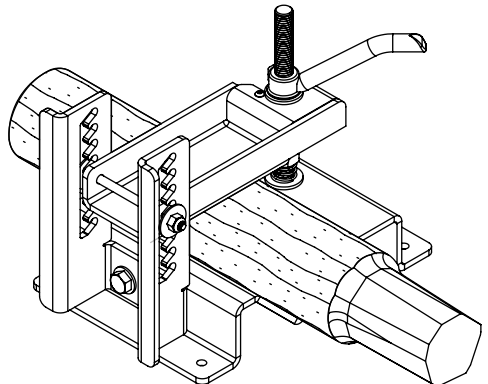


Max	Capacity
Round	2.00" DIA
Square	1.50" x 1.50"

- Secure the stock in a vise, clamp, or fixture with a "V" shaped notch
- The **Log Lock (LL1545)** is a safe, easy, economical way to clamp material, and is available on our website

3

- If the diameter is larger than the tool can accept, taper the end with a hatchet or draw knife



## Cutting Stakes (cont.)

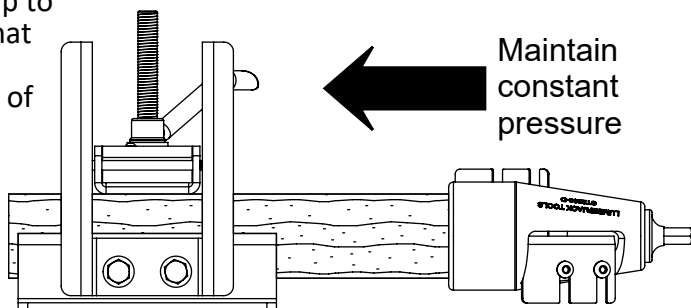


**ALWAYS** unplug the drill before adjusting the blades or adjusting the chuck

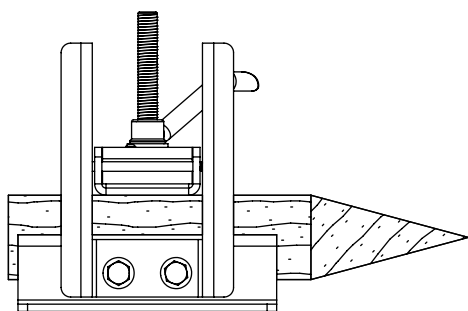
**4**

- Carefully install the staking tool into an unplugged 1/2" drill, and tighten it firmly. Use the chuck key to tighten the chuck

- With the tool installed, square up to the log/stock so that the cutting face is flush with the end of the log/stock

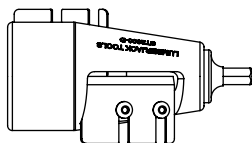


- Apply body pressure by leaning against the back of the drill



- Pull the trigger to cut a stake. Continue applying body pressure as the tool cuts

Pull back once drill has stopped



- Wait until the drill comes to a complete stop before removing the cutter from the log/stock

### TIP

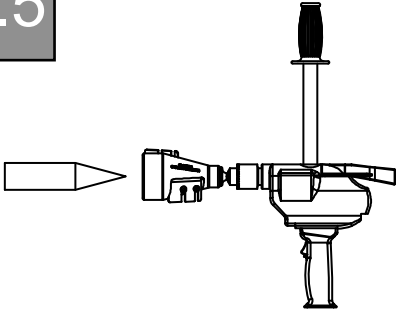
- The staking tool will continue to cut even after the log is pointed
- Stop the drill immediately after the point is cut to avoid wasting material

## Cutting Stakes (cont.)



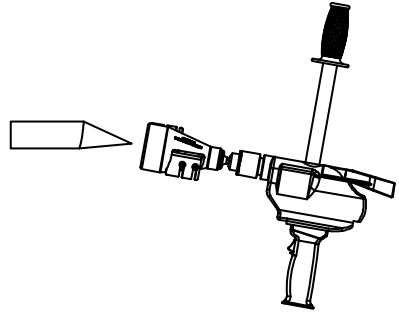
- Make sure the tool is square against the end of the log before cutting
- If the tool is held at an angle the stake will be cut angled

4.5



**CORRECT**

Drill in-line with stock

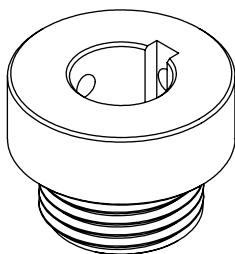
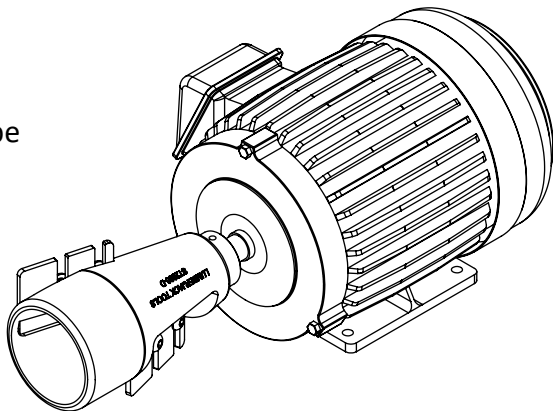


**WRONG**

Drill not in-line with stock (crooked)

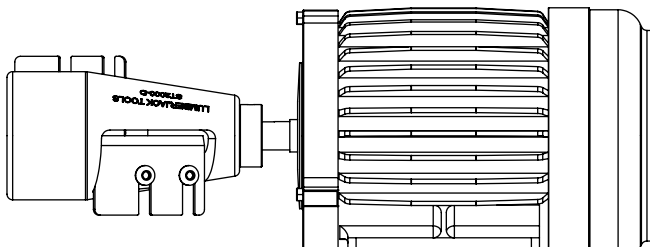
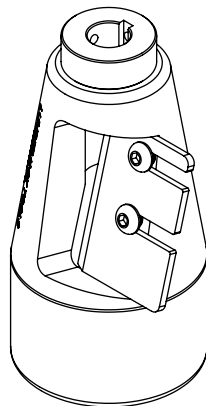
# Motor Mount Adapter

- If desired the ST2000 can be mounted to a motor for production stake cutting



- We offer an adapter that allows the tool to fit over a motor shaft. The Motor Shaft Adapter is available for purchase on our website or by phone

- Remove the shank that comes pre-installed to the tool by using a pipe wrench
- Screw the adapter into the tool where the shank was removed
- Slide the tool with the adapter over the motor shaft and secure in place by tightening the set screws
- **NEVER** exceed more than 1750 RPM when operating the tool
- If you have any questions or would like to know more information customer service is always glad to help!



# Maintenance

## ● Body

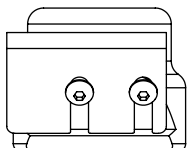
- Cleaning
  - Keep the staking tool body clear of sap and other build-up
  - Always remove the blades before cleaning
  - Clean the tool with a solvent (such as mineral spirits)



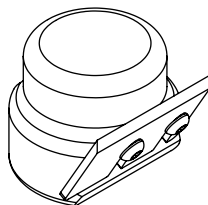
**WARNING: ALWAYS HANDLE THE BLADES WITH EXTREME CARE! FAILURE TO DO SO MAY RESULT IN SERIOUS INJURY**

## ● Blades

- Care
  - Always wipe blades with a thin film of oil at the end of the day to help prevent oxidation
- Cleaning
  - Clean the blades with a solvent (such as mineral spirits) and **immediately** apply a thin film of oil to prevent oxidation
- Sharpening
  - Use a sharpening stone, file or the **Blade Boss** (BB2575) to re-sharpen the blades, then clean the blades and apply a thin film of oil



*Visit our website or call  
for more information  
about our Blade Boss*



## ● Shank

- Replacement
  - If your shank breaks, we offer replacement shanks (see first page for contact information)
  - Turn the shank counter-clockwise to remove
  - Turn the shank clockwise to install

TASK	EACH USE
Clean blade pockets	X
Clean cutter bore	X
Clean blades	X
Inspect blades	X
Oil blades	X

# Troubleshooting

PROBLEM	CAUSE	SOLUTION
<ul style="list-style-type: none"> <li>• Tool Skips off to one side or bounces around</li> </ul>	<ul style="list-style-type: none"> <li>• Stock is larger than tool will accept</li> </ul>	<ul style="list-style-type: none"> <li>• Taper down the end of the stock with a draw knife</li> </ul>
	<ul style="list-style-type: none"> <li>• Not enough pressure is being applied</li> </ul>	<ul style="list-style-type: none"> <li>• Lean into drill with body</li> </ul>
<ul style="list-style-type: none"> <li>• Not cutting stock</li> </ul>	<ul style="list-style-type: none"> <li>• Stock is larger than tool will accept</li> </ul>	<ul style="list-style-type: none"> <li>• Taper down the end of the log with a draw knife</li> </ul>
	<ul style="list-style-type: none"> <li>• Blades are slid too close</li> </ul>	<ul style="list-style-type: none"> <li>• Position blades so they are back no closer than 1/8"</li> </ul>
	<ul style="list-style-type: none"> <li>• Blades are dull</li> </ul>	<ul style="list-style-type: none"> <li>• Sharpen blades</li> <li>• Purchase new blades</li> </ul>
	<ul style="list-style-type: none"> <li>• Not applying enough pressure</li> </ul>	<ul style="list-style-type: none"> <li>• Lean into drill with body</li> </ul>
<ul style="list-style-type: none"> <li>• Takes too much of a "bite"</li> </ul>	<ul style="list-style-type: none"> <li>• Aggressive cutting from dual blades</li> </ul>	<ul style="list-style-type: none"> <li>• Use the TB2500 Blade Shims</li> </ul>
<ul style="list-style-type: none"> <li>• Crooked Stake</li> </ul>	<ul style="list-style-type: none"> <li>• Holding drill crooked while cutting</li> </ul>	<ul style="list-style-type: none"> <li>• Position the drill square against the stock before cutting</li> </ul>
<ul style="list-style-type: none"> <li>• Drill stops or cuts on small diameter stock but not larger</li> </ul>	<ul style="list-style-type: none"> <li>• Using a variable speed drill</li> </ul>	<ul style="list-style-type: none"> <li>• Make sure you are using a single-speed drill with low RPMs</li> </ul>
	<ul style="list-style-type: none"> <li>• Using a non-Milwaukee brand drill</li> </ul>	<ul style="list-style-type: none"> <li>• We recommend purchasing a Milwaukee brand hole hog drill</li> </ul>
<ul style="list-style-type: none"> <li>• Spiral grooves on Stake</li> </ul>	<ul style="list-style-type: none"> <li>• Lateral wobbling of the drill</li> </ul>	<ul style="list-style-type: none"> <li>• Hold the drill as steady as you can while cutting</li> </ul>
	<ul style="list-style-type: none"> <li>• Removing the cutter while drill is still spinning</li> </ul>	<ul style="list-style-type: none"> <li>• DO NOT remove the cutter until the drill has come to a complete stop</li> </ul>

## **Unexpected Occurrences**

Engineers and Quality Control staff at Lumberjack Tools have provided you with one of the easiest to use and safest staking tools on the market. However, there is always the unexpected chance of failure.

- Please contact our customer support for a replacement if a failure ever occurs to the tool body, shank or blades

**Thank you again for purchasing our tools!**