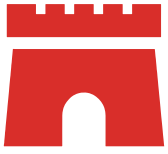




Production pocket joinery... for *ANY* shop.

Castle USA



Castle USA

About Us

We develop products that support woodworking shops of all sizes in their efforts to be productive and successful. We use local vendors wherever possible and as an American machinery manufacturer, Castle champions the cause of the American entrepreneurial woodworker.

It all started when founder Max Durney, then a partner at an architectural millwork firm, was trying to find an assembly solution for store fixtures he was shipping overseas. Max wanted to produce fixtures that could be shipped flat, site-assembled, and which would have strong, stable joints when put together. Max solved his dilemma by inventing a machine which could create a 6 degree pilot hole with a routed pocket in a fast, efficient, two-step process. This new method included machining a pocket using a router, drilling a pilot hole from the opposite side, and then fastening the parts with screws through the pocket into the adjoining part.

Many years and numerous patents later, Max's solution is still known today, industry-wide, as the "Castle low-angle pocket."

At Castle, our dedication to quality, service, and support is evidenced in our products and in our loyal customer base. We strive to always deliver value to our customers, market partners, suppliers, and employees.

Why Castle?

Castle stands alone as the American manufacturer who pioneered pocket cutting technology and machinery – we've been making pocket cutting machines since 1985 and we were awarded the very first patent in the industry. And, as the result of Castle's continued product innovations and improvements, many additional patents have been awarded to us for our expanded range of pocket cutters and for our latest machine, the CSI 1.5D Pocket Cutter/Screw Inserter.

We make and assemble everything in Petaluma, California, and our products are manufactured to the highest standards. We also manufacture world-class assembly tables, accessories, and tooling.

Our products are virtually unsurpassed when it comes to service life, durability, ease of maintenance and simplicity in user training. Just about anyone can master any of our machines with minimal training. We are committed to our customers, dealers, and machine operators, and take pride in our friendly and effective customer service. We are pleased to have contributed to the ever-growing use of pocket joinery.

The Castle, Low-Angle Pocket

- Castle pockets are routed and leave a clean slot without the tear-out typical of drilled (high-angle) pockets
- The 6 degree pilot hole is drilled from the edge of the material, clear through to the pocket, and its low-angle reduces joint shift, creating a more stable joint
- Drilling the pilot hole from the edge of the material into the pocket eliminates material from getting trapped in the joint preventing good joint tightness.



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Castle Education Program



Castle is proud to support woodworking education. In today's challenging labor market, it's more important than ever for us and others to invest in developing talent and to recognize woodworking excellence.

The first part of our **Education Program** is our ongoing, 15% product discount. We offer this to qualified/accredited educational institutions and programs.

We're also excited to announce our new **"What's Your Angle?" woodworking competition**, which will debut in 2022.

What's Your Angle?

Castle's 2022 Competition for Woodworking Education Students and Programs
Showcase your woodworking talents and craftsmanship and submit your Woodworking Project for a chance to WIN:

Grand Prize*Individual Entry: Castle 110 Pocket Cutter. This will be awarded to the student, whether in high school or in a secondary educational woodworking or vocational program, who submits the winning entry.

Grand Prize*High School Program/Class: TSM-12 Pocket Cutting Machine. This will be awarded to the high school program or class who submits the winning entry.

Grand Prize*Secondary School or Vo-tech Program/Class: TSM-22 Pocket Cutting Machine. This will be awarded to the secondary educational woodworking or vocational program or class who submits the winning entry.

Go to <https://castleusa.com/pages/resources/education-program.html> for complete details.

What's Your Angle?

Entry Deadline:

11:59 PM
November 1, 2022

Winners:

Will be announced
December 15, 2022



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CSI 1.5D

Pocket Cutter/ Screw Inserter Machine

With the patented Screw-In-Pocket (SIP) technology, CSI-1.5D cuts Castle's distinctive, low-angle screw pocket, drills a low-angle pilot hole and inserts a screw - all in 1.5 seconds.

Castle's CSI-1.5D Pocket Cutter/Screw Inserter Pocket cuts pockets and inserts screws in one step: pockets with screws, delivered! Our patented technology reduces assembly time by 50%. The CSI-1.5D produces stackable parts in faster production times, reduces waste, and eliminates non-value-added labor in high-capacity production joinery.

Use the CSI-1.5D with composites, panel and hard or soft wood.

*Ask us about our new CSI program, "Try It First", where you can use the CSI 1.5D for two months without having to pay for the machine! Yes, we're that confident you will love what the CSI does for your bottom line. Contact us today to learn more: sales@castleusa.com

For best results with the CSI, modified pan head screws are recommended.

FEATURES AND BENEFITS INCLUDE:

- Pocket cutter and screw inserter in one step - patented technology reduces assembly time by 50%
- Cuts the Castle low-angle pocket, for strong, stable, tight, and superior joints
- Cuts pockets and inserts screws in 1.5 seconds, eliminating non-value-adding labor
- Designed for high-capacity, continuous production joinery for maximum throughput of stackable parts
- Manufactured in the USA
- Low-angle pockets minimize the need for clamping during assembly
- Footswitch with automated operation is simple and easy to use
- CSI-1.5D comes ready to work for fast integration
- Customizable work decks and flip stops for efficient and accurate material alignment
- Air table option - perfect for panel and large part production
- Hi-Lo Plate option - for easily handling dado material

U.S. Patent #6,877,536 | Canadian Patent #2,456,044



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CSI 1.5D (continued)

Castle's CSI-1.5D Pocket Cutter/Screw Inserter has a super heavy-duty, robust build. It is designed for continuous production, requiring simple, routine maintenance so that down time is minimized.

Detailed Benefits & Design Features:

- 1.5 second, single operation pocket cutting and screw insertion
- Inserted Screws are below flush – parts can be stacked without marring
- Works with 1-1/4" or 1-1/2" pocket screws Shop Castle screws
- "Pocket Detect" sensing prevents loaded-pocket cutting errors
- Easy access to carriages for quick tooling changes (Part C55850 - CSI Universal Screw Tube Plate)
- Adjustable router feed rate optimizes quality and cycle time for various materials
- Includes premium, solid carbide router bit, drill bit, and dust collection port

Also Available:

- Optional air table specifically designed for the CSI 1.5D, for panel/large part processing; runs on 230V or 460V 3 phase, and extends the work surface on either side to 59"
- Customizable work decks and work stops for efficient and accurate material alignment

Key Components*:

- Siemens LOGO! PLC controls
- LCD status display with cycle counter
- Variable frequency drive
- Teknomotor .44HP 220/380V 18000 RPM drill spindle
- Teknomotor 2.7 HP 230V or 460V 18000 RPM router spindle
- Castle screw delivery system w/vibratory feeder bowl level sensor
- Heavy duty, Parker Viking Xtreme Series valves w/manual override

Technical Specifications:

- Electrical: 230V or 460V
- Air: 85 psi with minimum 3/8" ID supply line
- Dust collection: 4" duct port
- REQ CFM: 350 CFM with 4" dust collection
- Footprint: 35" x 33" (35" x 63" including Screw Feeder)
- Working Height: 36"
- Machine Height: 72"
- Worktop Area: 33" x 35"
- Shipping Weight: 1085 LBS.
- Manufactured in the USA

**Actual brands and models are dependent on 3rd party suppliers.*





Castle USA

TSM-30 Series Pocket Cutter Machines

Designed for continuous production in cabinet manufacturing, furniture plants, mobile home factories, and more. The TSM-30 Series Pocket Cutters are available in three different voltage options: 220V Single Phase, 230V Three Phase, and 460V Three Phase. Each cuts the patented, six-degree, Castle low-angle pocket. TSM-30s are extremely well-suited for multi-shift production in a broad variety of woodworking manufacturing environments.

Heavy duty induction motors drive the pocket cutting spindle: the TSM-31 uses a 220V, single phase induction motor and the TSM-35 models use three phase induction motors in either 230V or 460V. All models use a high-torque, heavy-duty air motor - specifically designed for Castle - to drive the pilot bit. Both operations - pocket cutting and pilot hole drilling - are completed in a single cycle.

TSM-30 series feature heavy duty construction throughout, with easy, top-down access for quick tooling changes. Adjustable indexing stops are built into the top for quick part transitions during high production shifts. These premier woodworking shop tools can produce more than a quarter million pockets per month for years on end with minimal maintenance.



FEATURES AND BENEFITS INCLUDE:

- Cuts the Castle low-angle pocket, for strong, stable, tight, and superior joints – even in ½" material!
- Designed for high-capacity, continuous production joinery for maximum throughput of parts and components
- Low-angle pockets minimize the need for clamping during assembly
- Cuts pocket and pilot hole in a single cycle, increasing throughput and decreasing material damage and waste
- Standard machine height with a small footprint - easy to fit into any production line
- Easy maintenance and bit changing
- Minimal shop air required: 85 psi
- Footswitch with automated operation that's simple and easy to use
- TSM-30 series machines quickly integrate into any existing manufacturing process or workflow



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Technical Specifications:

- Motor: 1.5hp Baldor Router Motor (TSM-31 220V), 1hp Leeson Router Motor (TSM-35 230V and TSM-35 460V)
- Drill: Sioux SDG10S25FCT Air Motor
- Router bit: Premium 3/8" Solid Carbide, Rough Mill
- Drill bit: Premium 9/64" Brad and Spur TiN-Coated Bit
- Power Options: 220V Single Phase; 230V Three Phase; 460V Three Phase
- Air req: 85 psi—external regulator, filter and lubricator included
- Basic footprint: 21" depth x 19" width
- Working height: 36.5"
- Worktop usable area: 16" depth x 18.5" width
- Machine height: 38"
- Shipping weight: Approx. 340 lbs
- Shipping dimensions: 22" x 28" x 52"
- Manufactured in USA





Castle USA



TSM-22 Pocket Cutter Machine

The TSM-22 is our latest model in the TSM-20 series, the most widely used, and best-selling pocket cutting machine series ever made. Known for its durability, ease of operation and low maintenance, the TSM-22 is a clear favorite among professionals in cabinet making, furniture making, and woodworking.

The TSM-22 clamps the stock, routs a pocket, and drills a pilot hole with a tap of the foot pedal, all in about 1.5 to 2 seconds per cycle.

With the TSM-22, creating strong, stable joints is fast and easy. Requiring minimal training and maintenance, the TSM-22 uses standard 110V electric, and only requires minimal set-up upon delivery.

Use the TSM-22 with composites, panel, hard or soft wood.

FEATURES AND BENEFITS INCLUDE:

- Cuts the Castle low-angle pocket, for strong, stable, tight, and superior joints
- Designed for professional, joinery with maximum throughput of parts and components
- Low-angle pockets minimize the need for clamping during assembly
- Cuts pocket and pilot hole in a single cycle, increasing throughput and decreasing material damage and waste
- Footswitch with automated operation that's simple and easy to use
- Adjustable for different sized webs
- Standard machine height with a small footprint - easy to fit into any shop
- Lid lifts for fast and easy tool changes and maintenance
- Minimal shop air required: 85 psi
- Integrated, 4" dust port for minimizing dust and debris
- Requires only basic, 110V power
- TSM-22 requires minimal assembly, for quick integration into any existing production process or work-flow



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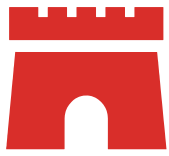
TSM-22 Pocket Cutter Machine *(continued)*

Technical Specifications*:

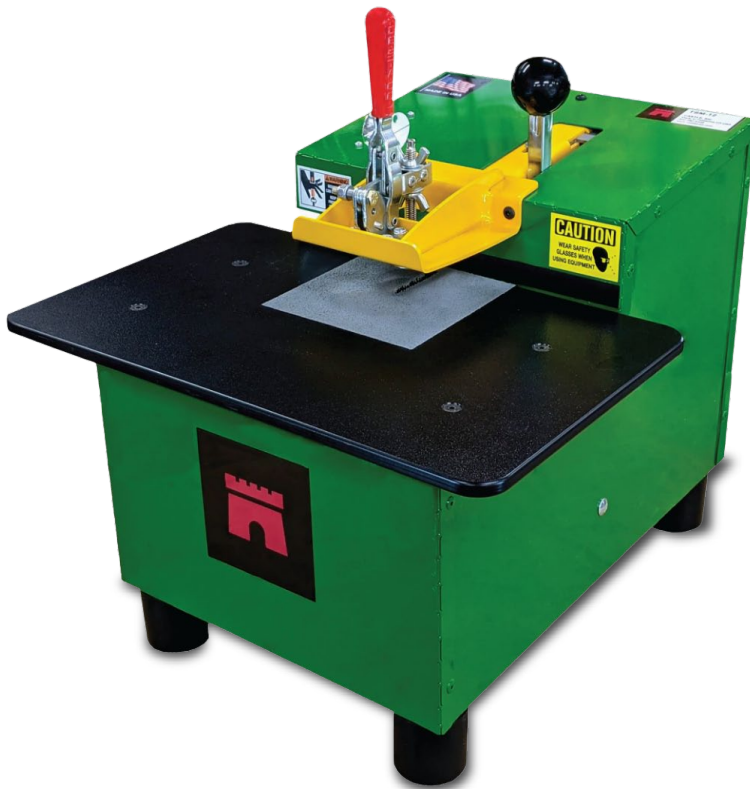
- Router: Bosch 2.0hp #1617
- Drill: Bosch Colt 1.0hp #PR20EVS
- Router bit: Premium 3/8" Solid Carbide, Rough Mill
- Drill bit: Premium 9/64" Brad and Spur TiN-Coated Bit
- Power req: 110V, 15 amps
- Air req: 85 psi
- Bosch 1617 Router 2hp for pocket cutting
- Bosch Colt Router 1hp for drilling pilot hole
- Basic footprint: 31.5" depth x 30" width x 48" high
- Working height: 36.5"
- 4" integrated dust port
- Manufactured in USA

**Actual brands and models are dependent on 3rd party suppliers.*





Castle USA



TSM-12 Pocket Cutter Machine

The TSM-12 benchtop pocket cutter machine is designed very similarly to Castle's original pocket cutter. These machines have an amazingly long service life, and on the rare occasion when one becomes available in the used tool market, it tends to sell quickly and at a price that's close to the current MSRP. The TSM-12 routs the 6 degree, low-angle Castle Pocket with no tear out in less than 2 seconds. The superior low screw angle minimizes joint shift while providing strong, stable joints.

The TSM-12 uses standard 110V electric, and does not require any shop air, so it's ideal for jobsites, small shops, or the weekend woodworker. Each TSM-12 is equipped with a Bosch 1617 Router with a 3/8" three-flute solid carbide router bit for cutting the pocket and a Bosch Colt Router with a 9/64" premium drill bit for drilling the pilot hole. The TSM-12 requires minimal set-up, so you'll quickly be creating Castle quality with every pocket you cut.

FEATURES AND BENEFITS INCLUDE:

- Cuts the Castle low-angle pocket, for strong, stable, tight, and superior joints
- Equipped with:
 - Bosch 1617 Router with a 3/8" three-flute solid carbide router bit for cutting the pocket
 - Bosch Colt Router with a 9/64" premium drill bit for drilling the pilot hole
- Low-angle pockets minimize the need for clamping during assembly
- Wider throat opening for thicker stock – accommodates stock from 1/2" to 1-1/2" thick
- Adjustable web for handling various pocket screw lengths
- Integral work clamp and pocket cutting lever are ergonomically positioned for fast pocket cutting
- Two, integrated dust port knockouts for Shop Vac or 4" hose sizes
- Easy maintenance and bit changing
- Requires only basic, 110V power
- Durable, solid surface work top
- TSM-12 comes factory tested with minimal set-up required



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TSM-12 Pocket Cutter Machine *(continued)*

Technical Specifications:

- Router: Bosch 2.0hp #1617 Router Motor
- Drill: Bosch Colt 1.0hp #PR20EVS
- Router Bit: Premium 3/8" Solid Carbide, Rough Mill
- Drill bit: Premium 9/64" Brad and Spur TiN-Coated Bit
- Power req: 110V, 15 amps
- Shipping weight: 65 lbs
- Footprint: 13.5W x 20L x 20H

**Actual brands and models are dependent on 3rd party suppliers.*





110 Pocket Cutter Machine

Create Castle low-angle, professional pockets in seconds with the Castle 110 Pocket Cutter. The 110 cuts our exclusive low-angle pocket, makes fast, strong, and attractive joints for cabinets, bookcases, face frames and other woodworking projects, and minimizes the joint misalignment common with a drilled pocket.

Since the screw's pilot hole is drilled from the opposite side, there is no accumulation of waste or tear out, allowing joined pieces to fit as tightly as possible.

FEATURES AND BENEFITS INCLUDE:

- 3 Degree Pocket minimizes joint shift
- Stronger joints and faster assembly
- Portable and adjustable, 120V
- Super clean pockets
- Factory assembled and adjusted. No additional setup required.
- Designed and assembled in the USA from US and global components.
- The Castle 110 is our update to the Castle 100, which is no longer in production.





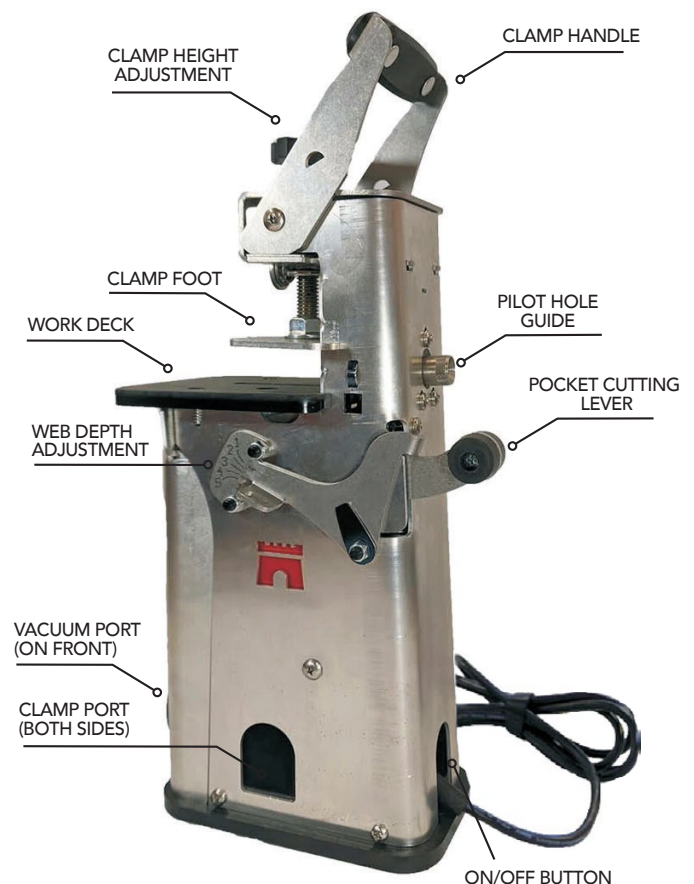
110 Pocket Cutter Machine (continued)

Base Model Includes:

- Operator Manual with Warranty Activation Card
- Overlay plate for quickly machining thinner materials (Part C11001)
- Bit Set-up Block with integrated bit height gauge (Part C11010)
- Collet Wrenches (Part K11000)
- T20 Torx driver bit, 6" round shaft (Part B00620)
- Smooth Router Bit (Part B02516) [installed and factory adjusted]
- Extra long (4.5") 5/32" drill bit for pilot hole (Part B06532)
- Box of 250 count, 1-1/2" Torx Hi-Low pocket screw (Part B04112-0250)
- Box of 250 count, 1-1/4" Torx Hi-Low pocket screw (Part B04114-0250)
- Work Stop Set, includes stop bar, left and right work stops (Part C11060)

The Professional Bundle includes the Base Model along with the following:

- 1 extra Smooth Router Bit (Part B02516)
- 1 8mm Rougher Bit for the Castle 110 (Part B02517)
- 1 extra T20 Torx driver bit, 6" round shaft (Part B00620)
- 1 extra box of 250 count, 1-1/2" Torx Hi-Low pocket screw (Part B04112-0250)
- 1 extra box of 250 count, 1-1/4" Torx Hi-Low pocket screw (Part B04114-0250)
- Castle Face Clamp (Part B40005)
- Castle Tight Access Driver (Part K10020)





AT-Race 4' x 8' Face Frame Assembly Table

Our Face Frame Assembly Table clamping arm glides smoothly on an open beam that allows larger face frames to extend beyond the top of the table. The redesigned quick-clamps feature dual handles and centered activation for easy clamping from either direction. The rigid steel arm, constructed out of Unistrut, will stand up to years of use, while the open back table gives you more work area and can handle oversize frames without taking up valuable shop space.

When you are in need of premier woodworking tools and supplies, turn to Castle USA. We pride ourselves on providing our customers with the absolute best and highest quality woodworking supplies.

FEATURES AND BENEFITS INCLUDE:

- Professional woodworking assembly table
- Open back design:
 - Accepts oversized frames and other large assemblies
 - Maximizes work area
- Unistrut clamping arms with three adjustable air cylinders hold work firmly for easy assembly and minimal sanding
- 45 Degree, 1" laminated top for easy glue clean-up and less operator fatigue than horizontal clamping tables
- Built-in driver holster keeps driver within easy reach for increased convenience and efficiency (driver sold separately)
- Convenient, integrated connection port for air powered driver adjacent to driver holster
- Rigid and lightweight for easier handling and positioning

TECHNICAL SPECIFICATIONS:

- Unistrut rigid steel arm with redesigned quick-clamps
- Driver sold separately
- Assembly required
- Footprint: 113" x 43" x 79"
- Manufactured in the USA





AT-Race 4' x 12' Face Frame Assembly Table

The AT Race 4' x 12' Open-Back Face Frame Assembly Table features clamping arms that glide smoothly on an open beam. This allows assembly of larger face frames or other components with parts that extend beyond the top of the table. The redesigned quick-clamps feature place-and-stay movement – no need to lock them into place – and centered activation for easy clamping from either direction. The rigid steel arms, constructed out of Unistrut, will stand up to years of use, while the open back table gives you more work area and can handle oversize frames without taking up valuable shop space.

Create a two-person work cell with the AT Race 4' x 12' - it includes both left- and right-side fences. This assembly table is an essential addition to your inventory of professional woodworking production tools.

When you are in need of premier woodworking tools and supplies, turn to Castle USA. We pride ourselves on providing our customers with the absolute best and highest quality tools, machinery, and accessories.

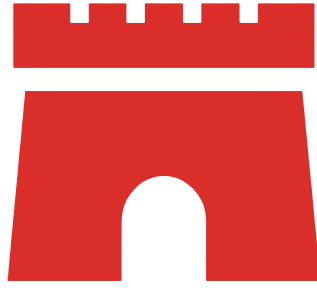
FEATURES AND BENEFITS INCLUDE:

- Professional woodworking assembly table
- Open back design:
 - Accepts oversized frames and other large assemblies
 - Maximizes work area
- Dual Unistrut clamping arms with three adjustable air cylinders that hold work firmly for easy assembly and minimal sanding
- 45 Degree, 1" laminated top for easy glue clean-up and less operator fatigue than horizontal clamping tables
- Built-in driver holster keeps driver within easy reach for increased convenience and efficiency (driver sold separately)
- Convenient integrated connection port for air powered driver adjacent to driver holster
- Left- and right-side fences allow two-person operation
- Rigid and lightweight for easier handling and positioning

TECHNICAL SPECIFICATIONS:

- Unistrut rigid steel arms with redesigned quick-clamps
- Driver sold separately
- Assembly required
- Footprint: 165" x 43" x 83"
- Manufactured in the USA





Production pocket joinery... for ANY shop.



Made in USA

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Petaluma, CA 94954

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CastleUSA.com



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