

Figure 2. When using the knife setting gauge (1) to check or adjust knife height, seat the square slotted end (2) of the gauge over the outfeed tie bar (3), and let the tip (4) rest against the cutterhead (5). Rotate the cutterhead to position a knife (6) on the zero line (7) on the gauge. When the knife height is properly adjusted, the cutting edge of the knife will barely touch the zero line on the ramp (8) without lifting the tip from the cutterhead.

Pages 25, 26

Removing, Installing, and Adjusting Knives

10. Adjust the height of the knife to within $1/32$ " of its correct position. Place the knife setting gauge over the right end of the outfeed tie bar as described in "Checking Knife Positions" in this section. Insert the $5/32$ " Allen wrench in the right knife leveling screw. Slowly rock the cutterhead back and forth so that the knife passes under the gauge. At the same time, turn the leveling screw counterclockwise until the edge of the knife comes within $1/32$ " of the zero line you scribed on the ramp of the gauge. (See Figure 3.)

Repeat this procedure for the left knife leveling screw. Then 'snug

up' all eight wedge locking screws, turning them just one revolution clockwise to seat them. Do not completely tighten the wedge locking screws at this time. If you tighten these screws past 'snug,' the wedge will seat and you won't have the freedom to make the final height adjustment. You may also bend or break the knife.

Final Adjustment

11. Adjust the height at the right and left ends of the knife. Replace the knife setting gauge near the right knife leveling screw. Insert the Allen wrench in this screw and rock the cutterhead back and forth. Carefully turn the knife leveling screw until the knife touches the zero line scribed on the gauge.

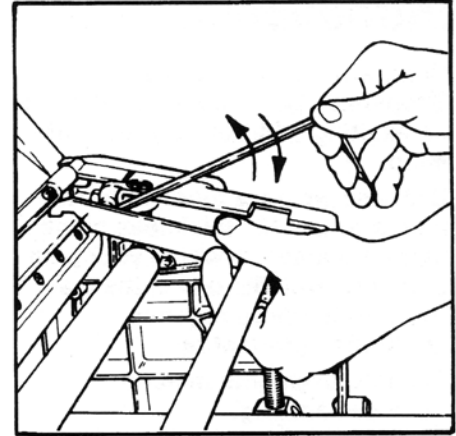


Figure 3. Initially, adjust the knife height so that the cutting edge almost touches the zero line of the knife setting gauge, as shown.

Repeat this procedure for the left knife leveling screw, skipping over the middle screw for the moment. When you have made the final height adjustment at both ends of the knife, tighten the extreme right wedge locking screw in the right wedge, then the extreme left wedge locking screw in the left wedge. Leave the other wedge locking screws alone for the moment.

After tightening these screws, recheck the knife height at both ends of the knife. Tightening the screws may move the knife slightly. If this happens, loosen the wedge locking screws and pop the wedge loose again. Readjust the knife height, compensating for the movement.

Page 29

Synchronizing the Table Mounting Posts

If the chain should slip or break, or should you need to remove it for any reason, one or more of the mounting posts may be turned out of synchronization with the others. With the posts 'out of sync,' the thickness adjusting mechanism will not operate properly, you may not