

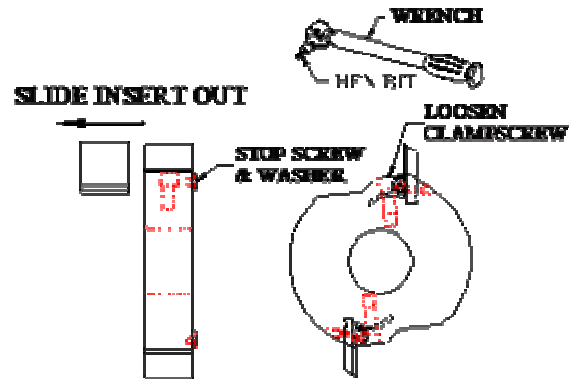
WEINIG PROFILE INSERT TOOLS

INSERT AND BACKER REPLACEMENT INSTRUCTIONS

(New style cutter with 6mm clamp screws)

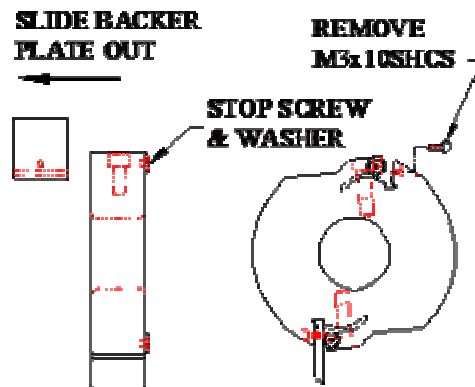
Insert Removal

1. Use a wrench with a 5mm hex bit to loosen the clampscrews. It is not necessary to remove these screws to remove the inserts. (Remove screws after every other replacement to reapply Anti-Seize.)
2. **Do not remove the stopscrews & stopscrew washers**, which are located on the side of the cutter.
3. With clampscrew loosened, slide the insert out to the side opposite the stopscrew. **Note:** The backer plates are held in position with a 3mm cap screw and do not need to be changed when replacing inserts with the same profile.



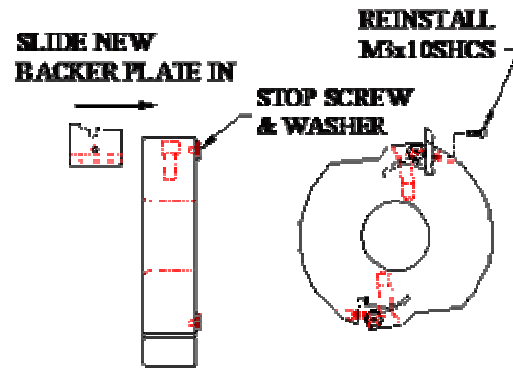
Backer Plate Removal

Using a 2.5mm hex key remove the M3x10SHCS (socket head cap screw) that is fastened into the backer plate. Slide the backer plate out to the side opposite the stopscrew. Continue around the cutter until all backer plates are removed.



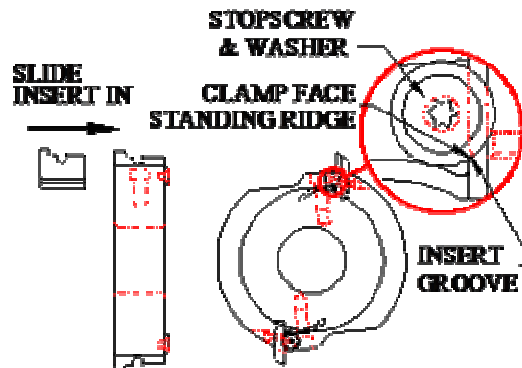
Insert and Backer Plate Installation

1. With all inserts & backer plates removed, clean cutter and insert slots using an air hose to blow out any loose material. Remove wood pitch or "caked on material" using Weinig Cutterguard.
2. Before reinstalling screws apply a small amount of anti-seize, which was supplied with your cutter, on the threads and under the head of each screw.
3. Slide in a new backer plate with the new profile into the slot making sure the standing ridge of the body is within the groove of the backer plate. Slide the backer plate in until it stops against the stopscrew washer. After applying anti-seize to the threads and under the head of the backer screw reinstall the screw into the threaded hole of the backer. Holding the backer against the bottom of the slot and against the stopscrew washer, tighten the backer screw using a T-handle hex wrench.

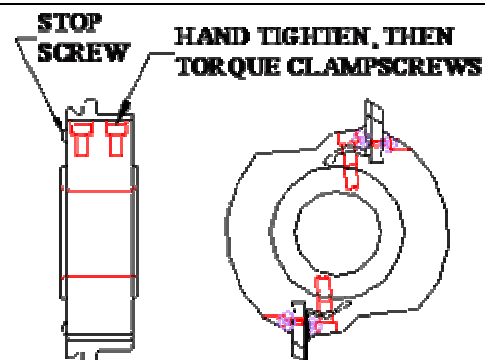


Repeat this procedure around the cutter until all backer plates are installed.

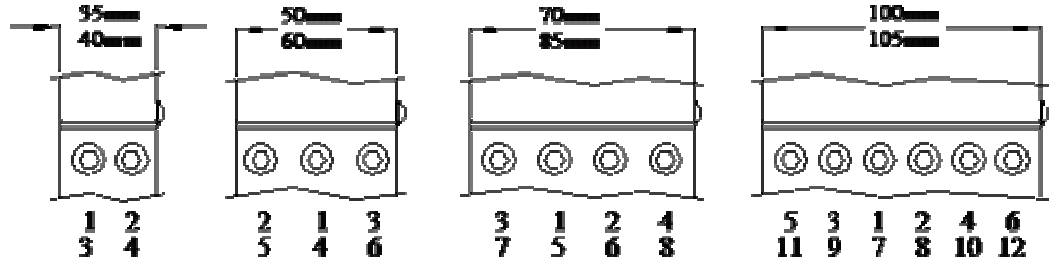
4. Slide a new insert into the slot, making sure the standing ridge of the clamp face is within the groove of the insert. Slide the insert in until it stops against the stopscrew washer.



5. Hold the insert against the stopscrew washer and against the flat bottom surface of the slot. **Be careful - the insert is sharp and can cut you.** The groove in the insert and the standing ridge in the clamp face are for safety only and do not in any way locate the insert. Applying pressure to hold the insert in place, tighten the clampscrews enough to hold the insert in place.



6. Using a torque wrench with a M5 hex bit, tighten each screw to 140-145 inch/pounds (15.8-16.4 newton meters). Torque wrench part no. 100426, Hex bit part no. 100427.



TIGHTENING SEQUENCE FOR CLAMPSCREWS

SCREW SIZE	HEX KEY SIZE	TORQUE VALUE	
		NEWTON METERS	INCH POUNDS
6mm	5mm	15.8 - 16.4	140 - 145



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