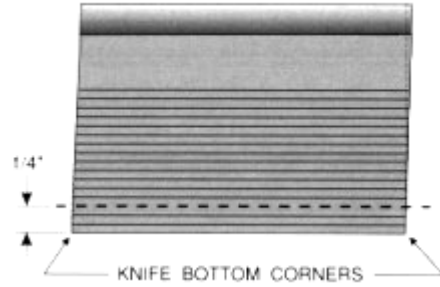


KNIFE TOLERANCES

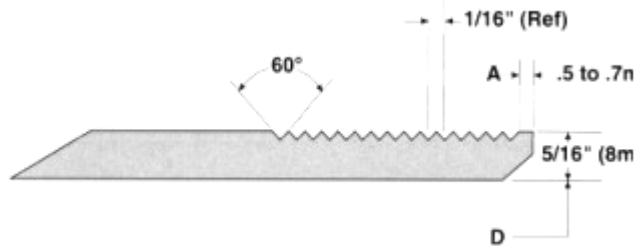
Constant reference point for profile knives

It is not necessary that the ends of the knife be perfectly square. When aligning knives in a cutterhead, always align the bottom corner of the knife (or any point within the bottom 1/4" of the knife as shown at right) with the tool reference surface.



Knife tolerances

The finished surface of the wood depends on the smooth running of the tools. The running of the tools is influenced by imbalance. This is why all profile knives employed in a profile cutterhead must have the same thickness (D) and be balanced in weight ***within 1/10th of a gram, if possible, and never more than one gram.***



Moreover, the start of the back corrugation (A) on all knives must be the same distance from the end (.5 to .7 mm) to maintain balance after grinding.

NOTICE

Always weigh new gibs and gib screws to verify their balance.

Maximum outward adjustment of knife

Resharpened knives may be moved outward in the knife slot, but the bottom of the knife can be no higher than the bottom of the gib or the line scribed on the head. (See drawing at right)

