

Weinig Cutterhead Operation & Safety Instructions

WEINIG PROFILE CUTTERHEADS Type 503, 513, 504, 514

Proper Installation of Corrugated Knives

- 1) Remove dirt and resin from clamping wedges and cutterhead serrations.
- 2) Insert the knife corrugations into the cutterhead corrugations. Always align the bottom ¼" corner of the knife with the tool reference surface. This will compensate for knives that may be cut crooked.
- 3) Push the clamping wedge in from side, and tighten lightly with a clamping bolt
- 4) Check the knife to insure proper fit into cutterhead corrugations
- 5) Tighten the clamping bolts from the middle bolt outwards (Example: Cutterhead slot requiring 5 bolts, you should tighten in bolt number sequence 3,2,4,1,5). Required tightening torque on clamping bolts: M10 bolts—18 to 19 ft/lbs; M12 bolts—22 to 24 ft/lbs. Do NOT overtighten.
- 6) To remove the knife, release the tension from the clamping bolts, push the clamping wedge out the side, and then remove the knife. Protect yourself from injury by wearing gloves whenever handling cutterheads and knives, and always undo clamping screws away from the cutting edge.

Important Information Regarding Operation of Weinig Profile Cutterheads

- 1) For safety reasons, the maximum adjustment of re-ground knives must not exceed four corrugations (1/4") from the bottom. There is a line on the cutterhead that indicates the maximum outward adjustment.
- 2) Insert knives successively opposite each other.
- 3) Always use no less than two clamping bolts to clamp knives and wedges.
- 4) Install filler strips into empty knife slots. Never run a cutterhead with empty pockets.
- 5) Use only original Weinig spare parts in the cutterhead.
- 6) All knives must be 16-60degree corrugations, and must be fitted in the same corrugation position.
- 7) Knives must have the same thickness, and must be balanced within 0.1 gram (0.0035 oz) of each other for proper performance. This is very important, as the finished surface of the wood depends on the smooth running of balanced tools.

- 8) When using knives that are significantly shorter than the cutterhead, either use a clamping wedge according to the width of the knife or install a filler strip in the balance of the knife slot.
- 9) Never allow the knife steel to extend past the end (or side) of the cutterhead more than the thickness of the knife steel.
- 10) Always weigh new gibs and gib screws to verify their balance.
- 11) Never exceed the maximum speed specified on the tool.
- 12) Type #504 and #514 hydro-cutterheads should be pressurized to 350 bar prior to machine operation.

For additional safety information regarding Weinig cutterheads, please request the instruction manual from the Weinig Tooling Department at 1-800-343-4644.

