

Planer Knife Setting Jig Instructions

The setting jig is used to quickly and accurately set planer or thicknesser knives. They can be used on any machine where access to the cutterblock can be gained or with fixed table machines where the tables are made from a magnetic material, such as cast iron or steel (not aluminium).

Minimum cutterblock diameter	75mm
Maximum cutterblock diameter	125mm
Number of knives	2 – 4
Height adjustment	0-22mm
Increments of adjustment	0.15mm

Important:

Before starting any maintenance unplug the machine from the electric supply.
Take care when handling sharp knives.

1) Depending on the type of machine, lift up or remove the planer tables to get access to the cutterblock.
(If the outfeed table is not removable, the jig can still be used providing the table is made of a magnetic substance. In this case follow the instructions below, but note that the shorter leg of the jig sits on the table rather than the cutterblock)

2) Ensure the knives currently installed in the cutter block are set correctly.

To check this:

- Rotate the cutterblock so that the tip of the installed knife is in its highest point
- Hold a straight edge, such as a metal ruler, across the outfeed table (the fixed table) and over the knife. The tip of the knife should just touch the underside of the straight edge. Do this on both ends of the knife, and repeat for each knife in the cutterblock.

3) Having confirmed the installed knives are correctly set, place one of the setting jigs onto the cutterblock as shown. The feet of the jig are magnetic and will hold themselves on to the steel of the cutterblock. Wind the setting rod down until it touches the tip of the blade. Turn the brass knob to lock this position. It is advisable to now make a note of the reading on the scale, on the label provided. Each jig will vary slightly, so repeat the process with the second jig and note down that reading too.

If you only use one planer thicknesser you will never need to adjust this setting. If you use the jig on more than one machine, you will need to note down a different height setting for each machine.

4) Remove the old knives from the cutterblock. Take one new knife and fit it loosely into position within the cutterblock. Place the two jigs, one at each end of the knife, over the cutterblock. Now lift the knife so that it is held in place by the magnets on the ends of the setting rods. The height of the knife is now perfectly set and the knife can be clamped in place.

5) Rotate the cutterblock and repeat for the remaining knives.

