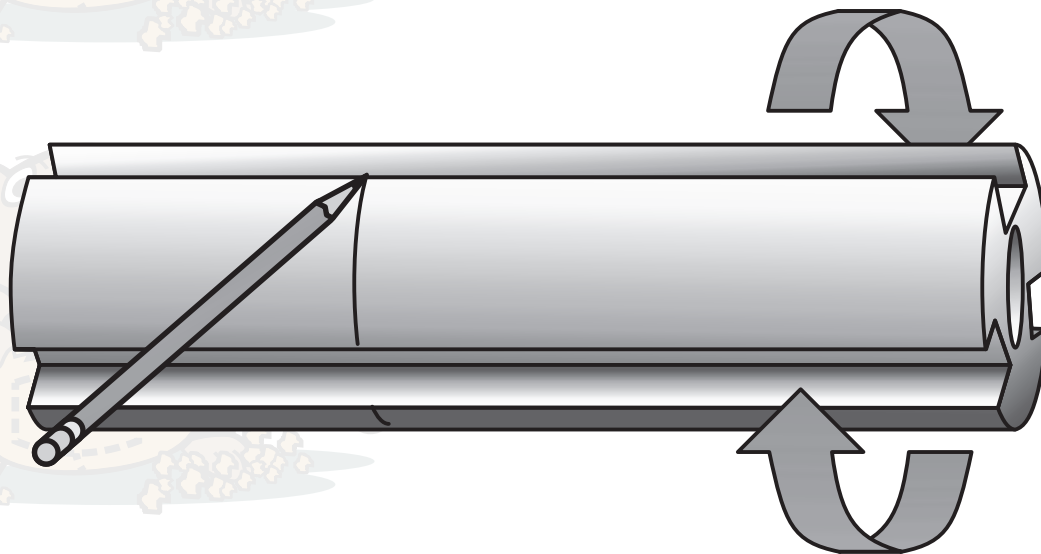


Knife Alignment Process

1. Unplug machine.
2. Remove planer blades from head.
3. Scribe lines on planer head with a pencil while turning head by hand.



4. Align edge of knives with pencil mark and lightly tighten in place. Use just enough pressure to hold knife in place. Make sure knife is seated in the bottom of the planer groove and does not move and misalign when tightened.

Because of our unique manufacturing process the matched set of 3 knives will have identical common measurements (+/- 0.002"). This will insure that the knives can be easily aligned using this method.

5. Tighten knives progressively around the planer head.
6. Install hood and set guides to manufacture molding. (Refer to pages 92-94 of our profile catalogue). You may view this at moldingknives.com.
7. If you have a variable speed feed molder, machine approximately 1 foot of a 3 foot blank. Shut off the feed and then the main motor. Disconnect electric and remove hood. Turn the head by hand. The knives will now describe the profile - any variation in knife placement can be easily corrected.
8. Retighten knives after machining the initial blank. Your knives are now set and should give you many hours of profitable pleasure.
9. **Have FUN!**

Shop Hint:

Keep a piece of the completed molding to use as a jig for your next set-up.