

## **CONVENTIONAL CUTTERHEADS**

After first setting all gib screws in the cutterhead snug they should be tightened using either a T-handle wrench or the standard gib screw wrench supplied by Weinig. A torque wrench is not required, but all screws should be tightened equally:

M10 gib screws - 25 Nm or 18 Ft. lbs.

M12 gib screws - 30 Nm or 22 Ft. lbs.

Never allow the knife steel to extend out past the end or side of the cutterhead more than the thickness of the knife steel.

Make sure that the knife steel or blind wedge (filler stock) is covered by a minimum of two gib screws.

If a gib screw does not have knife steel or blind wedge behind it, either remove it or tighten it down until it is just snug. Do not overtighten.

### **CAUTION**

**Never run a cutterhead with empty pockets. Always use filler strips or old planing knives that have been balanced. Tightening screws with only gib screws in the pocket can strip the threads.**

