



Model 40285H

20" PLANER INDEXABLE INSERT HELICAL STYLE CUTTER HEAD INSTRUCTIONS

This indexable helical style cutter head is designed for 40285H

These instructions make reference to many procedures detailed in your planer manual. Always consult your manual for these procedures.

⚠ WARNING:

Cutter head knives and inserts are razor sharp! Always wear heavy leather gloves when handling cutter heads and avoid contact with cutters whenever possible. Failure to comply can result in serious personal injury!

Inventory (Fig.1)

- A. 1 Helical Style Cutter head
- B. 1 Torx Wrench
- C. 40 Knife
- D. 40 Flat Head Torx Screw M5 x 8.8

Fig.1

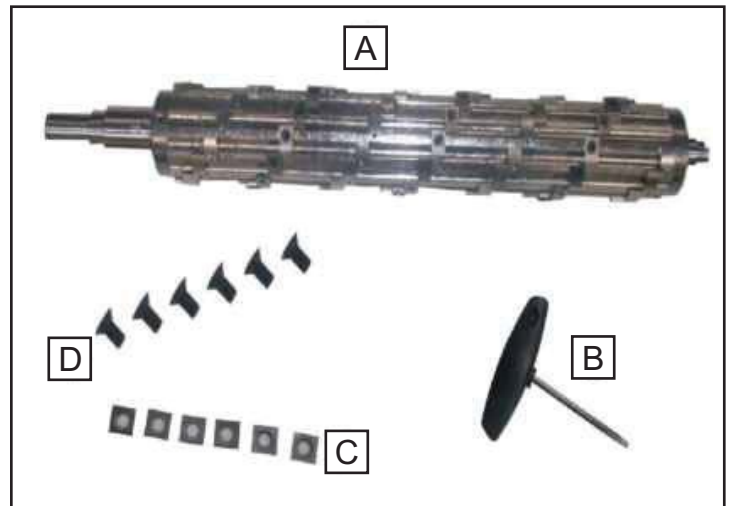


Fig.1 Model 20" Helical Style Cutter head

40930.....HSS	Tips (Box of 10)
40932.....Torx	Screws (Box of 10)
40933....."T"	Hand Wrench
40938	Carbide Tips (Box of 10)



Rotating/Changing High Speed Steel Cutters

Tools Needed:

1 T-Handle Wrench w/T25 Torx Bit

The 20" cutter head is equipped with 40 indexable high speed steelcutters. Each cutter can be rotated to reveal any one of its two cutting edges. Therefore, if one cutting edge becomes dull or damaged, simply rotate it 90 to reveal a fresh cutting edge (Fig.2).

In addition, each cutter has a reference dot on one corner. As the cutter is rotated, the reference dot location can be used as an indicator of which edges are used and which are new. When the reference dot revolves once, the cutters should be replaced with the accessories listed below.

Fig.2

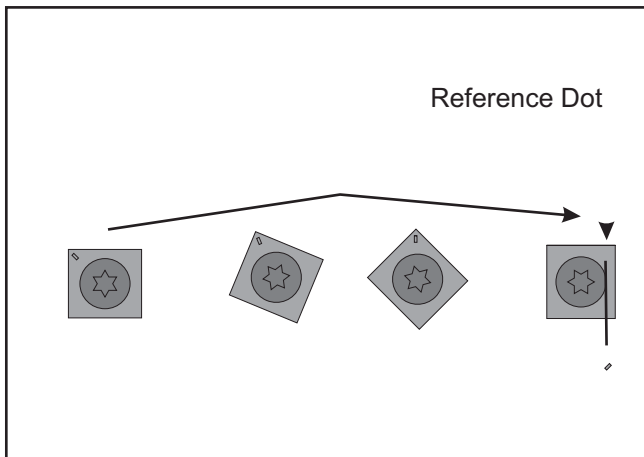


Fig.2 Cutter rotating sequence

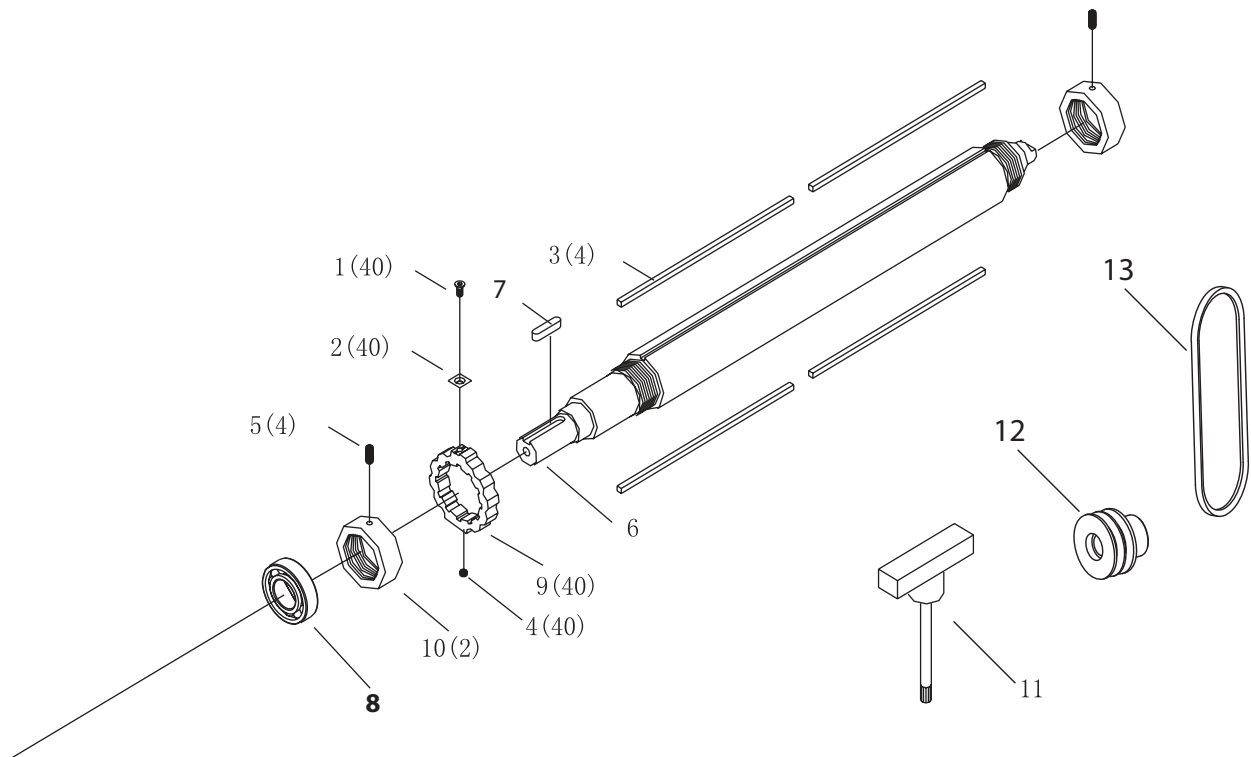
To rotate or change a high speed steel cutter:

1. **DISCONNECT THE PLANER FROM THE POWER SOURCE!**
 2. Remove any sawdust from the head of the high speed steel cutter Torx screw.
 3. Remove the Torx screw and high speed steel Cutter.
 4. Clean all dust and dirt off the cutter and the cutter head pocket from which the cutter was removed, and replace the cutter so a fresh, sharp edge is facing outward.
- Note:** Proper cleaning is critical to achieving a smooth finish. Dirt or dust trapped between the cutter and cutter head will slightly raise the cutter, and make a noticeable marks on your work pieces the next time you plane.
5. Lubricate the Torx screw threads with a light machine oil, wipe the excess oil off the threads, and torque the Torx screw to 48-50 inch/pounds. When rotating a tips, the tips will seat itself before tightening.

If available, try using pitch and gum remover to be sure all of the wood residue is off the cutter head and inserts before attempting to rotate them. Using a shot of compressed air is also helpful, be sure to wear safety glasses.



40285H 20" Industrial Planer Helical Style Cutter Head Part List



KEY NO.	PART NO.	DESCRIPTION	QTY	KEY NO.	PART NO.	DESCRIPTION	QTY
1	SC80702	M5 x 8.8mm TORX HD SCR	40	6	Assembly	CUTTER HEAD	1
2	SC10240H	KNIFE HSS	40	7	SC84506	KEY8 x7 x 40mm	1
3	SC84508	KEY 5x5x254mm	4	8	SC83003	BALL BEARING 6206-2RS	1
4	SC80709	M4x8mm HEX SOC SET SCR	40	9	SC10242	KNIFE PLATE	40
5	SC80605	M5x8mm HEX SOC SET SCR	4	10	SC10243	ROUND NUT	2
				11	SC10259	TORX WRENCH	1
				12		PULLEY 103.5mm	1
				13		BELT A1676	2

NOTE: cutter head speed 6000 RPM

NOTES

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