



Model 40535GH

6" JOINTER INDEXABLE INSERT HELICAL STYLE CUTTER HEAD INSTRUCTIONS

This indexable helical style cutter head is designed for 40535GH.

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. 12 Knife
- D. 12 Flat Head Torx Screw M5 x 8.8

Fig.1

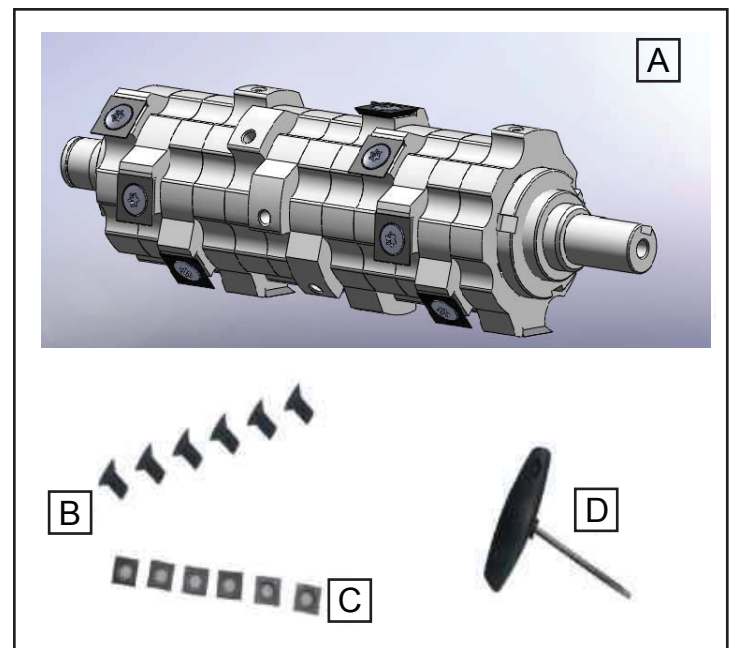


Fig.1 Model 6" Helical Style Cutter head

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 6" cutter head is equipped with 12 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.

Fig.2

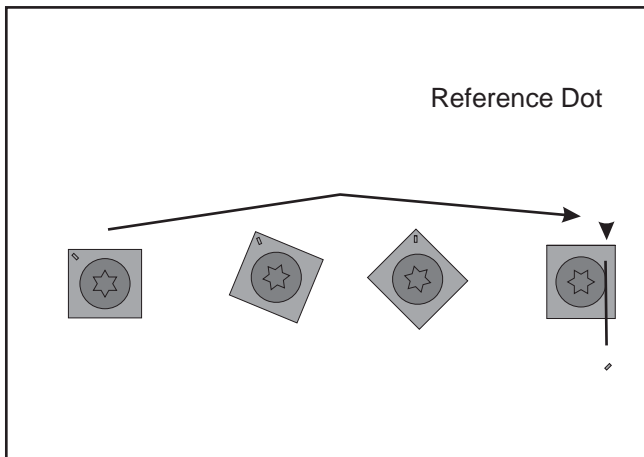
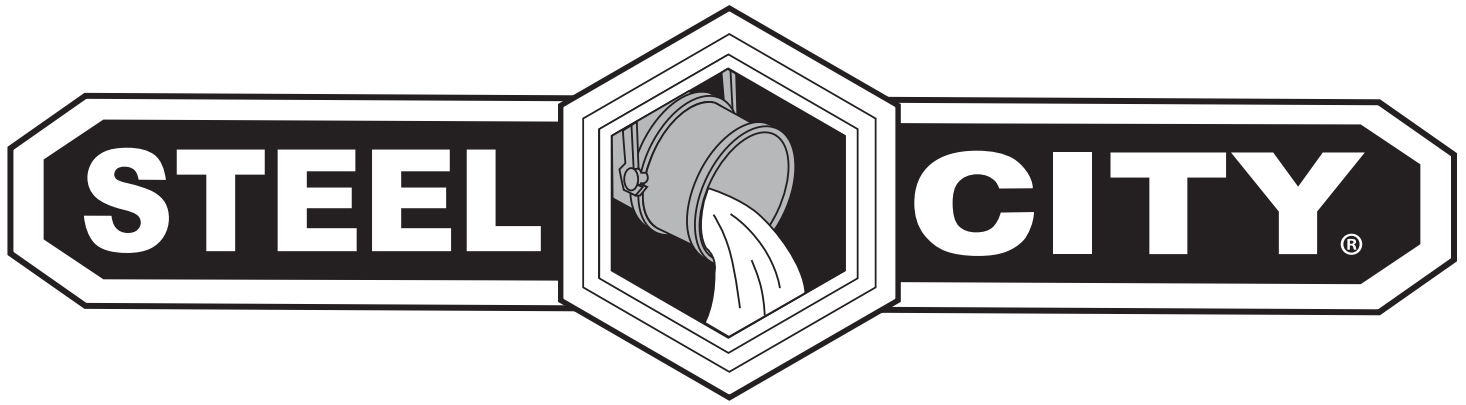


Fig.2 Cutter rotating sequence

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.



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