REFER TO YOUR OPERATORS MANUAL FOR SAFETY GUIDELINES

A SUB PLATE MAY BE NEEDED

Knives that are designed to cut beyond the thickness of stock, or very close to it should be used with caution. The design of these knives may cause the knife to hit the bed of the molder. Some examples would be crown bottoms, half rounds, quarter rounds, and screen molds.

W&H recommends the following be checked each time knives and/or stock thickness change.

- Use a sub plate of millable material. When using a sub plate add the thickness of the sub plate and the thickness of your material to set the molder height accurately. A set of guides should be used to guide the stock through the knife cutting area.

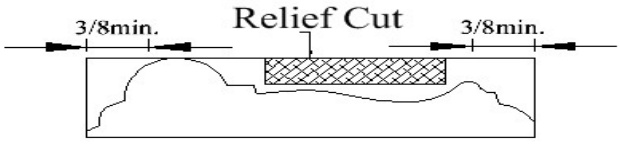
  Example: sub plate thickness ½" & material thickness ¾" = set the head at 1 ¼".
  NOTE: Depending on the scale setting and thickness of sub plates this example may vary.

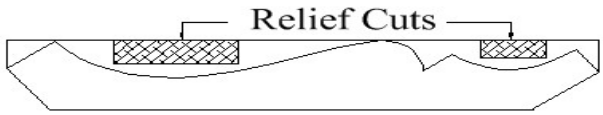
- Before installing the chute/chip deflector **rotate the knife arbor by hand** before starting the molder to ensure the knives are clear from interference from the guides, bed and/or head. The power on the molder should always be **turned off** when rotating the arbor.

DEEP CUTS MAY REQUIRE A RELIEF CUT - Multi-Pass may eliminate this step

Knives that have a deep cut (s) may require a relief cut in the deep section with a roughing knife or dado cut. Relieving deep cuts allows the molder to not bog down, will have less tear out and gives a better finish. IF the molder is equipped with the multi-pass system, this step is not often required.

This illustration is an example of how to make a relief cut. It is important to leave at least 3/8" width of full stock on each side to ensure a secure hold of the stock as it is being molded.





PLANING WITH MULTI-PASS – NEED TO BACK OFF PRESSURE SCREWS!

Backing off the pressure screws for planing is needed if your molder has multi-pass. Multi-pass is on all molders manufactured March 2005 to this date or added onto your molder as a retro kit. Not sure if you have multi-pass?

- Disconnect power. Remove knives from arbor, raise the head ¾" + 3/16"
- Slide a ¾" piece of stock onto the sub-plate or base of the molder.
- If the rollers have contact with the stock, your molder has multi-pass. If the rollers do not have contact with the stock your molder does not have multi-pass.
- Multi-pass retro kits are available for all older W&H molders.

Loosen the (4) 54-25 pressure screws exposing ¼" of thread when planing. This will give you proper roller pressure. Failure to do so will cause feeding difficulties and feed system damage.

When MOLDING all four pressure screws should be equally tightened.