



# PROFILE PRESSURE GUIDES

ITEM # PPG-1



Instruction  
Manual

December 27, 2018

## **INSTRUCTIONS FOR INSTALLING** **IN-FEED & OUT-FEED PROFILE PRESSURE GUIDES**

### **Item #PPG-1**

**The instructions provided are based on using a W&H GS-2-1 Guide System, yellow measurement scale, our ½” thick sub-plate and molders equipped with our Multi-Pass System. Our Profile Pressure Guide (PPG) example used in these instructions is based on the features mentioned. Customer designed sub-plates at different thicknesses and scale set variations will need to be taken into consideration when setting the scale and roller assembly. Molders will need to be equipped with our Multi-Pass System.**

#### **Included:**

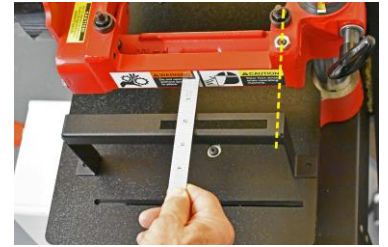
<b>2</b>	<b>PPG-12-FIN</b>	<b>Bracket, Profile Pressure Guide, Finished</b>
<b>2</b>	<b>PPG-30</b>	<b>Roller Assembly (includes the next 8 items)</b>
	PPG-13	Roll, Pressure, 9/32” with bearing, 80 Duro, Yellow
	PPG-15	Rod, 3/8-16, Threaded, Finished
	PPG-17	Roll, Pressure, Housing
	PPG-18	Pin, Bridge, Finished
	PPG-19	Pin, Clevis, 5/16”
	PPG-20	Washer, Flat, ¼”, SAE
	PPG-22	Knob, Fluted with 3/8” Threaded Insert
	PPG-25	Nut, Weld, 3/8-16 x 7/16”
<b>1</b>	<b>PPG-31</b>	<b>Hardware Bag (includes the next 2 items)</b>
	PPG-23	Screw, PPH, ¼-20 x ½”, St Zp
	PPG-24	Insert, Threaded, ¼-20, Steel

#### **Tools Needed:**

- 6mm Allen Wrench or 6mm Head Hex Insert bit for Drill, Phillips Head Screw Driver
- Hammer
- Medium Chamfer Drill Bit
- Transfer Punch
- Electric Drill
- Safety Glasses

**DRILL HOLES IN THE 1/2" BLACK SUB-PLATE FOR THREADED INSERTS**

1. Disconnect power. Remove the chip extractor and raise head.
2. **IN-FEED SIDE** - Using (1) PPG-12-FIN Brackets as a guide, place the bracket on the sub-plate evenly spaced 1-1/2" away from the infeed side of head casting, with the edge of the bracket lined up with the post-side of the guide plate.



*NOTE: The yellow dotted line represents PPG Bracket Position, this is important if using an alternative sized sub-plate. Align the in-feed & out-feed PPG Brackets with the pressure screws on the post side of the molder.*

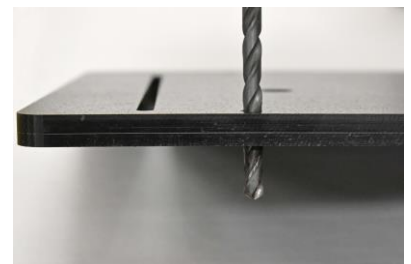
3. Use a metallic marker (or any pen that can make visible marks on a black surface) to create a guide mark in the center of the each hole on the bracket.
4. **OUT-FEED SIDE** – Repeat Step #2 & #3 for the out-feed bracket.



5. Remove the sub-plate from the molder and place on an even, flat surface to allow space to drill the holes. Use a transfer punch and hammer to make a prick punch on each guide mark (4).



6. Using an 11/32" drill bit, drill all (4) holes through the sub-plate, making sure to drill **straight** through to the other side.



7. Use a medium chamfer drill bit to chamfer the holes.



8. Using a 6mm Allen Wrench or 6mm Hex Head Insert drill bit, screw in the PPG-24 threaded inserts until they are flush with the surface of the sub-plate. Attach sub-plate to molder base.



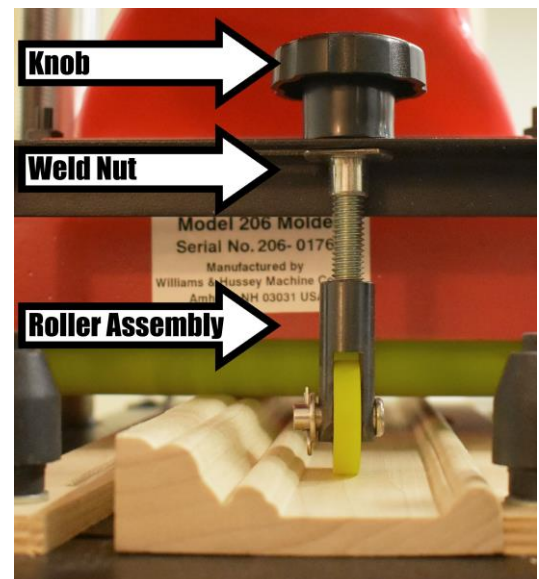
### **ATTACH PPG BRACKETS & ROLLER ASSEMBLY**

1. With the machine off, bolt knives to arbor, set your guides to your sized stock, tighten adjusting handles.
2. Attach (1) PPG Bracket to the in-feed side sub-plate using the PPG-23 screws.
3. Repeat Step #2 on the out-feed side of the sub-plate.
4. Attach the Roller Assembly to the bracket by feeding the bolt with weld nut already applied up through the opening of the bracket. Weld nut should be held tight to the inside-top of the bracket, then screw on the knob.



NOTE: Height adjustments will be made in the next step.

**PRO TIP: PPG BRACKETS  
ARE INTERCHANGEABLE  
AND REVERSIBLE.**



**SETTING MOLDER SCALE & PPG ROLLER ASSEMBLY**



**WARNING: SETTING PPG ROLLER ASSEMBLY TOO LOW  
CAN RESULT IN FEED ISSUES AND SAFETY HAZARD**

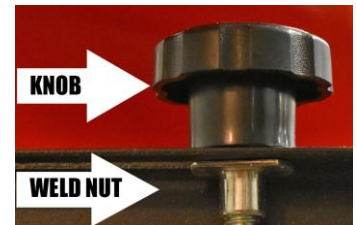
**Example Below Uses:**

In-Stock #2852	In-Stock #2271	GS-2-1	<b>WARNING:</b> HEIGHT SETTINGS SHOULD ALWAYS BE VERIFIED PRIOR TO MOLDING
A Rabbet cut has been performed prior to molding to reduce stress on the machine	Height settings for different profiles will change depending on the depth of cut	Customer designed sub-plates & scale set variations must be taken into consideration	

1. Adjust the height of the Roller Assembly to accommodate the lowest portion of the molding on the outfeed. Each turn = 1/32". 1 full revolution = 1/16"
2. Tighten knob at desired height. CAUTION: Double-check that knob and weld nut are tightened prior to molding.

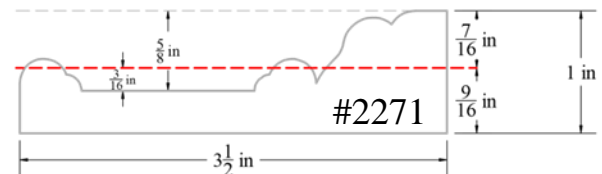
Note: Roller Assembly will be set differently for infeed and outfeed.

MATERIAL STAGES	SCALE	PPG INFEED	PPG OUTFEED
SIZED STOCK	1"	PPG Not Needed	PPG Not Needed
RABBET CUT #2852	1"	PPG Not Needed	PPG Not Needed



**Example Formula**

**Step 1**    **10/16"**    Full Depth Of Cut  
               -    **3/16"**    Multi-pass Gap  
                      **7/16"**    Initial Depth of Cut  
  
**Step 2**        **1"**    Stock Height  
                   -    **7/16"**    Initial Depth of Cut  
                      **9/16"**    PPG setting for First Pass



MATERIAL STAGES	SCALE	PPG INFEED	PPG OUTFEED
FIRST PASS	1 3/16"	PPG Not Needed	9/16"
SECOND PASS	1 1/16"	9/16"	7/16"
FINISH PASS	1"	7/16"	6/16"

3. After the first pass, adjust both PPG Roller Assembly and the head scale in the same increments.  
Example 1/16" at a time.

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