

## 84-120 Insert-Pro Glue Joint Shaper Cutter Setup Instructions

The unique design of this cutterhead allows the fit of the profile to be adjusted for a tighter or looser fit and to accommodate the change in profile after sharpening.

### Tools Needed:

- Set of feeler gauges
- 1.5mm Allen key
- Flat-blade screwdriver

### How To Make Adjustments:

1. Loosen the stop on the bottom of the cutter head that has been marked and loosen the internal set screw (lower photo at right).
2. Remove the corresponding knife.
3. Insert a feeler gauge between the cutter body and the stop. The stock spacing is 0.007".
  - a. For a tighter-fitting joint reduce the spacing.
  - b. For a looser-fitting joint, increase the spacing.
  - c. We recommend making changes in no more than 0.001" increments and making test cuts between each adjustment until the desired fit is achieved.
4. Tighten the stop screw against the feeler gauge by hand then tighten the internal set screw in the stop.
5. Reinstall the knife and make test cuts to confirm fit.

**NOTE:** Preset factory cutter offset is .007".

**NOTE:** Only one knife is adjusted to create a properly fitting joint. The stop for the knife that is not marked from the factory should remain seated against the cutter body.

