HAFCO WOODMASTER

SPIRAL CUTTER INSTALL INSTRUCTIONS

Models
SHC6-28, SHC8-40

Order Code W761, Order Code W763

Edition No : SC-001

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HAFCO WOODMASTER

OPERATION MANUAL

Introduction

The indexable-insert helical cutterheads in this manual are designed to replace the straight knife cutterhead on the Hafco Woodmaster PT-6 & P-200H planners.

Specifications

Order Code	W761	W763
Model No.	**SHC6-28**	**SHC8-40**
Suits Hafco Planer	PT-6	P-200H
Cutting Head Length (mm)	150	200
Suits Cutter Head Diameter (mm)	Ø 64	Ø77.5
Number of Spirals	4	4
Number of Inserts	28	40

Installation

The total installation and setup procedure takes approximately two hours. Read these instructions thoroughly before beginning.
NOTE: This instruction sheet is to be used in conjunction with the machine manual.

MACHINERYHOUSE

WARNING **Knives and inserts are extremely sharp. Wear leather gloves to avoid the risk of serious personal injury during the procedure.**

REMOVAL OF FACTORY SPINDLE

1. DISCONNECT MACHINE FROM THE POWER SUPPLY.
2. Remove the blade guard.(Fig.1)

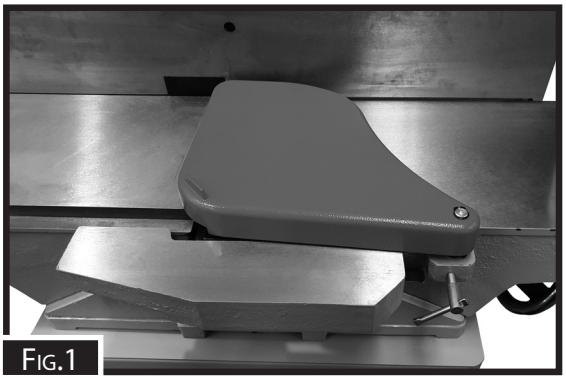
Fig.1

Fig.2

3. Remove top half of fence attachment by undoing nut from underneath. (Fig.2)

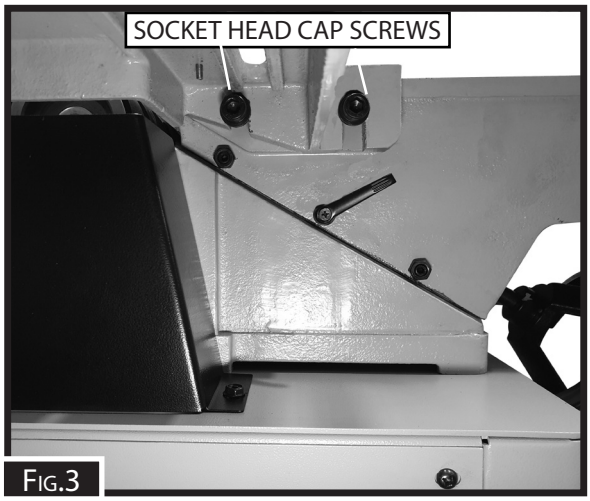

Fig.3

4. Remove fence support - by loosening the two cap head screws. (Fig.3)
5. Remove the rear cover - by removing the three screws across the top and loosing them across the bottom. (Fig.4)

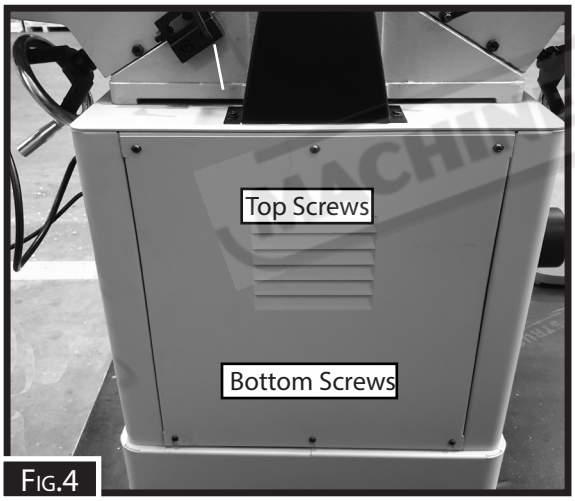

Fig.4

6. Remove belt cover. (Fig.5)

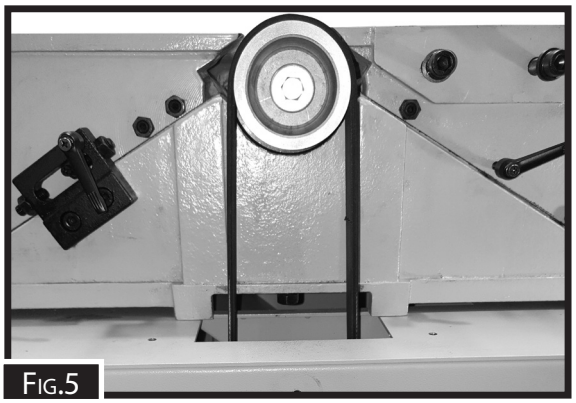
Fig.5

7. Remove dust port.
8. Remove belt and remove pulley by un screwing hex head bolt and loosening grub screw. Then with gear puller remove the pulley, key and spacer washer. (spacer washer only found on P-200H) (Fig.6)

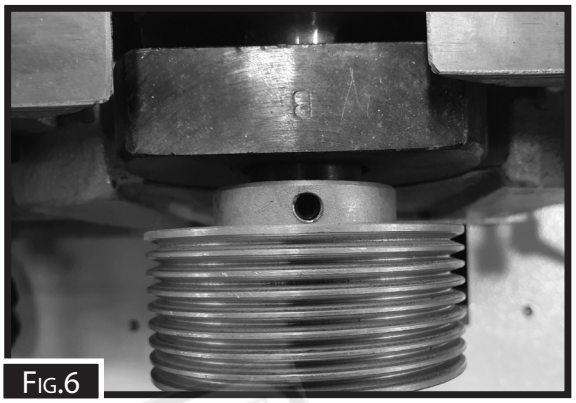
Fig.6

9. Wind in and out feed tables to lower limits.
10. Unbolt three main bolts holding jointer to base. (Two are in the main base (Fig.7) enclosure, one is in the dust chute).

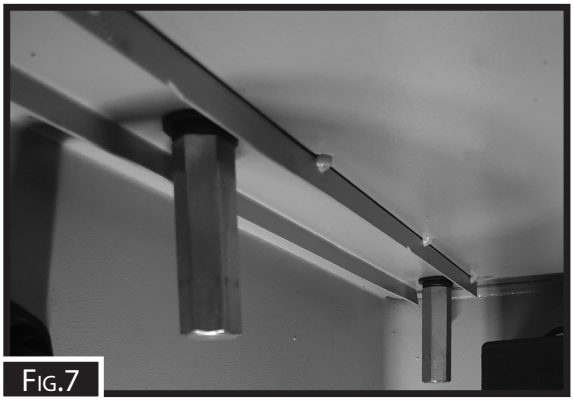
Fig.7

11. Use a mechanical lifting device to lift the machine off the base and place blocks of wood under each side to access the spindle mounting nuts. (Fig.8)

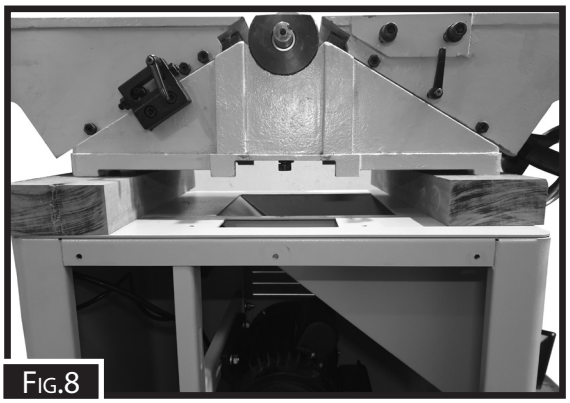

Fig.8

12. Unbolt the two spindle mounting bolts. (Fig.9)

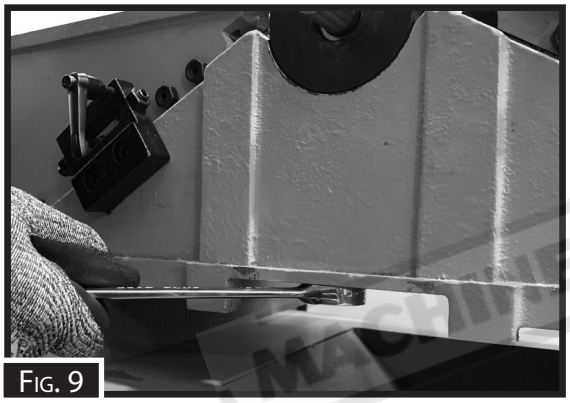

Fig. 9

13. Carefully (use gloves or remove blades) re move the whole spindle assembly (take note of any shims under the bearing blocks).
14. Remove bearing blocks off each end using bearing/gear puller (take note of which side each comes off). (Fig. 10)

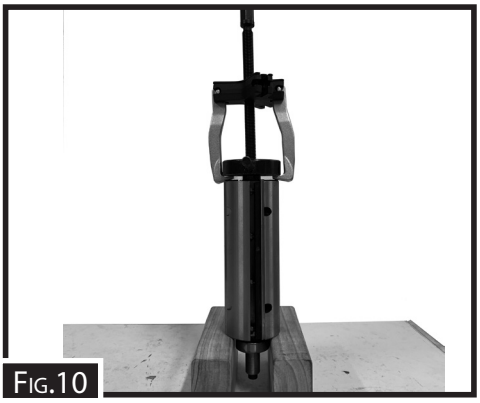

Fig.10

FITTING NEW SPIRAL CUTTER

1. Place the cutterhead assembly on work bench or flat surface with pulley side of cutterhead shaft facing up, then place wooden blocks under rear bearing block, as shown in Fig.11
2. Refit bearing blocks (ensure each are put on the same side they came off).(Fig. 11)

Fig. 11

3. Refit spindle assembly to machine (ensure shims are put back in the same side if fitted). (Fig.12)

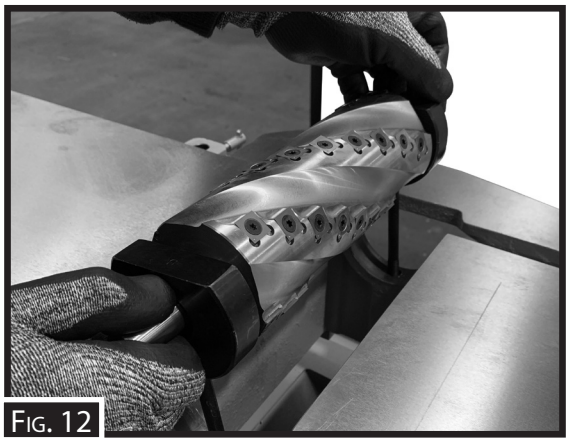

Fig. 12

4. Tighten the helical cutterhead in place, making sure to replace shims, lock washer and hex nuts previously removed. (Fig.13)

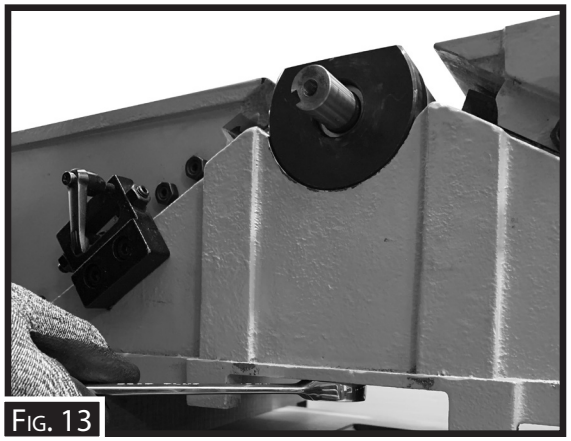

Fig. 13

5. Use a straight edge and feeler gauge to check that the cutter head is parallel with the outfeed table (shim if necessary) (Fig.14) Place the straightedge in position, on one side of the outfeed table and raise or lower outfeed table until the cutterhead body (not the insert) just touches straightedge. (Fig.14) Move the straightedge to the other side to determine if one end of cutterhead body is higher/lower than the other. (Place feeler gauge between cutterhead body and straightedge to determine the height difference.) Place shim under the bearing blocks until parallel.

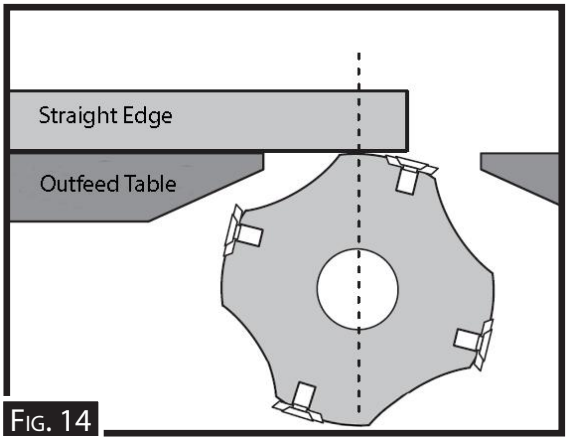

Fig. 14

6. Remove the wooden blocks and bolt the machine back onto stand.
7. Re-install the key onto the keyway, then press pulley onto new cutterhead shaft
8. Refit the belt, belt cover, rear cover and dust port (Ensure the Belt is in good alignment).
8. Refit fence support and fence assembly.
10. Use a straight edge to realign out feed table with top of cutter edge. (Fig.15)

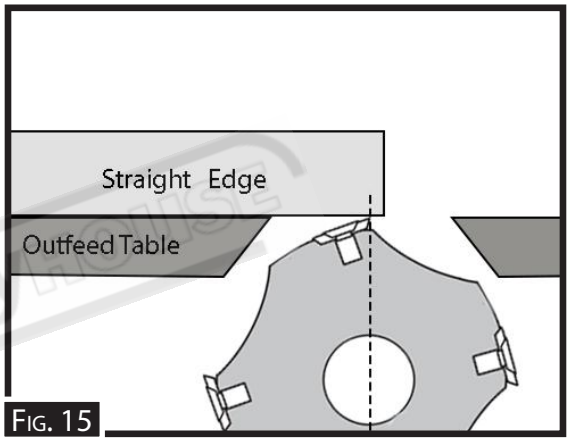

Fig. 15

10. Refit blade guard.
11. Test run the machine

CHANGING INSERTS

The cutterhead is equipped with indexable inserts.

28 Inserts SHC6-28 (W761)
40 Inserts SHC8-40 (W763)

Each insert can be rotated to reveal one of its four cutting edges. If one cutting edge becomes dull or damaged, then rotate it clockwise 90˚ to reveal a fresh cutting edge. Each corner of the insert has a reference mark. As the insert is rotated, the reference mark can be used as an indicator of which edges are used and which are new. The insert must be replaced when all four edges are dull (Fig.16

Fig. 16

INSTALLING OR ADJUSTING A HSS INSERT

1. DISCONNECT MACHINE FROM POWER!
2. Remove any sawdust from the insert and the insert Torx screw.
3. Remove Torx screw and HSS insert.
4. Clean all dust and dirt off the insert and cutterhead pocket and replace the insert so a fresh, sharp edge is facing outward.

Note: Proper cleaning is critical to achieving a smooth finish. Dirt or dust trapped between the insert and cutterhead will raise the insert, and make noticeable marks on your workpieces the next time you cut.

5. Lubricate Torx screw threads with a light machine oil, wipe excess oil off threads, and tighten the Torx screw.

Note: Excess oil may squeeze between insert and cutterhead or in screw hole, thereby lifting insert or screw slightly and affecting workpiece finishes.

Replacement Inserts
Order Code
W765
Packet. of 10