W1216A
PLANER PAL® KNIFE SETTING JIG
Instruction Sheet

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Planer Preparation



⚠WARNING
Wear safety glasses during entire setup process!

1. DISCONNECT YOUR PLANER FROM POWER!
2. Remove dust cover from planer.
3. Remove chip deflector and loosen springs holding chipbreaker down, if necessary. Loosening the springs will allow chipbreaker to be raised, exposing a larger portion of cutterhead when space is a limiting factor.

   IMPORTANT: Do not remove planer knives until instructed in **Replacing Knives** on **Page 2**.

If your planer has:	You should use:
Knives up to 20" length	Two PLANER PAL® Jigs
Knives 21" or longer	Three PLANER PAL® Jigs

Jig Preparation

The Planer Pal® Jig can be adjusted to the same height as the knives currently installed in your planer.

To prepare your jig, do these steps:

1. Loosen (1) set screw on each side of jig, as shown in **Figure 1**.
2. Position jig over knife in the middle of cutterhead. Verify middle bar contacts knife edge and end bars contact cutterhead securely (see **Figure 2**).

   IMPORTANT: Wipe magnets before use to ensure no metal filings interfere with magnet attachment.
3. Tighten (2) set screws to secure middle bar position.
4. Remove first jig and repeat **Steps 1**–**3** on remaining jig(s) in same location on cutterhead as first jig.

   IMPORTANT: To maintain consistency, it is essential you place each jig in the same position on knives. Otherwise, knife height could vary slightly from end to end.

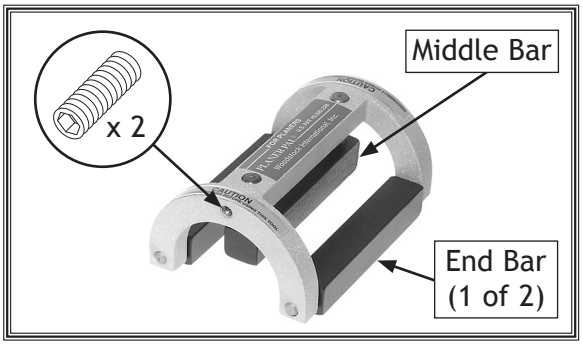


Figure 1. Planer Pal® components.

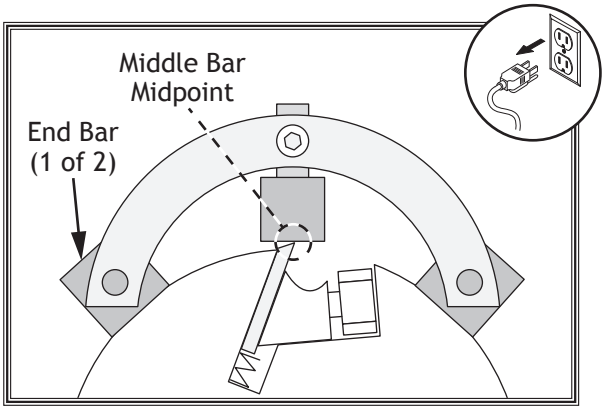


Figure 2. Jig contacting knife edge.

Replacing Knives

Once the Planer Pal® Jigs are properly adjusted for your planer, the knives can be replaced. For best results, remove and replace one knife at a time.

To replace knives, do these steps:

1. Remove (1) knife and replace with a new knife. Position knife above cutterhead so jigs can push knife in place. If using (2) jigs, place one at each end of cutterhead. If using (3) jigs, place third jig in center of cutterhead between other jigs.

2. Tighten gib bolts just enough to allow for knife movement, and gently push down on jigs until middle and end bars contact knife and cutterhead.

3. When all jigs are secure, tighten gib bolts gradually by turning each bolt once and moving on to the next gib. If a gib bolt is inaccessible due to jig placement, return later and tighten after other gib bolts have been fully secured.

4. Repeat **Steps 1**–**3** on remaining knives.

Additional Tips

- It is not always necessary to replace knives that have been nicked. You can often reset the nicked blades by slightly offsetting the knives from side to side so the nicks are no longer aligned with each other. This can be done after you have prepared the jigs as instructed in **Jig Preparation** on **Page 1**. Set the jigs on the cutterhead, loosen the knives (one at a time), slide them slightly to the left or right and re-tighten. Proceed to the next knife and offset in the opposite direction from the first. This method is an ideal way to deal with small nicks. Knives with larger nicks should be removed from the machine and taken to a professional knife sharpener. However, be sure to prepare your jigs prior to removal of the knives so that you can easily reset them to the same height when replaced.

- Once all knives have been replaced, return chipbreaker and feed rollers to their original position.

⚠WARNING

Injury may occur if knives are positioned higher than previous adjustment height. Always adjust your chipbreaker and feed rollers so that they are below the level of your blades at bottom dead center. Refer to your planer owner's manual for instructions regarding setting knife height.

⚠CAUTION

Cutterhead knives are extremely sharp. Contact with knives can result in severe cuts. Take great caution whenever working with or around cutterhead knives. Wear heavy leather gloves to reduce risk of severe cuts.

NOTICE

To maintain accurate and consistent planing results, replace dull knives or have them professionally sharpened.

- Always alternate the surfaces of your wood when taking multiple passes with your planer. Your workpieces will retain dimensional stability if you remove material from both sides. If the knives have been removed before you are able to adjust your jigs, you can use an alternative method to set them. Place the Planer Pal® Jig on your cutterhead and lower the middle bar until it comes in contact with the cutterhead. Insert feeler gauges (equal to the knife height recommended in your planer's manual) between the middle bar and the cutterhead and tighten the jig's set screws. Repeat the process on the remaining jigs.

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