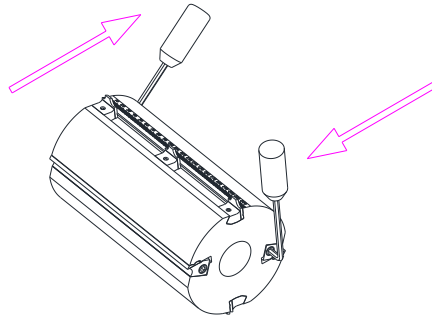


CentroLock Planing & Combihead – Insert/Knife Replacement Instructions

Note: Instructions are for a typical cutter. The cutter shown may not look identical to your cutter.

Planing Knife Removal

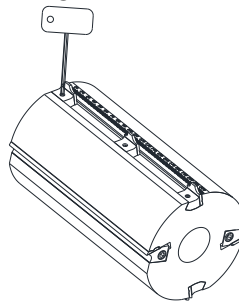
Simultaneously loosen the two clamp screws on both ends of the knife wedge. Tap the knife wedge down to loosen the knife. Slide knife out.



PLANING KNIFE REMOVAL

Profile Insert Removal

Loosen set screw in the insert wedge. Tap the wedge down to loosen the insert. Slide the profile insert out.



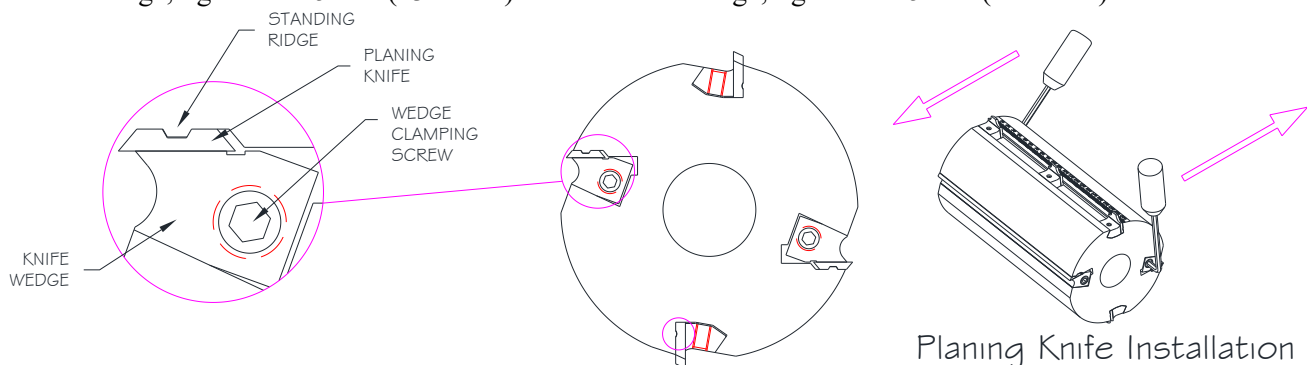
PROFILE INSERT REMOVAL

Clean the Tool

Once inserts and knives are removed, clean the tool and insert slots with compressed air. If more cleaning is necessary to remove build-up, use hot water or a cleaning solvent.

Planing Knife Installation

The planing knife that was removed can be flipped 180° to use the second cutting surface of the knife. If both cutting edges are worn or the knife is damaged and won't seat properly, replace the knife. Slide the knife into the slot, making sure the standing ridge on the cutter is within the groove of the knife, until it is flush with the end of the cutter body. **Simultaneously tighten from both sides the knife wedge clamping screws in two stages.** In the first stage, tighten to 15 Nm (132 lb-in). In the second stage, tighten to 25 Nm (221 lb-in).



Planing Knife Installation

Profile Insert Installation

Slide the insert in the slot, making sure the standing ridge of the cutter is within the groove of the insert. Tighten the set screw enough to hold the insert in place. Using a torque wrench with a hex bit torque the set screw to the correct torque specified in *A00182 – Torque Specifications*. **Note: Ensure you use the correct torque based on the cutter body material.**

