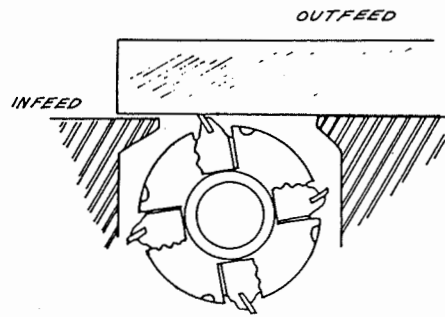


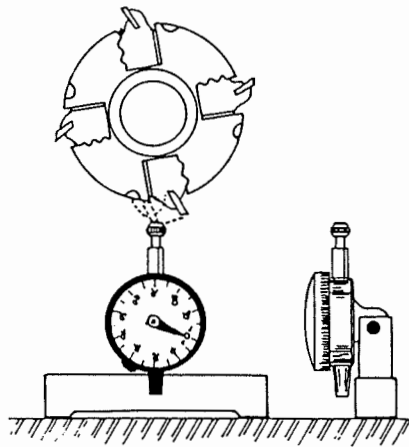
1



LOWER CUTTER HEAD

USE STRAIGHT EDGE

2

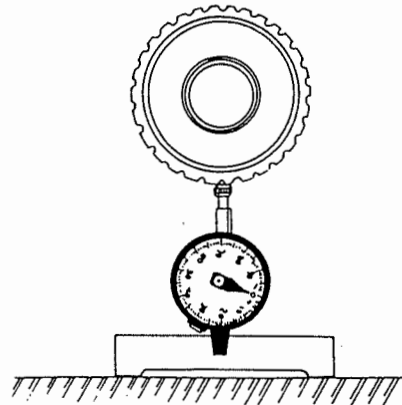


UPPER CUTTER HEAD

DIAL SETTING: .000

3

NOTE: SET SECTIONAL INFEED ROLL BEFORE SETTING CHIP BREAKER.

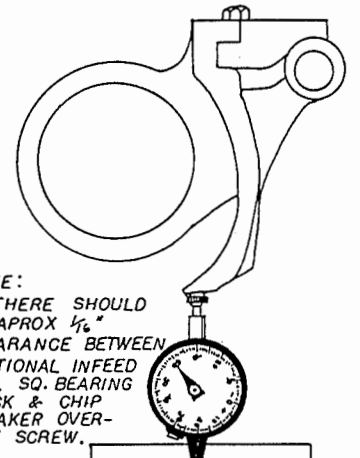


SECTIONAL INFEED ROLL

ADJUST ROLL ON CUTTING CIRCLE

4

DATE	BY	REVISION RECORD	APPR.	DR.	CHK.
8-23		chip settings, over-ride screw			

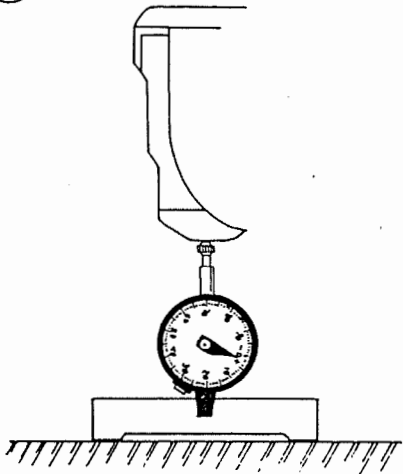


NOTE:  
THERE SHOULD BE APPROX 1/16" CLEARANCE BETWEEN SECTIONAL INFEED ROLL SQ. BEARING BLOCK & CHIP BREAKER OVER-RIDE SCREW.

CHIP BREAKER

ADJUST BREAKER 1.5MM ABOVE KNIVES

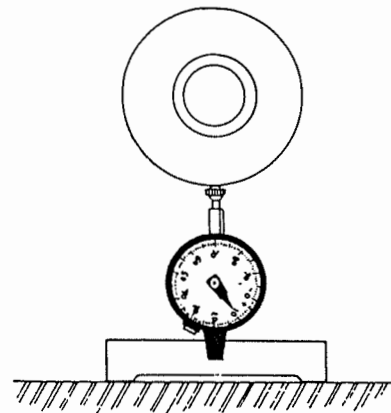
5



PRESSURE BAR

ADJUST BAR .05MM ABOVE KNIVES

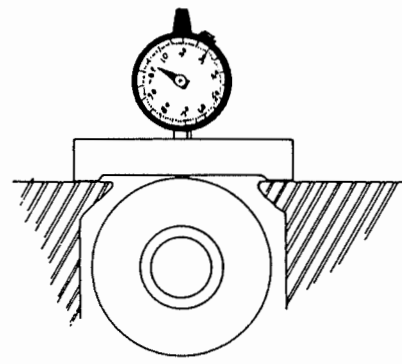
6



TOP OUTFEED ROLLER

ADJUST ROLLER .25MM BELOW KNIVES

7



BOTTOM ROLLER

ADJUST ROLLER .1MM ABOVE TABLE

NOTE:  
THE MEASUREMENTS GIVEN ARE BEGINNING SETTINGS BEFORE TESTING. THEY MAY NEED ADJUSTING.

**METRIC**

NORTHFIELD FOUNDRY & MACHINE CO.  
P.O. BOX 140  
NORTHFIELD, MINN. 55057

TOLERANCES (EXCEPT AS NOTED)	NORTHFIELD FOUNDRY & MACHINE CO		
DECIMAL	240 PLANER	SCALE	DRAWN BY <i>Janis</i>
±			APPROVED BY
FRACTIONAL	TITLE		
±	ADJUSTMENT INSTRUCTIONS		
ANGULAR	DATE	DRAWING NUMBER	
±	8-23-78	240-541	