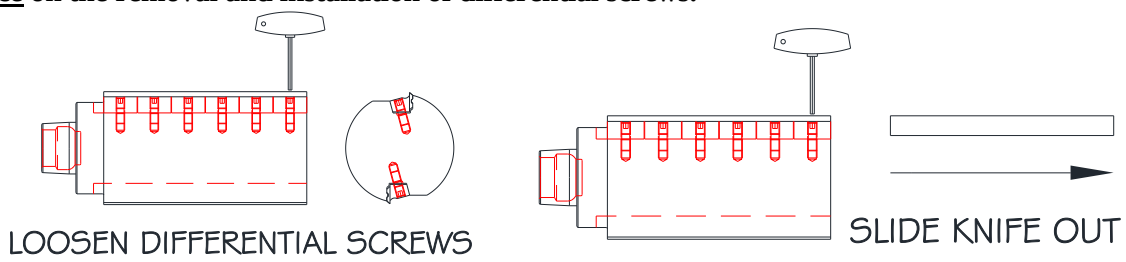
Great Lakes
Custom Tool Mfg., Inc.
Your American Cutting Tool Partner
Phone: 800-873-4528

Planing Knife Differential Wedge Screw Cutter instructions

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

Planing Knife Removal

Loosen the differential screws in the wedges one turn. It is not necessary to remove the wedges and screws. With the screws and wedges loosened, slide the knife out of the cutter. **Note: It is recommended to reapply anti-seize to the differential screws after every other blade replacement. Refer to A00187 – Differential Screw Maintenance on the removal and installation of differential screws.**

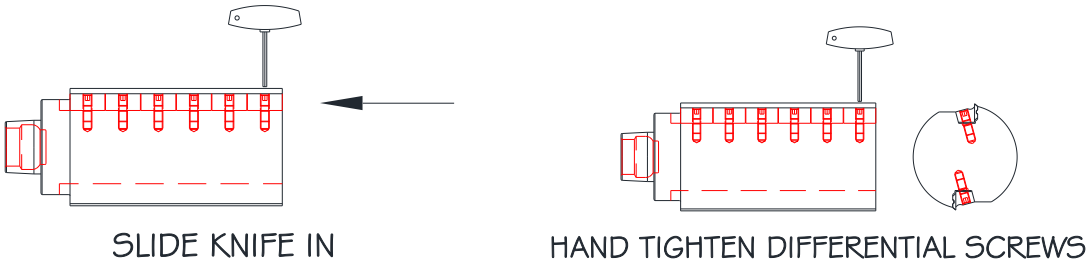


Clean the Tool

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

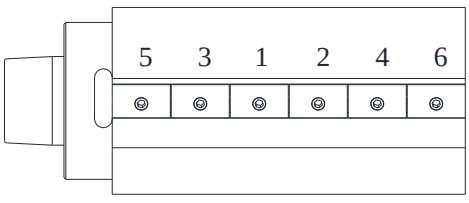
The planing knife that was removed can be flipped 180° to use the second cutting surface of the knife. If both cutting edges are worn or the knife is damaged and won't seat properly, replace the knife. Slide the knife into the slot, making sure the standing ridge on the cutter is within the groove of the knife, until it is flush with the end of the cutter body. Tighten the screws to hold the knife in place. Torque the differential screws following the instructions below.



Differential Screw Torque Instructions

1. After hand tightening the differential screws, use a torque wrench to tighten each screw to the correct torque values as listed in ***A00182 – Torque Specifications***. **Note: Ensure you use the correct torque based on the cutter body material.** Tighten each screw a small amount at a time following the tightening sequence below. **Do not** tighten the screw directly to the torque value listed. Tightening each screw a small amount at a time applies equal pressure to the wedges and helps keep knife precisely in place. (Note: The torque values listed are Anti-Seize lubricated torque values. Never torque a screw without Anti-Seize to this amount, false torque and/or failure could occur.)

2. After all the differential screws in one wing are fully torqued, move to the other wing directly across the cutter body and tighten those screws. Follow this pattern until all the differential screws on all the wings are tight.



Tightening Sequence for Wedges