

Moulder set-up Procedures

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- 1) Open moulder to tool change position
- 2) Lockout/tagout
- 3) Remove all necessary guards and place on jointer table
- 4) Start at the tail end of the machine and change all necessary tools
- 5) Start at last bottom and work forward:
 - a) Last bottom head
 - ✓ Set radial position
 - ✓ Set axial position
 - ✓ Adjust bedplates to within an 1/8" of the cutting circle
 - b) Top head
 - ✓ Set axial position
 - ✓ Adjust pressure shoe to tool radius
 - ✓ Adjust chipbreaker to the same height as pressure shoe using a straight edge
 - ✓ Adjust both the pressure shoe and chipbreaker horizontally to within a 1/4" of the cutterhead
 - ✓ Lift both the pressure shoe and chipbreaker and rotate the cutterhead to ensure the tool spins freely
 - c) Left side head
 - ✓ Set axial position
 - ✓ Adjust outfeed fence (set loose) and chipbreaker tangent to the tool radius
 - ✓ Pull on chipbreaker and rotate cutterhead to ensure the tool spins freely
 - d) Right side head
 - ✓ Set axial position
 - ✓ Set radial position
 - ✓ Adjust fences to within an 1/8" of the cutting circle
- 6) Add/remove feed rollers where necessary (note proper rotation)
- 7) Unlock machine
- 8) Set the radial position for the top and left side spindles
- 9) Push in both e-stops and rotate each spindle to ensure they all spin freely
- 10) Pull out e-stops and start each spindle in order, starting with the last spindle first.
- 11) Jog first component through the machine and check for specification
- 12) Make any necessary adjustments and turn feed rolls on to continuous feed and begin feeding components

Remember to occasionally check component specifications as you are running.