Moulder set-up Procedures
Bobby Ammerman, Extension Specialist

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 ¼” 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.