

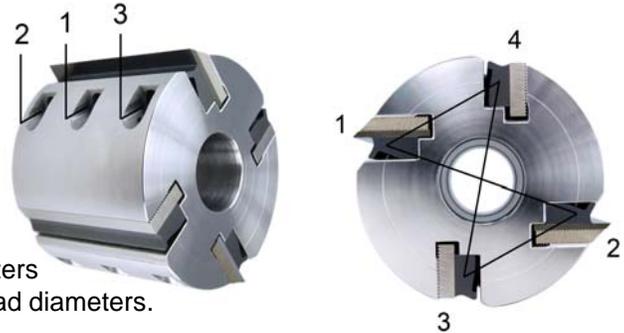
Titan Corrugated Moulder Head Assembly and Operation Instructions

(Conventional and Dual hook corrugated pocket style moulder heads)

16-60°Corrugated Knife Installation:

- 1) Remove dirt and debris from gibs, gib bolt sockets, and from the cutter-head corrugations.
- 2) Insert the knife into the bottom of the pocket of the cutter-head making sure the corrugations lock into the same corrugation elevation for each knife. Align the edge of the knife flush with the axial reference side of the head – keep in mind the knife steel might be cut slightly out of square. Never extend the knife protruding more than 5/16" outside the end of the head.
- 3) Insert the gib and lightly tighten the center gib bolt first to prevent the knife from moving as the screw is tightened. Lightly hand tighten the rest of the bolts just enough to prevent the knives from moving and the next knife is installed.
- 4) Tighten the clamping bolts from the middle bolt outwards and then proceed to successive knife pockets in a criss-cross pattern 180 degrees apart so that the bore is not distorted out of round. If a straight bore moulder head won't fit over the spindle the bolt must be loosened and re-tightened properly. The required tightening torque:

- M10 bolts (5mm hex key) = 19 ft/lbs – Smaller head diameters
- M12 bolts (6mm hex key) is 25 ft/lbs – Medium & larger head diameters.



Note: Never run moulder heads with empty pockets. Always use filler wedge steel in empty knife pockets.

Be sure not to mix up the gibs as they must be used in the pocket they are designed for. Dual hook head gibs are stamped with a 12 or 20 to indicate if they fit the 12 or 20 degree knife pocket. Examine the gib bolt threads and use oil or thread lubricant as needed. Do not use WD40 on gib bolts; it can add thread friction and decrease knife clamping pressure. Do not over tighten gib bolt.

- 5) To remove the knife; release the tension from the bolts and slide the gib out from the end and remove the knife. Wear gloves when handling cutter heads and knives to protect against hand cuts.

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Operation of Titan Corrugated Cutter Heads:

- 1) For safety reasons, the maximum vertical adjustment of the knife bottom must not ever exceed the center line of the gib screws or the knife can flutter in the cut or come out! A machined line on each end of the cutter head indicates the maximum point the bottom of the knife can be raised in the knife pocket.
- 2) When selecting a knife steel thickness be sure the profile depth of cut does not exceed 3 times the thickness of the knife to avoid knife breakage. Most Titan heads can accommodate steel up to 10mm thick.
- 3) Insert knives into successive pockets 180 degrees opposite of each other. Be sure knives and hardware are cross balanced to within 0.1 grams (0.0035oz) to avoid spindle vibration.
- 4) Use all bolts when clamping knives, gibs and filler wedge steel in the heads. Avoid using short knives in long heads if the gib bolts cannot push against a portion of the knife that is behind the gib.
- 5) Install hardened filler wedge steel into empty knife slots.
Never run a cutter head with empty pockets!
- 6) Only use Titan replacement parts in Titan brand cutter heads. Never exceed the maximum RPM engraved on the tool body.

