



INSTRUCTION SHEET

Model W1718

Spiral Cutterhead Planer

INTRODUCTION

The Model W1718 is the same planer as the Model W1683 with the upgrade of the spiral cutterhead.

The spiral cutterhead consists of 96 indexable carbide inserts. Each insert has four cutting edges, which can be easily rotated if the current cutting edge becomes dull or damaged.

In addition, a reference dot is in one corner of each insert face to indicate when that insert has been rotated. After all four edges have been used, the dot will be back to its original position and replacement of the insert will then be necessary. Note—*To avoid confusion about which edges are sharp, always rotate inserts clockwise.*

INVENTORY

For the Model W1718, use the inventory list from the Model W1683, but exchange the parts below for the knife setting jig:

- Torx T-Handle Wrench1
- Flat-Head Torx Screws 20
- Torx Bits T20 10
- Indexable Carbide Inserts5

REPLACING or ROTATING INSERTS

To replace or rotate the inserts, do these steps:

1. **UNPLUG THE PLANER**, and open the top cover to access the spiral cutterhead.
2. Clean out the heads of the indexable insert Torx screws that you wish to replace or rotate.
3. Remove the Torx screw, replace or rotate the cutter, lubricate the threads of the Torx screw with a light machine oil, and torque the screw down to 50 in/lb (inch pounds).

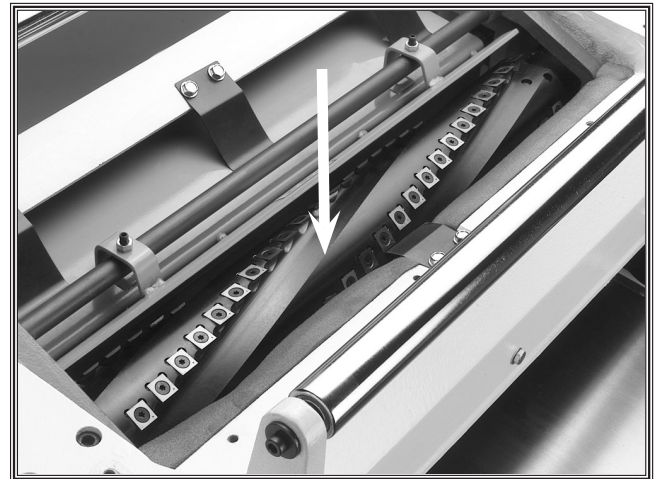


Figure 1. Spiral cutterhead.

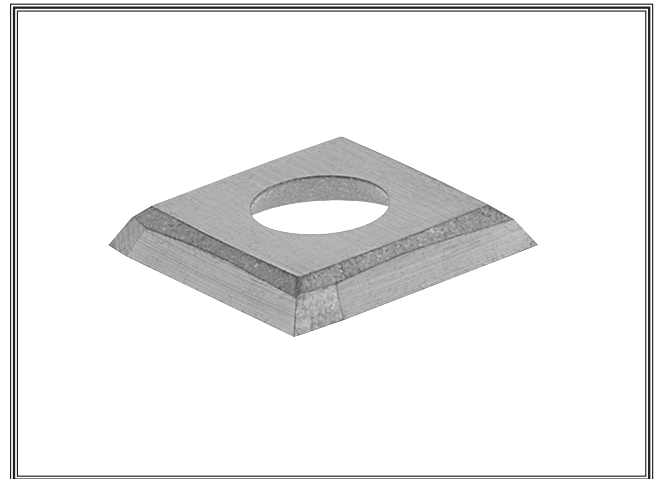


Figure 2. Indexable carbide insert.

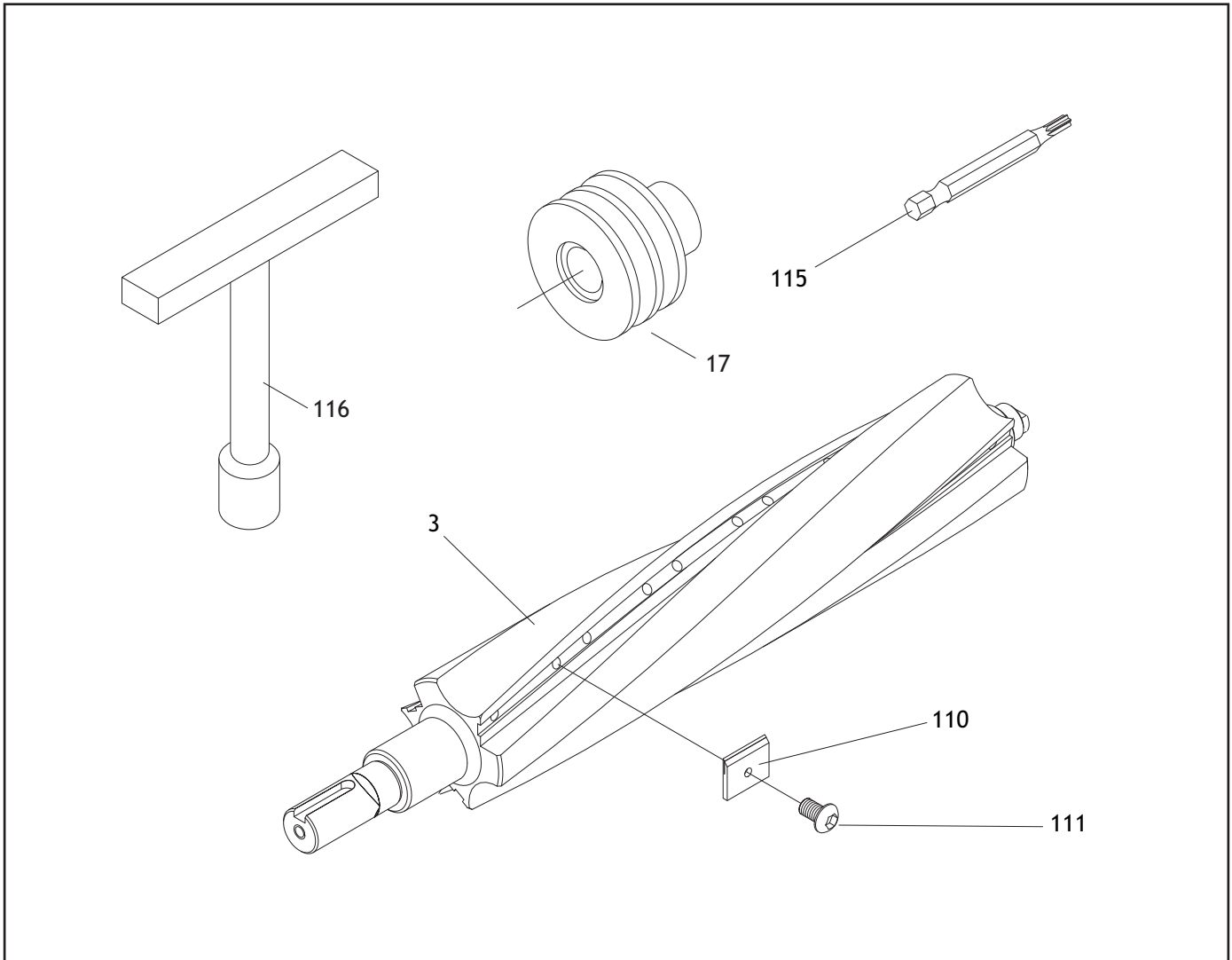
NOTICE

Make sure there is no wood dust or debris under insert when replacing it.

NOTICE

Over-tightening Torx screws may cause damage to the cutterhead!

W1718 Replacement Parts



REF	PART #	DESCRIPTION
3	X1718003	SPIRAL CUTTERHEAD
17	X1718017	MOTOR PULLEY
110	X1718110	INDEXABLE CARBIDE INSERT
111	XPFH15M	FLAT HD TRX T20 M6-1 X 16
115	X1718115	TORX BIT T20
116	X1718116	TORX T-HANDLE WRENCH

NOTICE

All parts for the Model W1718, except those shown above, are the same as the Model W1683. Therefore, please use the included Model W1683 manual when ordering new parts for your machine, unless those parts are shown above.

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