FORM 2481
MP260 HELICAL TOP CUTTER KIT INSTALLATION INSTRUCTIONS

Part No. THH260.TC-A

REF	DESCRIPTION (♦ Indicates Parts Available in Assemblies Only)	PART #	QTY.	
	Kit, MP260 Helical Top Cutterhead	THH260.TC-A	1	
	Cutterhead, Helical W/80 Tip HM-MP260 TC	THH260.TC	1	
	Screw, 10-32x1/2 FH BO; Torx Plus	F05004-325	1	
	Insert, HM 15x15x2.5 R=100 (10PCS)	TIK.19HM	1	
	Bearing, 6206 2RSR P6 Rolling	100787	2	
	Inst Sheet, MP260 Helical Cutter Kit	THH-2481	1	

DANGER! Disconnect and lock out power supply before performing any maintenance work, cleaning, or servicing the planer/moulder. Failure to do so will result in death or serious injury.

WARNING! Wear hand protection while servicing the Planer/Moulder knives.

NOTICE Utilize two people to perform cutter removal/installation.

THE CUTTER HEAD REPLACEMENT PROCESS REQUIRES REMOVAL OF MANY HARDWARE PARTS. ORGANIZE THEM AS THEY ARE REMOVED TO PREVENT REINSTALLATION ERRORS.

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FIG. 1

Remove Covers

1. Lift top cover.
2. Use hex key to loosen (5) screws on chain cover.
3. Pull cover back from top and lift slightly to remove as shown in FIG. 2.
4. Use hex key to loosen (4) screws on rear belt cover.
5. Lift cover slightly to remove as shown in FIG. 3.

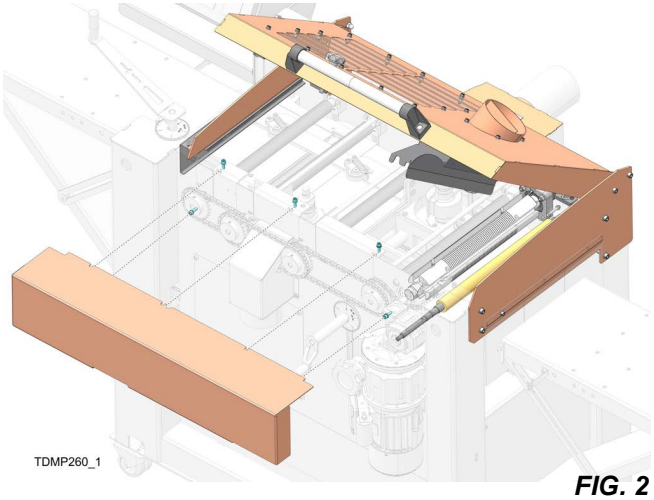

FIG. 2

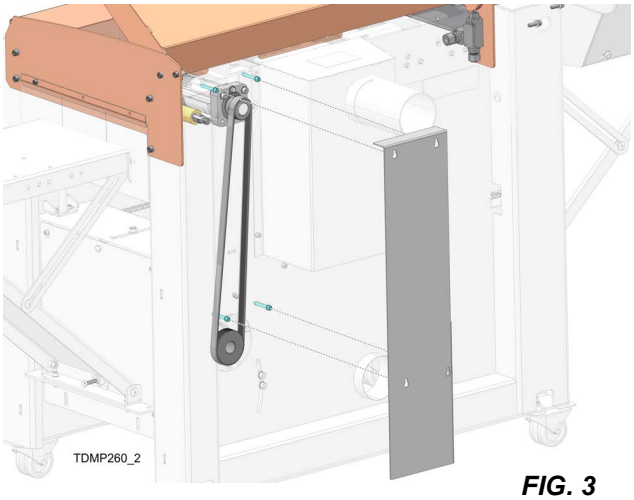

FIG. 3

Remove Feed Drive Assembly

NOTICE: The drive assembly power cord will not reach floor when connected. Place a sturdy object in front of machine on which to rest removed assembly.

1. Use wrench to loosen nut on end of feed roller shaft.
2. Carefully slide drive assembly off of shaft and place on sturdy surface. See FIG 4.
3. Remove lock washer from inside of collar.
4. If shaft keys are loose, set aside for safe keeping.

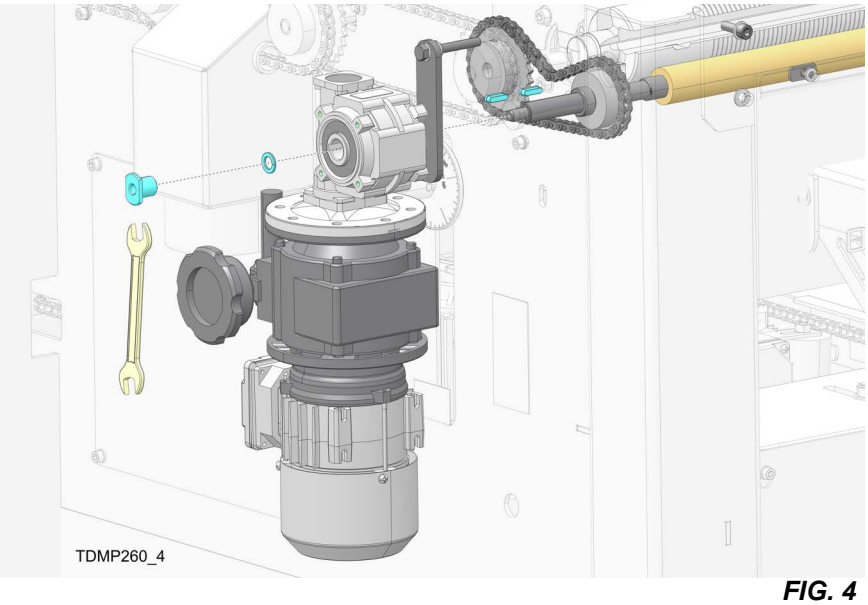

FIG. 4

Remove Drive Belt and Pulley

NOTE: The hardware used to secure drive mounting plate may vary from pictured based upon model.

1. Loosen hardware securing lower drive pulley mount.
2. Firmly grip the drive belt.
3. Rotate belt counter-clockwise while pulling belt off of top pulley. See FIG. 5.
4. Set belt aside.

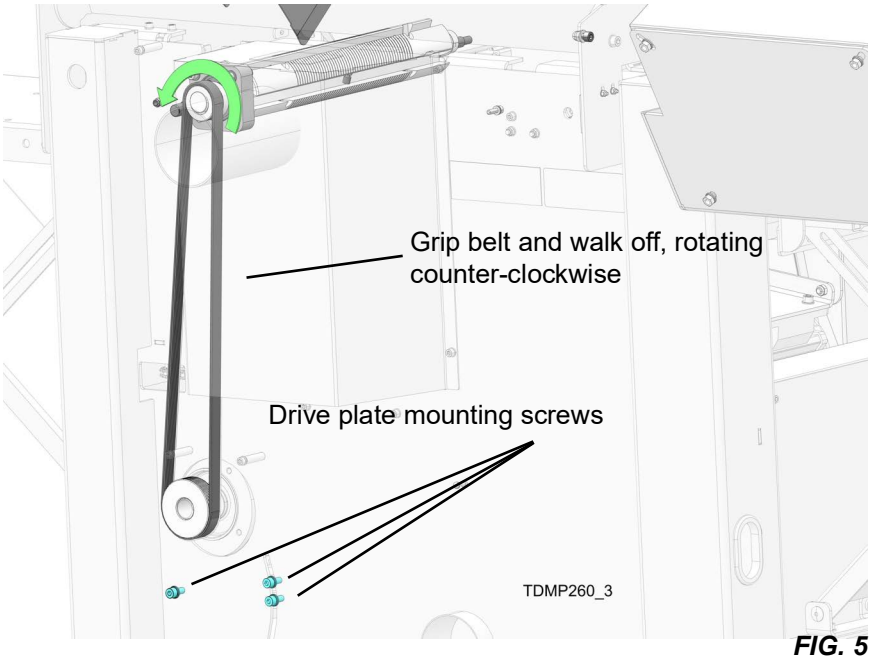

FIG. 5

5. Remove set screw from pulley on backside of cutter head shaft.
6. Remove pulley from shaft. See FIG. 6.

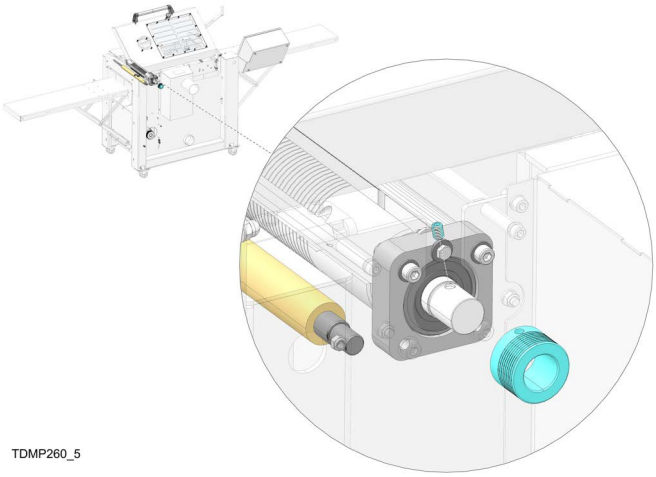

FIG. 6

Remove Feed Chains

1. Loosen tension bolt to create slack in feed chain #1. See FIG. 7.
2. Locate master link on feed chain #1.
3. Use a flat-head screw driver to push master link clip off of link pins. See FIG. 7.

   NOTE: The direction of the clip should be noted. The clip will be reinstalled in the same direction in a later step.
4. Remove side plate from link.
5. Pull master link from chain.
6. Remove chain from sprockets.
7. Repeat steps 1-5 to remove Feed Chain #2.

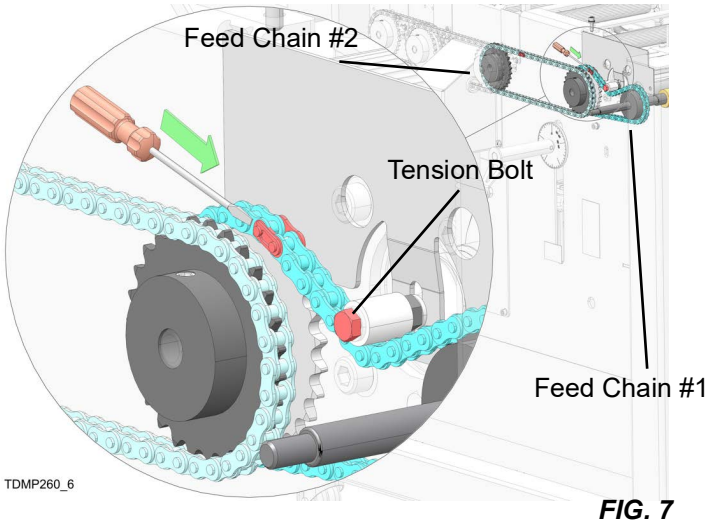

FIG. 7

Access Bearing Housing Bolts

1. Loosen (2) M8 hex set screw from (2) sprockets as shown.
2. Slide sprockets off of feed roller shaft.
3. Remove (2) M6 hex screws.
4. Remove tension plate bracket.

NOTE: Sprockets and tension plate must be removed to access bearing housing bolts.

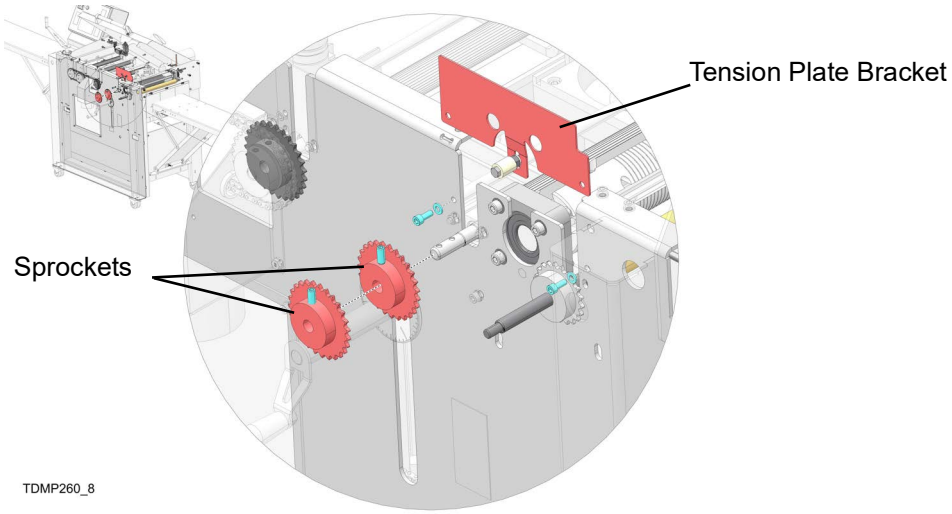

FIG. 8

Detach Slide Block Assemblies

1. Use box wrenches to remove (2) nuts, (2) flat washers, and (2) bolts from front slide block assembly.
2. Repeat step for rear slide block assembly. See FIG. 9.

NOTE: Feed roller will not be removed from the machine. It only needs to free float to allow space for cutter head removal.

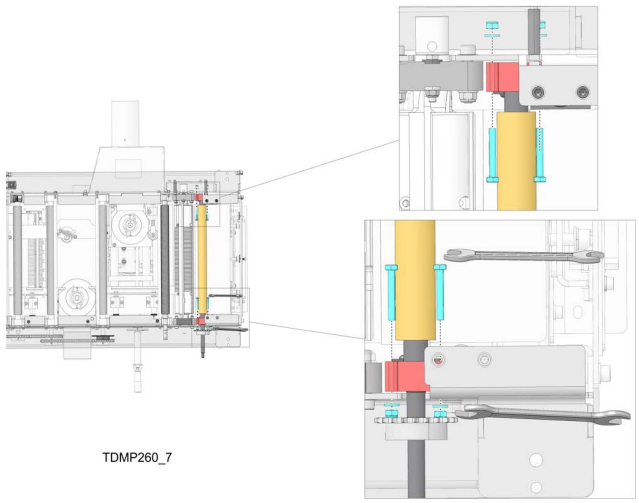

FIG. 9

Remove Bearing Housing Bolts

1. Use wrench and hex key to remove (4) nuts, (8) flat washers, and (4) M8 HSH screws from front side cutter bearing housing as shown in FIG. 10.

   NOTE: Lower right screw can only be accessed and removed by adjusting detached feed roller out of the way.

2. Repeat step for bearing housing at machine rear side as shown in FIG. 11.

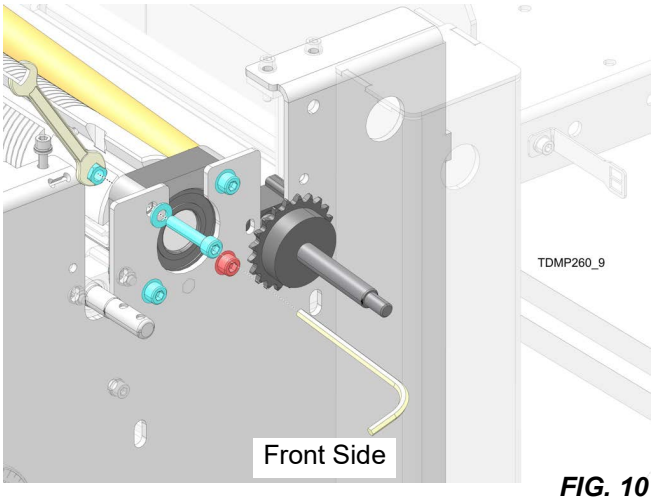

FIG. 10

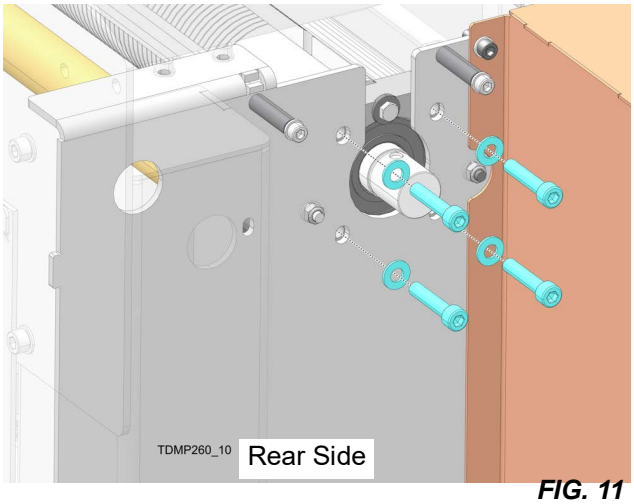

FIG. 11

Remove Cutter Assembly

1. Rotate cutter assembly toward feed roller and lift out of machine.

   NOTE: The cutter assembly is tightly fit in the machine. Careful maneuvering will be required to clear the cutter from the machine.

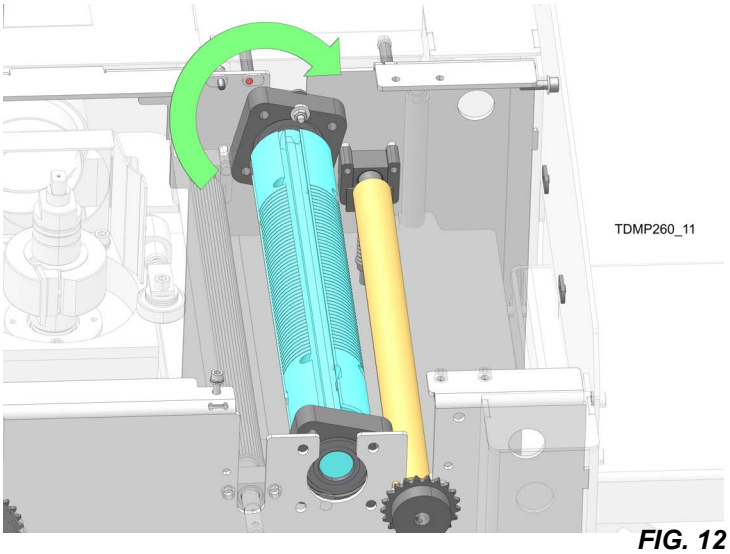

FIG. 12

Remove Bearing Housing

1. Remove nut, bolt, and (2) flat washers from each bearing housing. See FIG. 13.
2. Use a rubber mallet to knock housing off of each end of cutter shaft.
3. Knock out bearing from housing.

   NOTE: Bearings can be discarded. Helical Cutter Kit includes (2) new bearings.
4. Leave (2) O-rings in each housing for reuse.

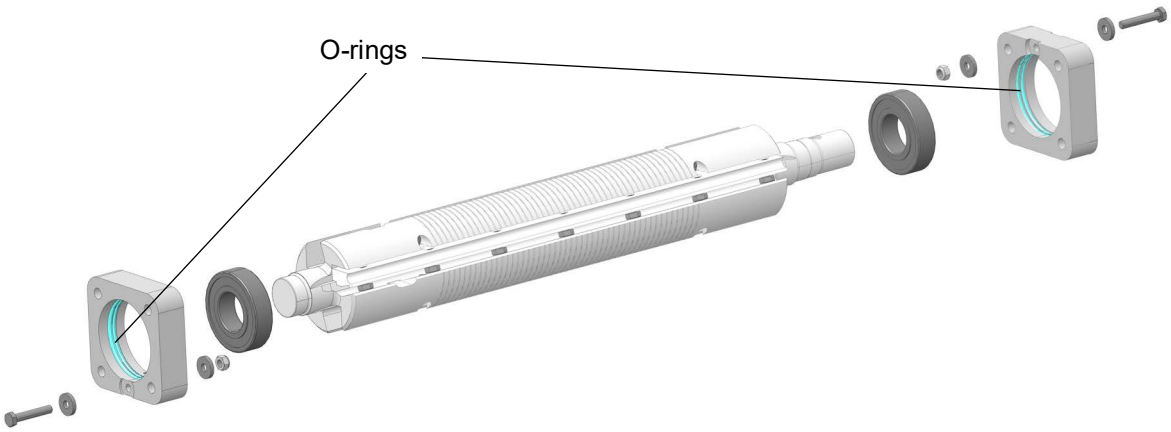

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FIG. 13

Install New Bearings

1. Use rubber mallet to seat (1) bearing on short end of cutter shaft.
2. On long end, use mallet and (2) 1 5/8” OD x 1 1/2” bushings to seat bearing fully onto shaft as shown in FIG. 14.

   NOTE: Bushings are included with MP260 Additional Part Kit. If bushings are not available, use a similar object.

   Bushings will not stay on shaft after bearing is seated.
3. Slide bearing house on each seated bearing. O-rings must stay in housing grooves to secure bearing.

4. Install nut, bolt, and (2) flat washers on each bearing housing. See FIG.15.

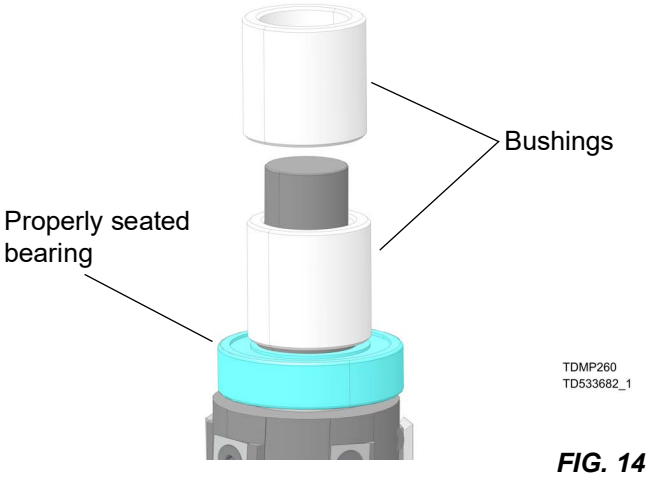

FIG. 14

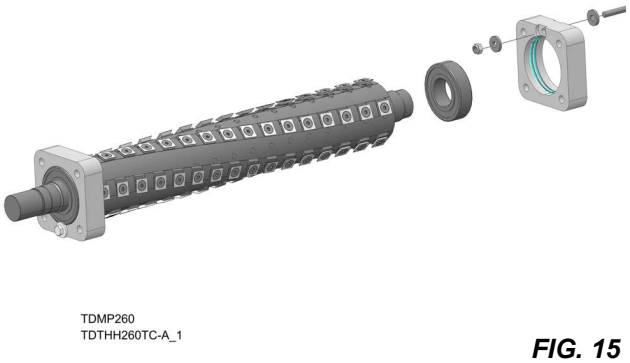

FIG. 15

Install New Cutterhead Assembly

1. Place cutterhead assembly into machine and align housing holes with mounting holes as shown in FIG 16.

2. Install (4) nuts, (8) flat washers, and (4) M8 HSH screws to loosely attach each cutter bearing housing to machine as shown in FIGS. 17 and 18.

   NOTE: Before tightening, the cutterhead assembly must be parallel to table below.

3. Place level object below cutterhead and raise table to support the cutterhead.

4. Use wrench and hex key to tighten (8) nuts and hex screws on both bearing housings.

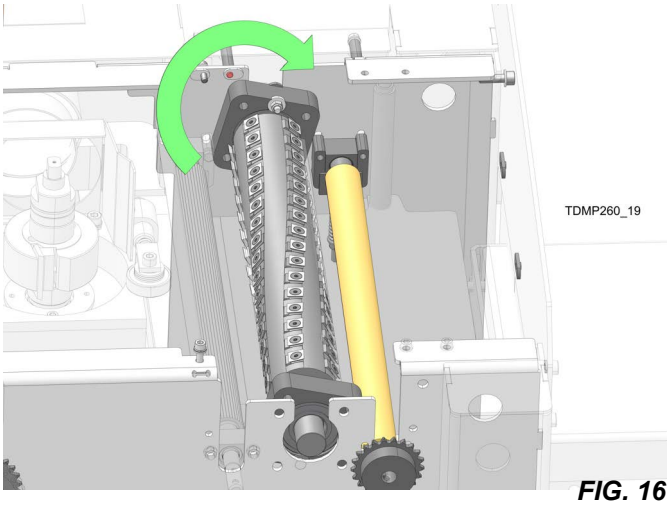

FIG. 16

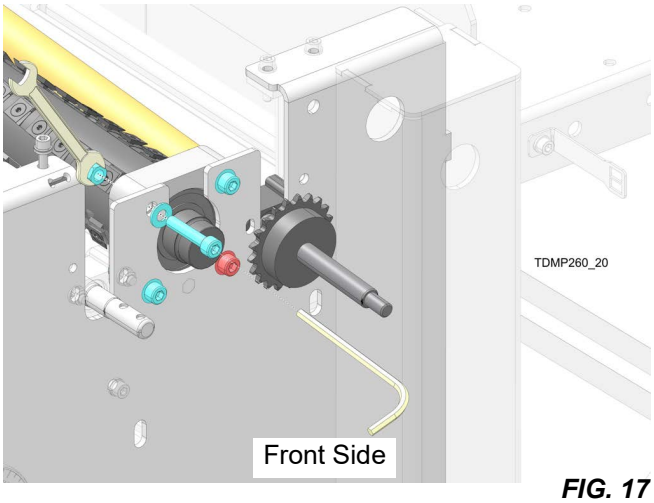

FIG. 17

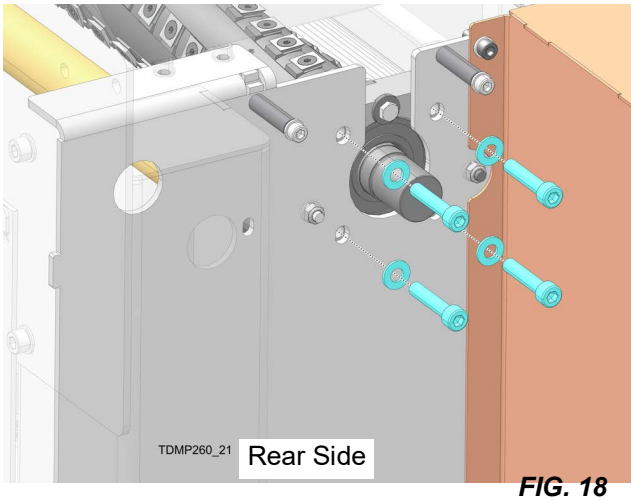

FIG. 18

Reattach Slide Block Assemblies

1. Use box wrenches to fasten (2) nuts, (2) flat washers, and (2) bolts front slide block assembly to machine. See FIG. 19.

2. Repeat step for rear slide block assembly.

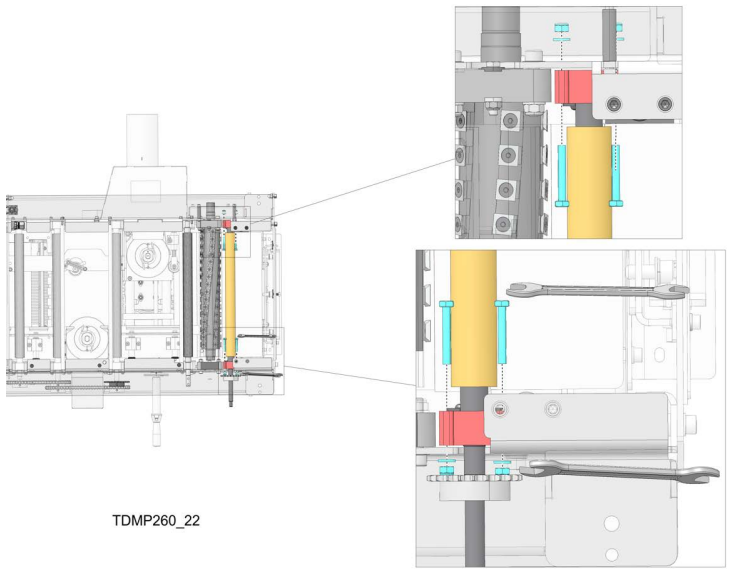

FIG. 19

Attach Sprockets and Tension Plate

1. Attach tension plate bracket using (2) M6 socket head cap screws and (2) flat washers as shown in FIG. 20.

2. Slide sprockets onto feed roller shaft.

3. Tighten (2) M8 hex set screw into (2) sprockets as shown in FIG. 20.

NOTE: The shaft is grooved for set screws to seat into.

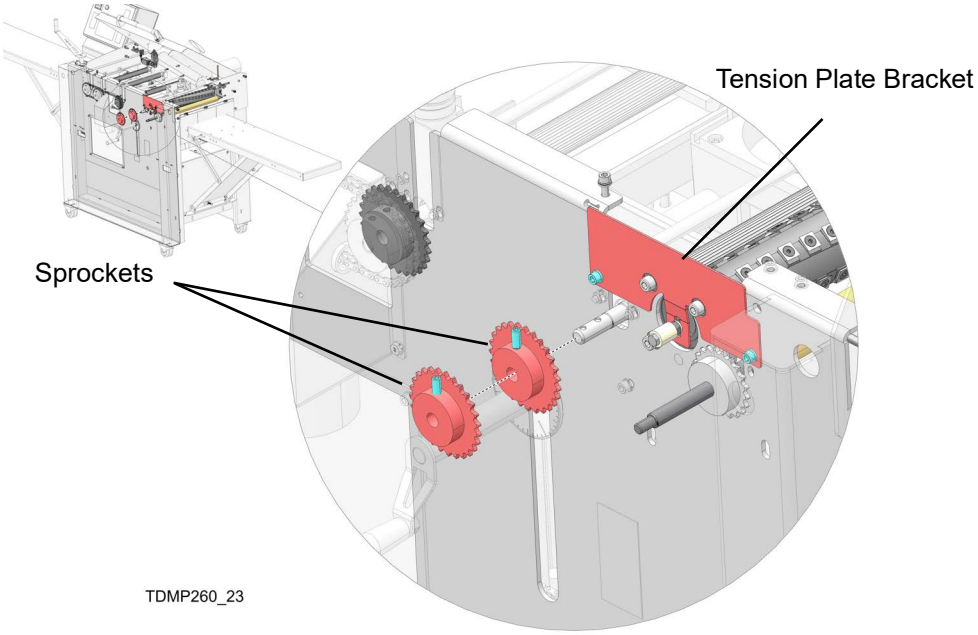

FIG. 20

Install Feed Chains

1. Route chain #1 around sprockets as shown in FIG. 21.

2. Install master link with clip opening facing left side of machine.

3. Use long-nose pliers to snap clip fully onto link pins.

4. Adjust tension bolt to apply tension to chain. See FIG. 21.

NOTE: Only tension to remove slack so chain will not skip.

5. Route chain #2 around sprockets as shown in FIG. 22.

6. Install master link with clip opening facing left side of machine.

7. Use long-nose pliers to snap clip fully onto link pins.

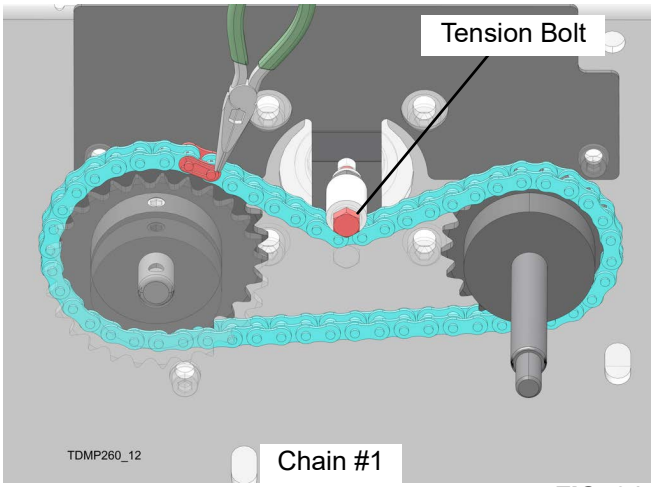

FIG. 21

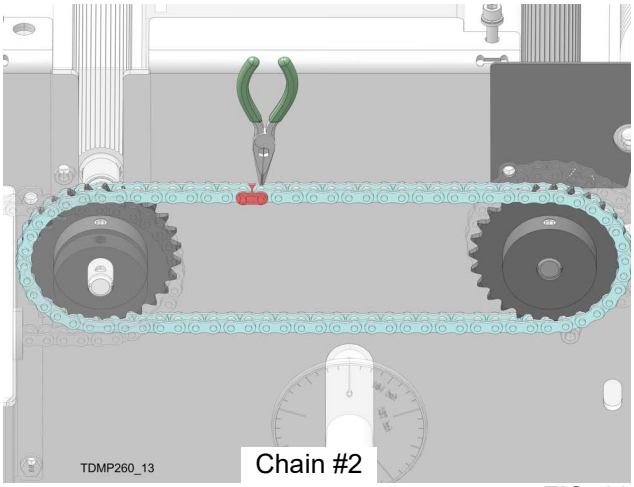

FIG. 22

Install Pulley and Drive Belt

1. Slide pulley onto cutterhead shaft.
2. Tighten set screw into groove in shaft. See FIG. 23.

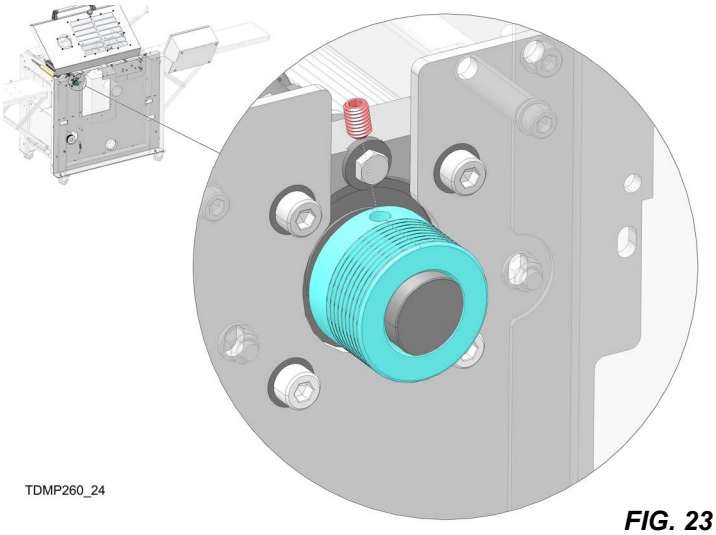

FIG. 23

3. Place belt onto lower drive pulley.
4. Walk belt onto cutterhead pulley while rotating clock-wise. See FIG. 24.

5. Tighten lower drive mounting fasteners.

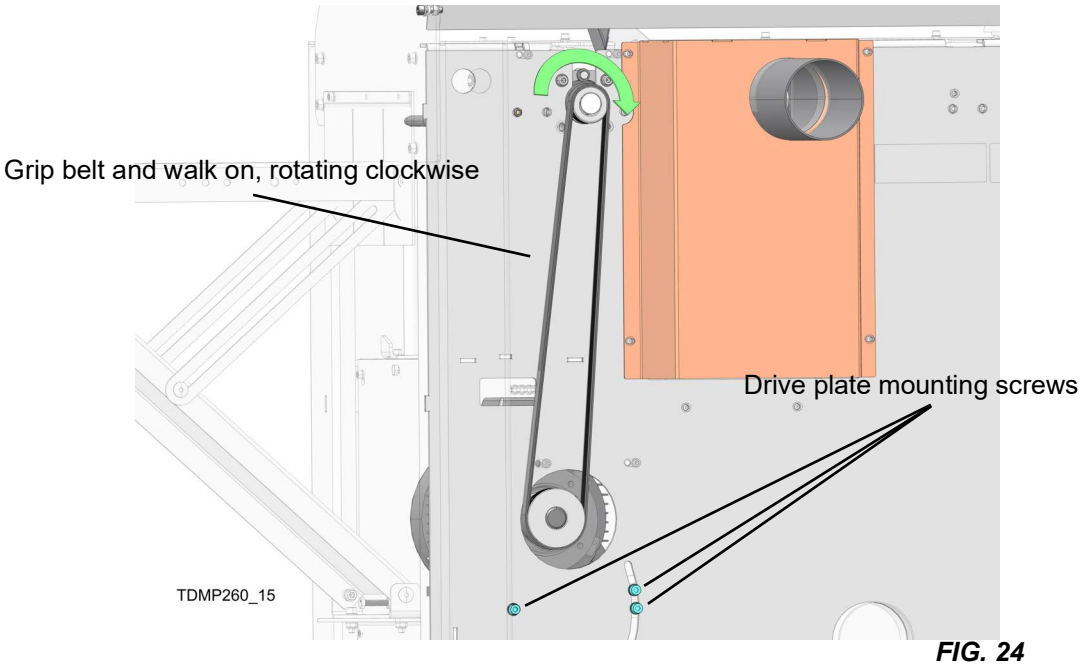

FIG. 24

Install Feed Drive Assembly

1. If removed in earlier step, insert shaft keys.
2. Slide drive assembly onto shaft.
3. Use wrench to tighten nut on end of feed roller shaft. See FIG. 25.

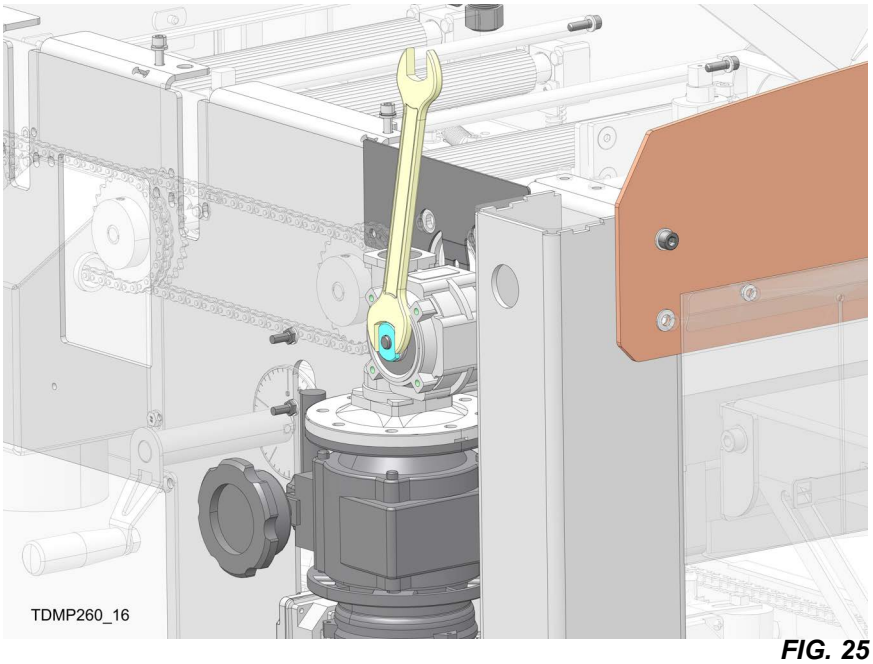

FIG. 25

Install Covers

1. Place rear cover over (4) hex screws and allow to slide down into place.
2. Tighten (4) screws with hex key as shown in FIG. 26.
3. Set chain cover over (2) lower screws and press forward onto (3) top screws.
4. Tighten (5) screws with hex key as shown in FIG. 27.
5. Lower top cover.

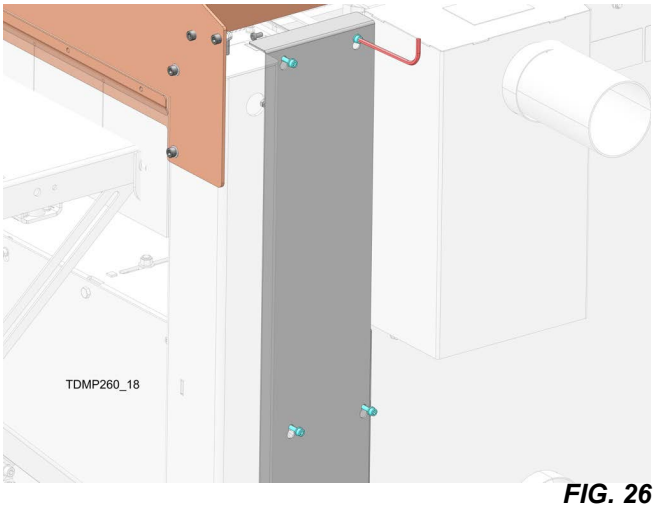

FIG. 26

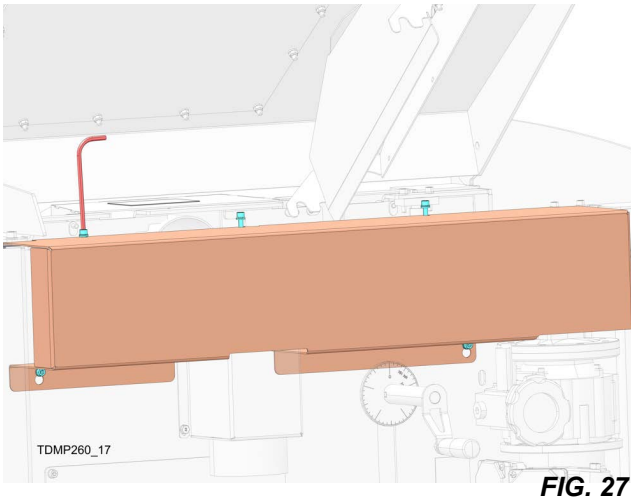

FIG. 27