

If clip or snipe appears at beginning of board:

- Pressure bar may be set too low
- Chipbreaker may be set too high
- Upper infeed roller may be set too high
- Lower infeed roller may be set too high
- Spring tension may be too light on pressure bar

If clip or snipe appears on long end of lumber:

- Pressure bar may be set too high
- Lower outfeed roller may be set too high
- Upper outfeed roller may be set too low
- Lumber may not be butted
- Grain may be running against knives

If knives tear out lumber:

- Feed may be too fast
- Joint on knives may be too heavy
- Moisture content of lumber may be too high
- Head may be running too slowly
- Cut may be too heavy
- Cutting angle may be too large
- Grain may be running against knives

If knives raise the grain:

- Joint may be too heavy – light joint best
- Feed may be too fast
- Cutting angle may be too large
- Head may be running too slowly
- Moisture content of lumber may be too high
- Cut may be too heavy

If chip marks appear on lumber:

- Blower system may not be strong enough
- Feed may be too fast
- May be loose connection in blower system – no suck power
- Exhaust pipe may join at too large an angle to main blower pipe

If panels are tapered across the width:

- Center table may not be set parallel with body of cylinder
- Grinding rail may not be set parallel with body of cylinder
- Center table may be worn

If undesired (pounded) glossy finish appears:

- Knives may be dull
- Feed may be too slow
- Joint may be too heavy

If washboard finish appears:

- Knives may have been driven back into the head
- Machine may be completely out of adjustment
- Joint may be too heavy

If revolution mark shows up:

- Knives may be ground poorly
- Knives may need jointing

If lines appear at right angles to the knife marks:

- Knives may have been checkered and nicked up by overgrinding and taking temper out of steel
- Chips may have wedged between rolls and tables
- Pressure bar may be dragging

If stock twist in machine:

- Pressure bar may be cocked
- Upper outfeed roll may have uneven spring tension on it
- Lower rolls may be cocked

If knife lifters must be replaced frequently:

- Jack screw may not be tight in slots and knives may drive back, shearing the lifters

If stock sticks or hesitates in machine:

- Pressure bar may be set too low
- Lower rolls may be set too low
- Upper rolls may be set too high
- Cut may be too heavy
- Coaxer board may help lumber through machine

If machine is noisy and vibrates and pounds:

- Knives may be too dull
- Machine may not be leveled up correctly
- Machine may not be on solid foundation
- Pulley belt may be jumping on pulley
- Pressure bar may be set too low

If morotes kick out:

- Knives may be dull, thus overloading motor
- Pressure bar may be set too low, putting drag on motor
- Motor may be drawing high current because other machinery in use in the plant has pulled down the voltage
- Machine may be out of adjustment
- Lower toll may be set too low

Please note: sometimes a particular machine is not suited for the job it is required to do. Also, many times a machine is worn beyond adjustment, and regardless of what is done to correct planing/molding difficulties, it cannot be made to do good work. These hints may help in some cases but not eliminate all problems in all machines.