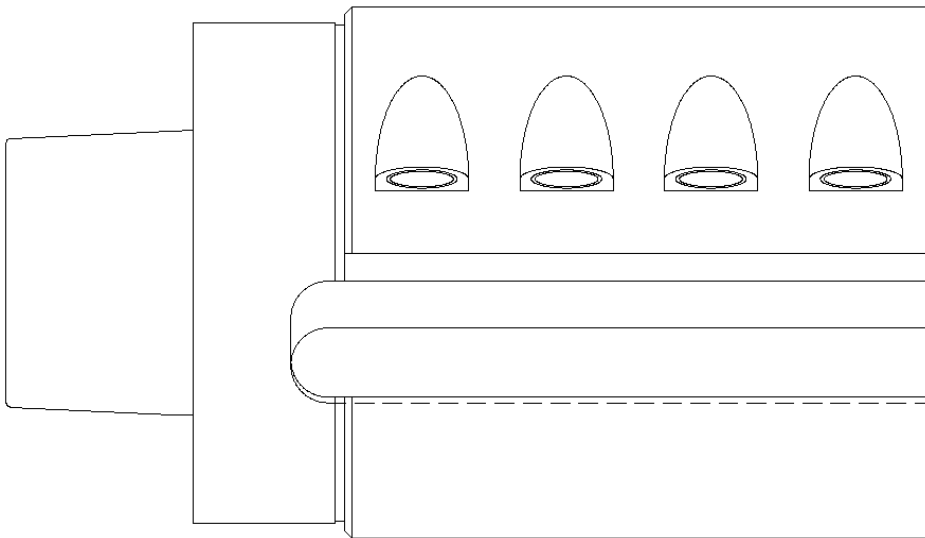


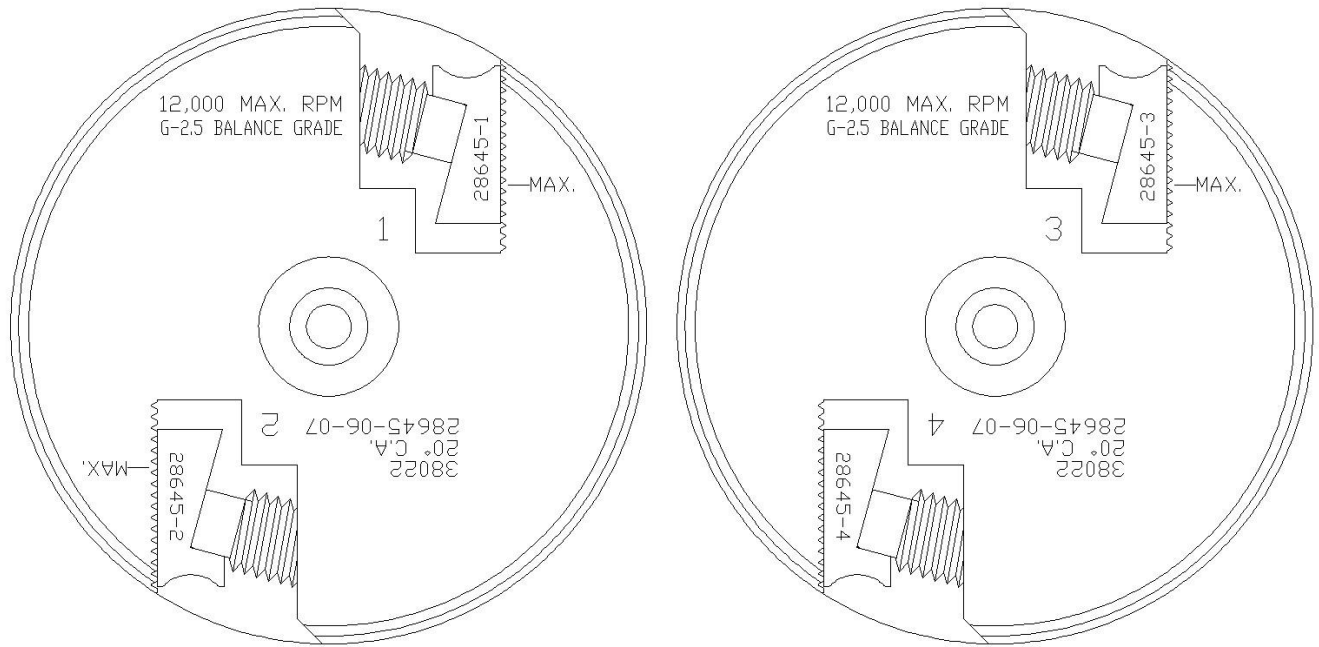
Corrugated Heads – HSK Type

03010A



“HSK” Corrugated Round Heads are manufactured to the highest standards and will meet or exceed operating specifications. As with any cutterhead, we recommend that care be taken to maintain the heads so that they are kept in good operating condition. This would include the following:

- 1. Be sure knives are balanced properly:** Knives should be balanced to within .1 gram or better.
- 2. Keep HSK taper clean:** It is very important that the internal clamping mechanism and the external taper and face on the heads be kept extremely clean in order to provide top working performance.
- 3. Keep head clean:** A clean head with no pitch or dirt build-up will run smoother and produce better finishes. Pitch build-up or out of balance knives will have an effect on the head running at its optimum.
- 4. Inspect heads for any damage:** Before any head is used visually inspect it for any damage or defects that may have occurred while handling, during the grinding process, or from general wear and tear. If any defects are discovered on the head body it is recommended that it be marked and separated from the other heads. The head should then be evaluated for possible reconditioning and balancing. It may be necessary to return it to the manufacturer for a full evaluation.
- 5. Corrugation Inspection:** A very common area where damage occurs is the top corner of the corrugation on each end of the head. This is usually caused by improper handling and may cause the knives to not seat properly in the corrugation and could affect performance.



6. **Use the correct gibs:** The head and gibs are marked with matching 5 digit order numbers with the gibs having an additional number to designate which knife slot it should be used in as shown below. It is recommended that the same gibs stay with the head and be used in the same knife slots they were originally balanced and supplied with. If the knives are properly balanced this will produce an assembly with the most precise balance. The order number with the month and year is engraved on the head body designating when the head was manufactured.
7. **Tighten the Gib Screws Properly:** When tightening the gib screws it is recommended that each wing be tightened incrementally from an initial snug up to a final torque of 25 ft.-lbs. By alternating the gib screw tightening process the stress buildup in the head body is held to a minimum and more evenly distributed preventing any head distortion.
8. **Maximum Knife Projection:** The same common sense rules apply as with standard corrugated heads when it comes to how far a knife can be safely projected from the head body. The following two rules can be used along with all other proper setup and safety procedures to help determine maximum knife extension.
 - a. Never grind a profile deeper than 3x the thickness of the knife.
 - b. There should be at least as much knife engaged inside the head as there is extended out from the head body.
9. **Do Not Exceed Recommended RPM:** Each head has its maximum RPM etched on the end. **It is very important that this not be exceeded.**