

HD25 & HDF15

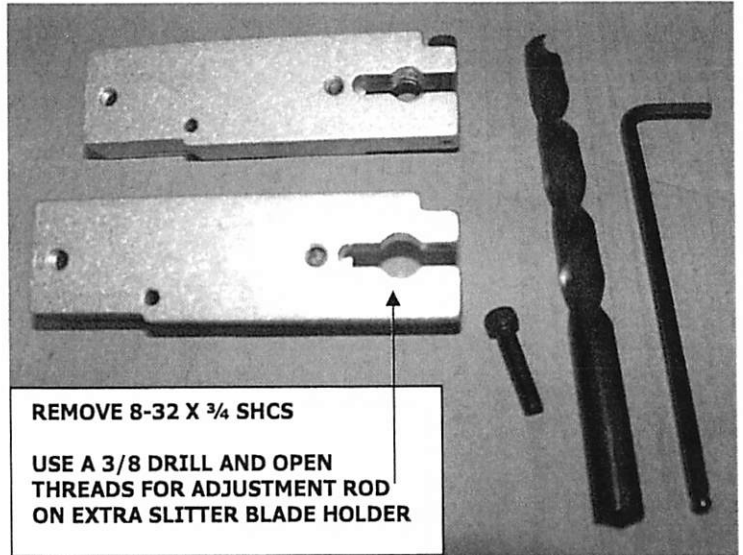
**EXTRA SLITTER BLADE
HOLDER OPTION**

**PREPARATION
PROCEDURES**

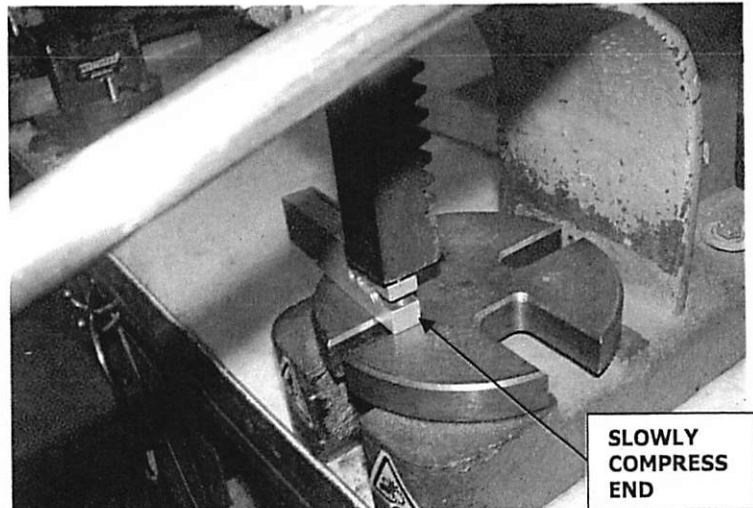
JANUARY 2018

HD25 EXTRA SLITTER OPTIONS

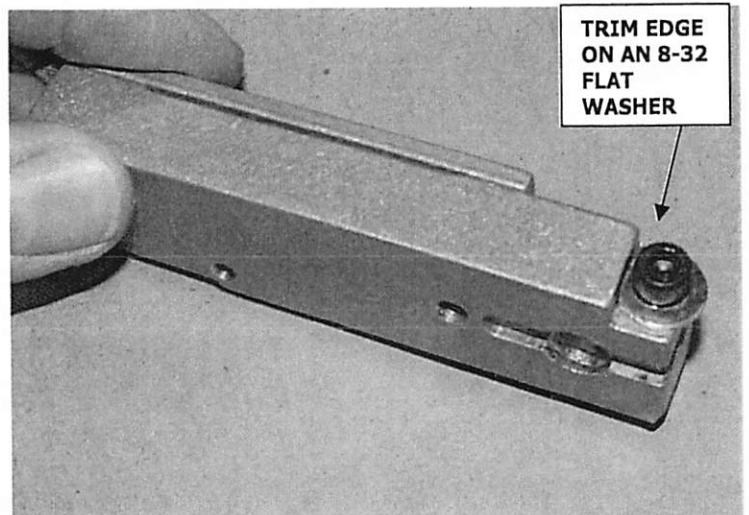
- 1) FROM RACK 22 TAKE THE NUMBER OF EXTRA KNIFE HOLDER COVER SUBS (H850 186.5) REQUESTED. REMOVE THE 8-32 X 3/4 SHCS ON UPPER END. USE A 3/8 DRILL AND REMOVE THE ADJUSTMENT ROD THREADS ON THE EXTRA BLADE HOLDERS. THE ADDITIONAL SLITTER BLADE HOLDERS MUST MOVE INDEPENDENTLY FROM THE SLITTER BLADE HOLDER THAT IS ALREADY WITH THE MACHINE AND MOVES BY WAY OF THE THREADED ADJUSTMENT ROD AND KNOB.



- 2) TEST MOVEMENT OF DRILLED SLITTER BLADE HOLDER ON A THREADED ADJUSTMENT ROD. IF THERE IS TOO MUCH MOVEMENT, THE ENDS OF THE DRILLED BLADE HOLDER CAN BE CAREFULLY COMPRESSED ON AN ARBOR PRESS. DO NOT OVER TIGHTEN. TEST BLADE HOLDER ON ADJUSTMENT ROD AGAIN. IT SHOULD BE MOVEABLE BUT WITH SOME DRAG.



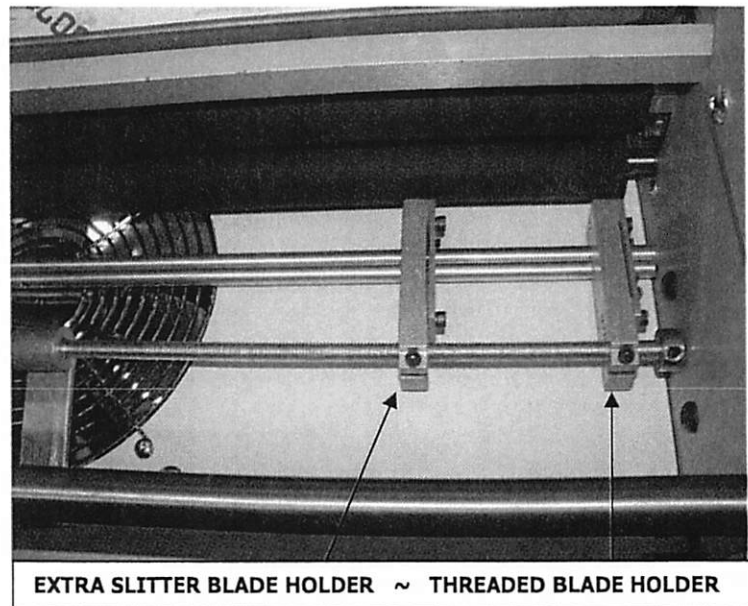
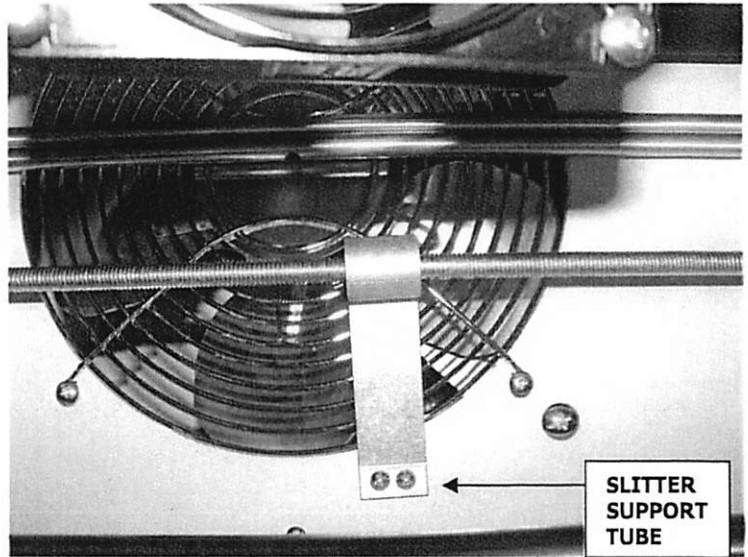
- 3) TEST THE BLADE HOLDER'S 8-32 THREADS WITH THE SHCS. COMPRESSING THE END MAY CHANGE THREAD ALIGNMENT. REOPEN THREADS WITH AN 8-32 TAP FROM THE BOTTOM UP. ADD A SMALL AMOUNT OF NICKEL ANTI-SEIZE TO THE 8-32 THREADS. SAND THE EDGE OF A #8 FLAT WASHER SO IT DOES NOT BIND ON THE SLITTER BLADE HOLDER END WHEN THE SHCS IS BEING TIGHTENED. PLACE THE FLAT WASHER ON THE 8-32 X 3/4 SHCS AND START IN THREADS.



- 4) REMOVE THE (2) PHILLIPS-HEAD SCREWS HOLDING THE SLITTER SUPPORT TUBE IN THE CENTER OF THE MACHINE. SLIDE SLITTER SUPPORT TUBE DOWN THREADED

ADJUSTMENT ROD. THE RODS SEPARATE. SLIDE DRILLED OUT, ASSEMBLED SLITTER HOLDER ONTO DESIRED THREADED ROD. RECENTER SUPPORT TUBE AND REPLACE (2) PHILLIPS-HEAD SCREWS.

- 5) THE OUTER SLITTER BLADE HOLDER THAT MOVES WITH THE ROD ADJUSTER THREADS MUST BE SET IN PLACE BEFORE THE INNER, DRILLED SLITTER BLADE HOLDER IS TIGHTENED ON THE ROD. TO SECURE DRILLED BLADE HOLDER, DETERMINE LOCATION AND TIGHTEN 8-32 SHCS ON THREADED ADJUSTMENT ROD.
- 6) ADD ANOTHER PACK OF (5) HOOK SLITTER BLADES (PRB031) AS09 TO THE ORDER, FOR EXTRA BLADE HOLDERS.



HD25 EXTRA SLITTER HEAD INSTALLATION INSTRUCTIONS

1. Remove two phillips-head screws which hold slitter support tube in center of machine.
Bar will separate.
2. Slide slitter head on to threaded bar along either side.
3. Place extra slitter heads into desired position and recenter support tube.
4. Tighten screws in once again (previously removed).