

**New Product**

# HSK CORRUGATED CUTTERHEADS FOR TODAY'S NEWEST MOULDERS



Our new HSK Cutterheads are made for today's newest moulders. Constructed from Alloy Steel with a hardened and ground HSK locking device, these heads are rated for 12,000 rpm and will run on any HSK machine. Made for 1/4", 5/16" and 3/8" thick knives, these 2 knife heads are available with a 12° or 20° cutting angle. Custom lengths, cutting angles and HSK arbors are available and are quoted on request. Speed tested and certified to run on high speed machines using this type of holding device.

| Cat No. | Width | Spindle | Cutting Angle | Price     |
|---------|-------|---------|---------------|-----------|
| MH300   | 60mm  | L/B     | 20°           | \$ 396.50 |
| MH301   | 80mm  | L/B     | 20°           | \$ 426.10 |
| MH302   | 100mm | L/B     | 20°           | \$ 451.80 |
| MH303   | 130mm | L/B     | 20°           | \$ 516.40 |
| MH304   | 150mm | L/B     | 20°           | \$ 541.70 |
| MH306   | 180mm | Bottom  | 20°           | \$ 581.40 |
| MH307   | 210mm | Bottom  | 20°           | \$ 651.60 |
| MH308   | 240mm | Bottom  | 20°           | \$ 696.90 |

| Cat. No. | Width | Spindle | Cutting Angle | Price     |
|----------|-------|---------|---------------|-----------|
| MH310    | 60mm  | R/T     | 20°           | \$ 396.50 |
| MH311    | 80mm  | R/T     | 20°           | \$ 426.10 |
| MH312    | 100mm | R/T     | 20°           | \$ 451.80 |
| MH313    | 130mm | R/T     | 20°           | \$ 516.40 |
| MH314    | 150mm | R/T     | 20°           | \$ 541.70 |
| MH316    | 180mm | Top     | 20°           | \$ 581.40 |
| MH317    | 210mm | Top     | 20°           | \$ 651.60 |
| MH318    | 240mm | Top     | 20°           | \$ 696.90 |

|       |       |        |     |           |
|-------|-------|--------|-----|-----------|
| MH320 | 60mm  | L/B    | 12° | \$ 396.50 |
| MH321 | 80mm  | L/B    | 12° | \$ 426.10 |
| MH322 | 100mm | L/B    | 12° | \$ 451.80 |
| MH323 | 130mm | L/B    | 12° | \$ 516.40 |
| MH324 | 150mm | L/B    | 12° | \$ 541.70 |
| MH326 | 180mm | Bottom | 12° | \$ 581.40 |
| MH327 | 210mm | Bottom | 12° | \$ 651.60 |
| MH328 | 240mm | Bottom | 12° | \$ 696.90 |

|       |       |     |     |           |
|-------|-------|-----|-----|-----------|
| MH330 | 60mm  | R/T | 12° | \$ 396.50 |
| MH331 | 80mm  | R/T | 12° | \$ 426.10 |
| MH332 | 100mm | R/T | 12° | \$ 451.80 |
| MH333 | 130mm | R/T | 12° | \$ 516.40 |
| MH334 | 150mm | R/T | 12° | \$ 541.70 |
| MH336 | 180mm | Top | 12° | \$ 581.40 |
| MH337 | 210mm | Top | 12° | \$ 651.60 |
| MH338 | 240mm | Top | 12° | \$ 696.90 |

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Toll Free Order Line: 1 800 SCHMIDT (724-6438)



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# **Tips for using our HSK Corrugated Cutterheads**

Our HSK Corrugated Cutterheads are manufactured to standards that will meet or exceed operating specifications. The head has been independently tested by a laboratory and met the requirements specified for the centrifugal over speed test according to EN 847-2-2005. 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. Make sure knives are balanced properly:** It is recommended that knives 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 little pitch and dirt build-up will run smoother and produce better finishes. Any pitch build-up, just like knives that are not in perfect balance, will have an affect on the head running at its optimum.
- 4. Inspect heads for any damage:** Before any head is used, visually inspect the head 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 evaluated, and possibly reconditioned and balanced. This can easily be done by returning it to us for a full evaluation.
- 5. Use the correct gibs:** 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. If the gibs are lost, contact us with the head number and we can provide new gibs with the proper weight to go with a particular head. The order number with the month and year is engraved on the head body indicating when the head was manufactured.
- 6. 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.
- 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 build-up in the head body is held to a minimum and more evenly distributed preventing any head distortion.
- 8. Maximum Knife Projection:** 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 3 times 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.

Please call 1 800 SCHMIDT (724-6438) if you have any additional questions or concerns.