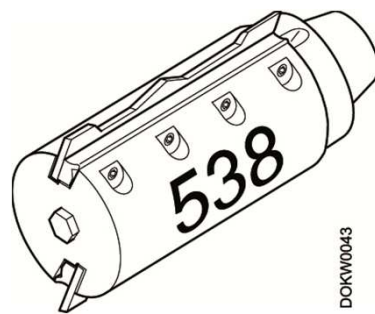


POWERLOCK KNIFE INSTALLATION PROCEDURES



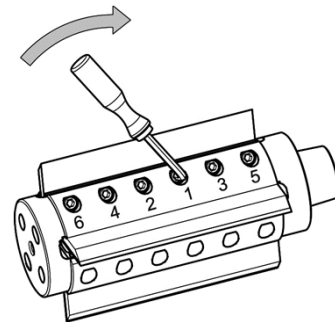
Observe the following handling instructions for type 538 cutterheads

- Always use at least two clamping screws to tighten the clamping gibs and profiled knives.
- When using narrow profile knives, select clamping gibs with the same length as the profiled knives. However, we strongly recommend using the proper size cutterhead for the job.
- Remove any unused clamping screws when using shorter clamping gibs.
- Check that the profiled knives are correctly seated in the serration.
- Insert all knives in the same position in the serration (distance from the bottom of groove).



Adhere exactly to the following order when tightening the clamping screws:

1. Tighten clamping screw (1) on all knives to a snug fit.
2. Tighten each respective clamping screw in the order depicted in the graphic in the same manner.
3. Once all clamping screws have been tightened on all knives, torque all clamping screws again in exactly the same order to 23 ft/lbs.



Clamping screws are loosened in the reverse order than when clamped. Undo the clamping screws in exactly the same order depicted in the graphic. First undo clamping screw (1) on all knives. Then undo clamping screw (2) and so forth on all knives.

