

Thank You



Thank you very much for purchasing from us. Our service to you just starts, not ends.

It will be our pleasure and honor to make customers like you satisfied with the products you receive and the service we provide in the future.





CAUTION



- After taking out the cutterhead from its craton or crate, put it on supporting blocks such as V blocks.
- Remove the wrapping materials with a scissor or knife. inspect carefully for any damage that may have occurred during transit.
- Check for loose, missing, or damaged parts. Report missing parts to dealer.
- Pay special attention during unpacking and never put the cutterhead directly on ground or floor without protection to the cutterhead. Direct contact of the carbide inserts to hard material, floor or ground may damage the edges of the inserts.
- Check for shipping damage. If damage has occurred, a claim must be filed with carrier. Check for completeness Immediately
- Never slide your finger(s) along the knife edges.
- Look at the knives and screws every month you use the cutterhead. Turn and real a new edge if there is broken edge. Tighten the screws if there is any loose.





SAFTY



- For your own safety and the safety of others, read through this owner's manual carefully before operating tool.
- Protect yourself and others by observing all safety information, warnings, and cautions. Always follow proper operating procedures as defined in this manual, even if you are familiar with use of this tool or similar tools. Remember that being careless for even a fraction of a second can result in severe personal injury and/or damage to product or property. Please retain instructions for future reference.
- Sheartak Tools disclaims no liability for tools that have been changed, modified or not used properly. Cater Tools reserves the right to make at any time, without prior notice, proper alterations to parts, components, the tool bodies we may deem necessary for any reason whatsoever.
- Safety, however, is ultimately the responsibility of the individual tool operator. The operator must exercise common sense and caution to use the tools safely. Before using this tool, familiarize with the following safety rules.
 1. If you are not properly trained in the use of a tool, do not use it until you have obtained proper training.
 2. Know the limitations and hazards associated with this tool.
 3. Do not wear gloves. Remove ties, rings, watch and other jewelry, loose outer clothing before you use this tool.
 4. Confine long hair.





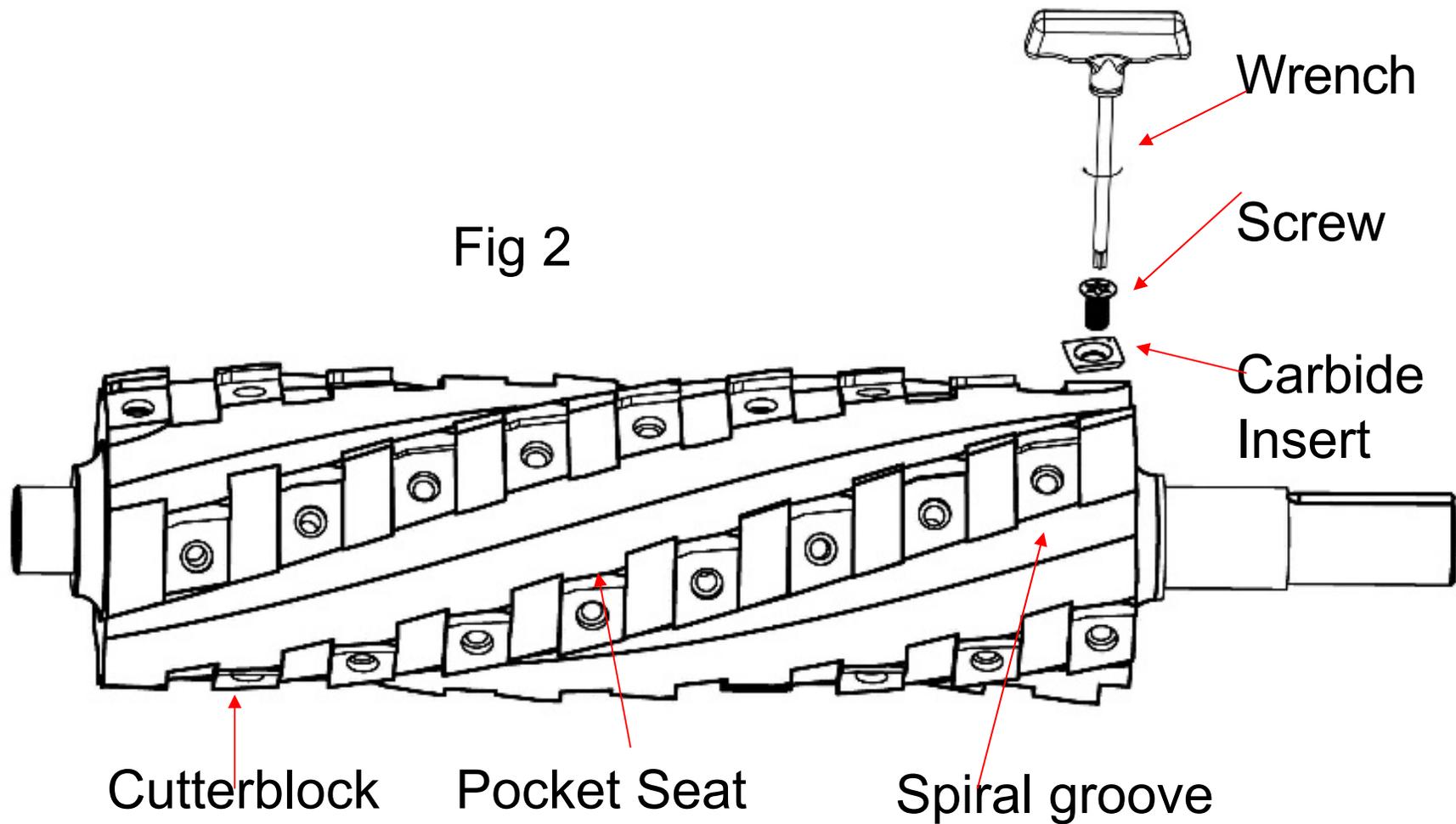
SAFTY



5. Wear an approved safety shield, goggles, or glasses to protect your eyes. Where the noise exceeds the level of exposure, use hearing protective device such as ear plugs.
6. Follow the safely rules as requested by your machine manufacturer.
7. Keep your machine guards in place before you use this tool. If any guards are removed for maintenance, DO NOT USE this tool until the guards are reinstalled.
8. Never start your work while your workpiece is in contact with the blades or knives.
9. Make sure the tool is running in the proper direction. The knives should be turning toward the infeed of your work
10. Always use push blocks when operating manually fed machines. Keep yourself at balanced stance all the time.
11. Disconnect all power sources for your machine before you perform any adjustment, maintenance or change knives.
12. Pay undivided attention to your work. Looking around, carrying on a conversation can result in serious injuries.
13. This tool is designed for cutting wood, plastic, rubber, XPS board, EPS board etc. Do not use it to cut any kind of metal substance. Otherwise Cater Tools disclaims any warranty and holds itself harmless for any injury or damage which may result from th use.
14. Use only genuine Sheartak Tools authorized blades, knives, inserts and parts



Know The Cutterhead



Shearcut Spiral Cutterheads



4 reversible edges

Pocket

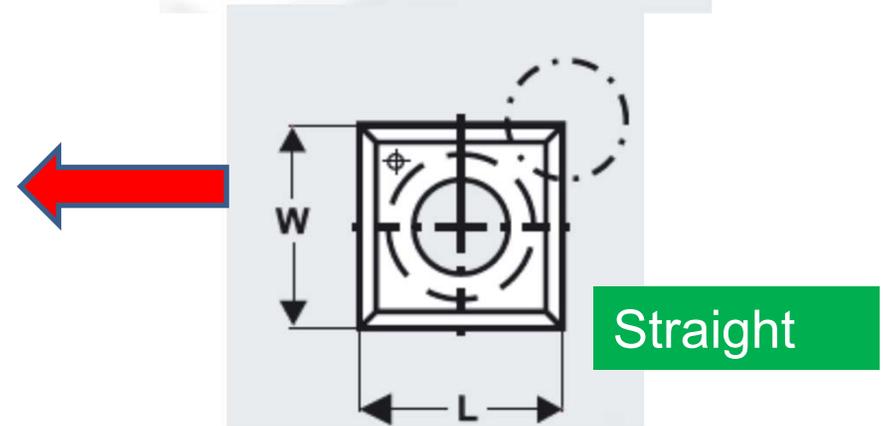
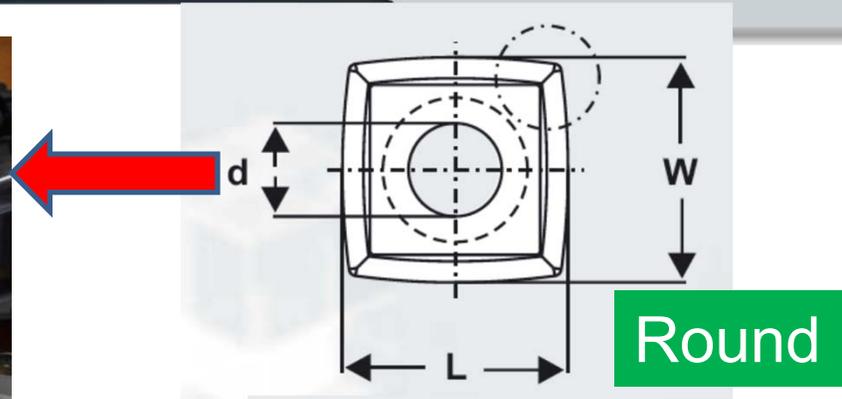
Reversible knives

TORX head
Super clamping

Cutting Edges
not parallel to
centerline

Knives place
along helical
grooves

Why Shearcut is better



The carbide knives on the shearcut type cutterheads sit at an angle to the centerline of the cutterblock. The edge approaches the board and cut gradually as the cutterhead rotates. It does not hammer the board at the whole length of the edge. Thus the cutterhead generate a shear cut action. It's much smoother and quieter than any other type of helical cutterheads.

How To Replace Knives

Follow the cart below and make sure all four edges are used before you replace them with new knives.

This is the start point.

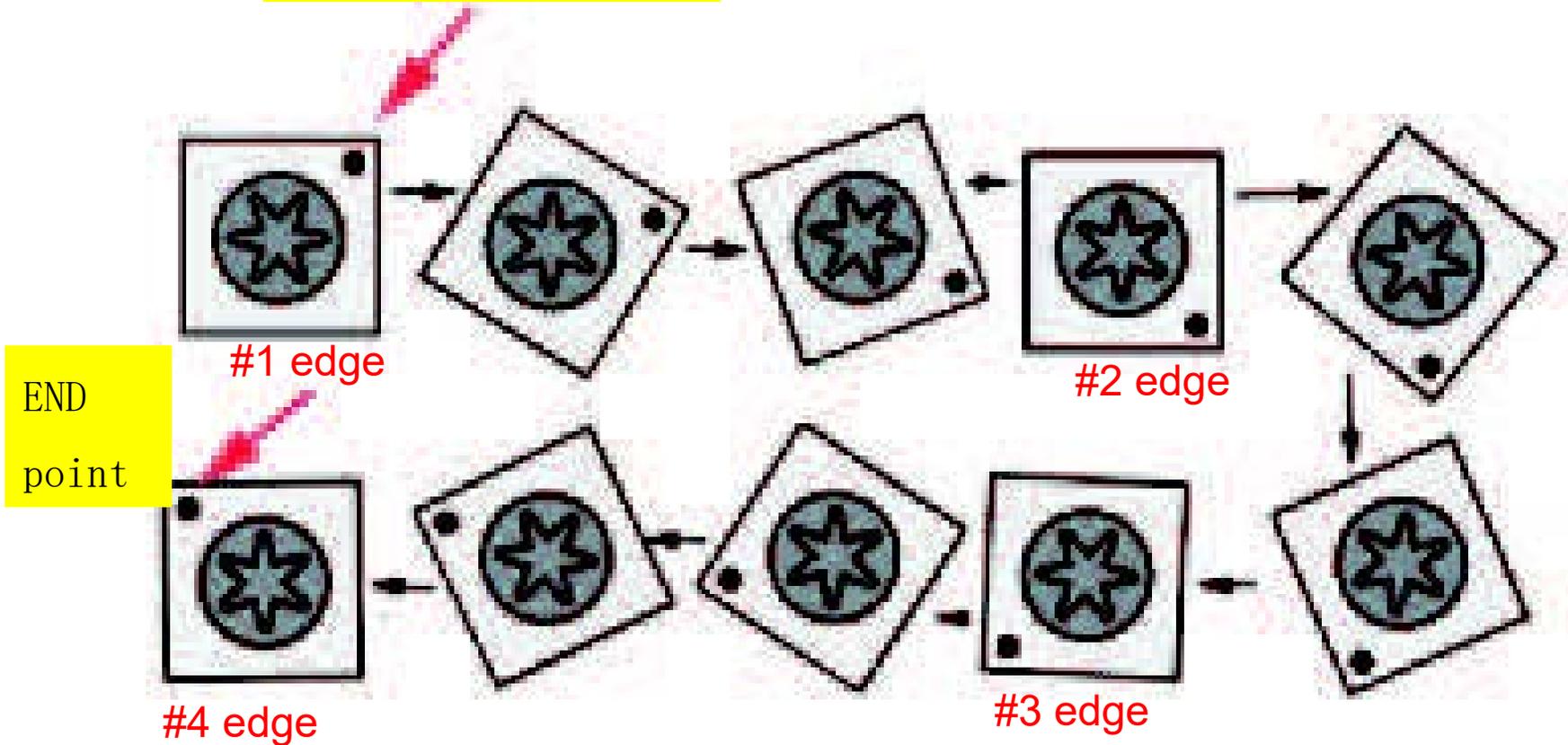


Fig 3

How To Replace Knives

1) Have the following tools and parts handy

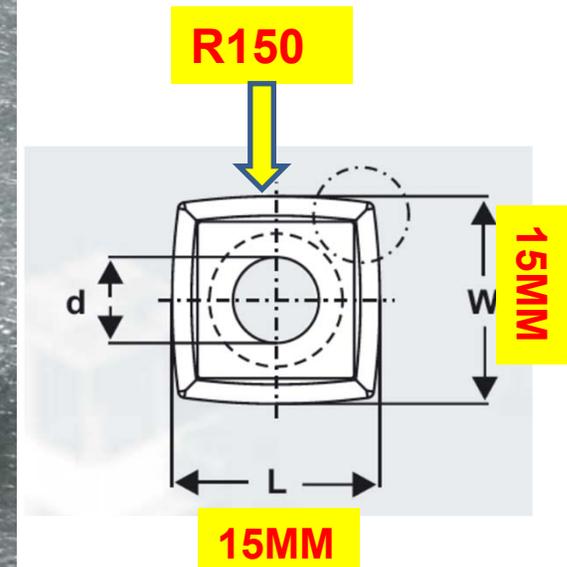
T25 or T20 wrenches

Put 15X15X2.5MM R150 round-edge knives, Never use 15X15X2.5MM straight edge knives



15X15X2.5MM R150 Round edge knives

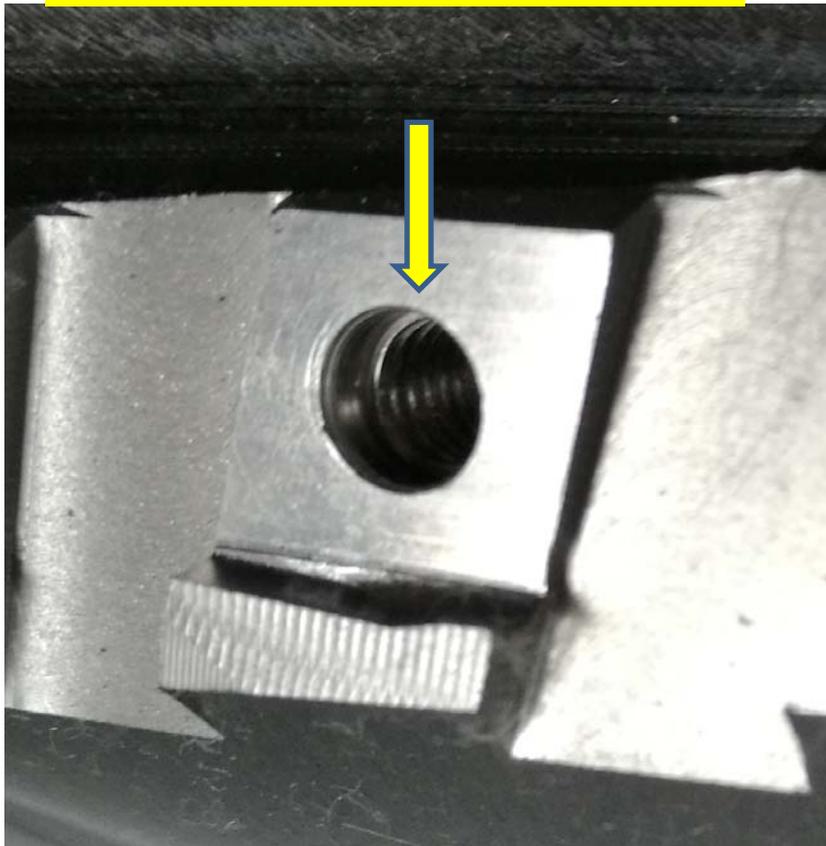
M6X1 T20 torx head screws or 10#-32TPI T25 Torx head screws.



M6X1 T20 torx head screws are about 15.4mm long and 10#-32TPI T25 Torx head screws are about 12.7mm long. For small cutterheads, we usually install 10#-32tpi T25 torx head screws, while M6X1 T20 torx head screws for larger cutterheads.

How To Replace Knives

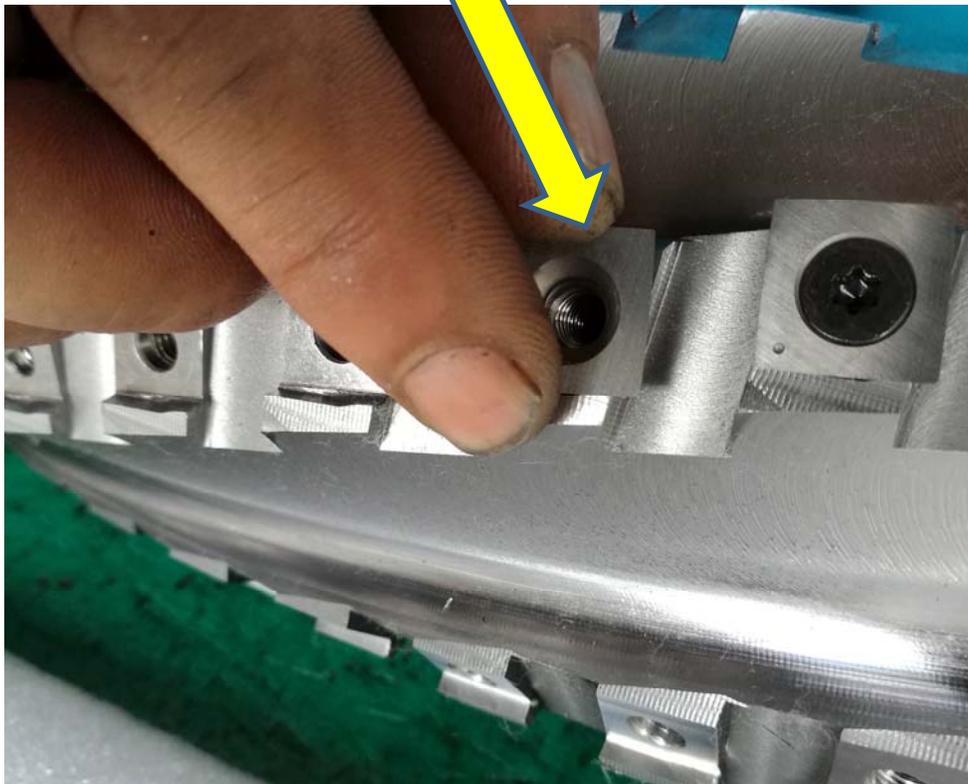
2) Clean up all the dirt from the thread holes



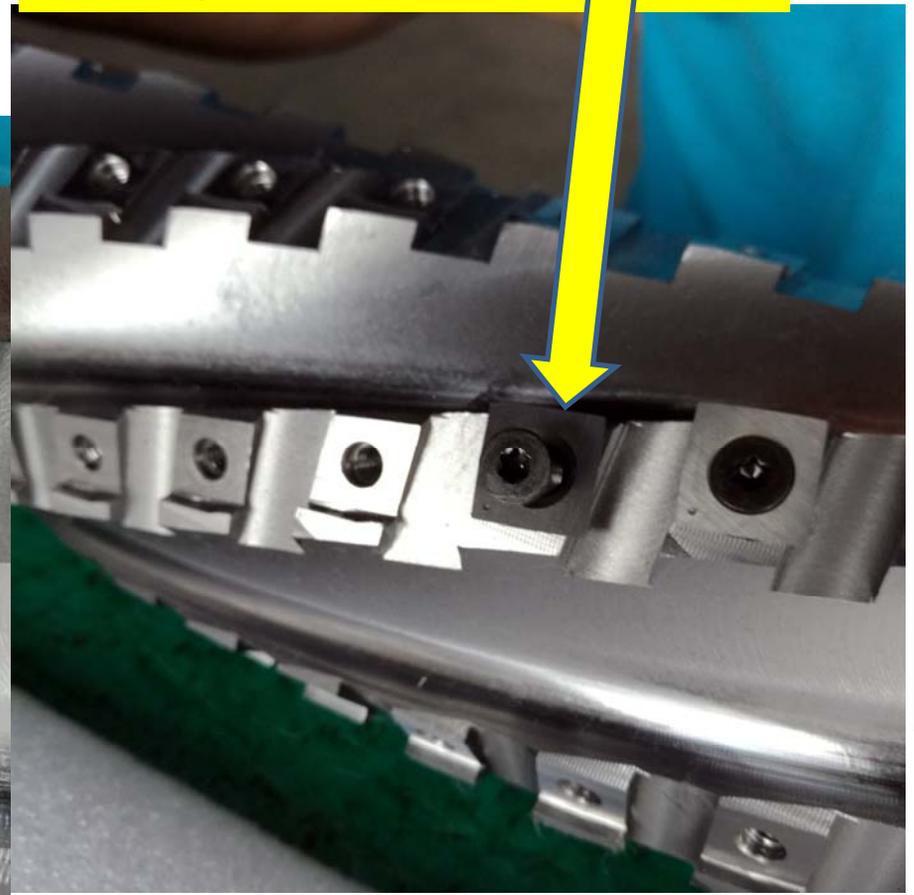
3 Put 15X15X2.5MM R150 round edes knives on it. Never use straight edge inserts

How To Replace Knives

4) Place the knife to the pocket

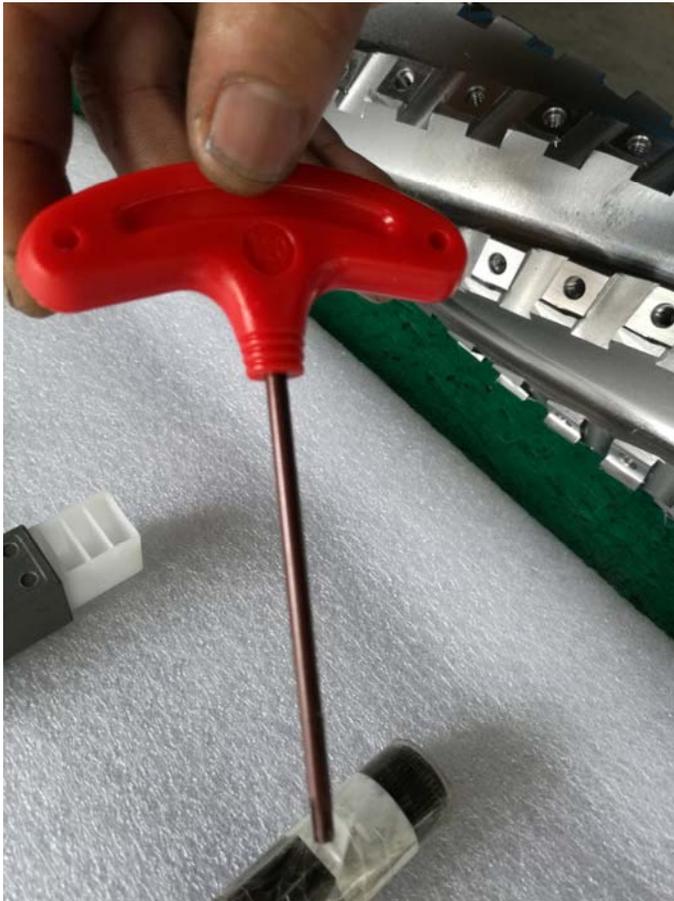


5) Turn the screws to the taper hole of the knife. No tightening at this stage.

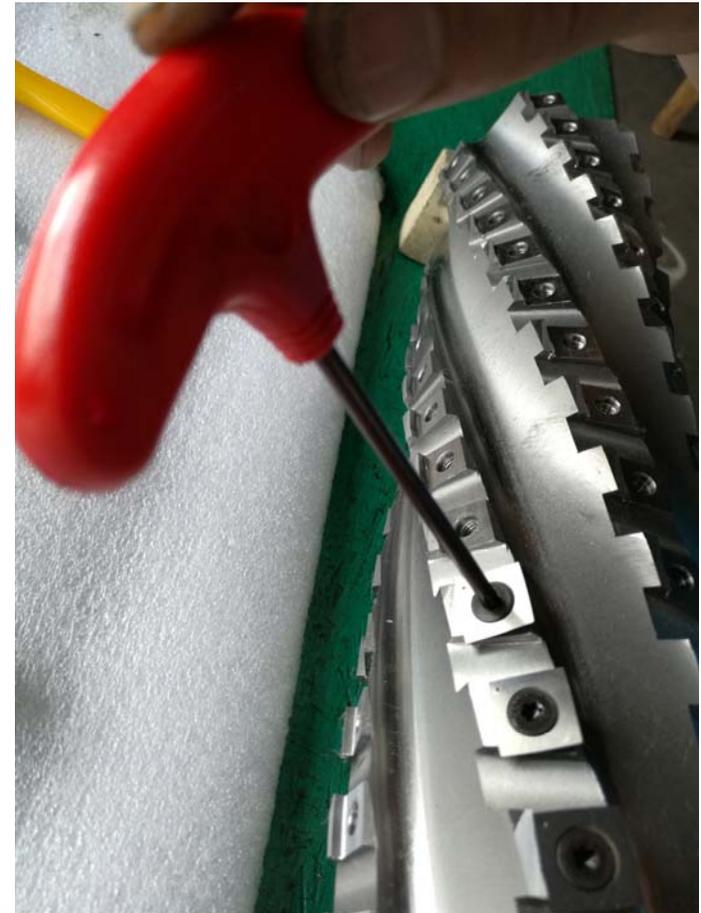


How To Replace Knives

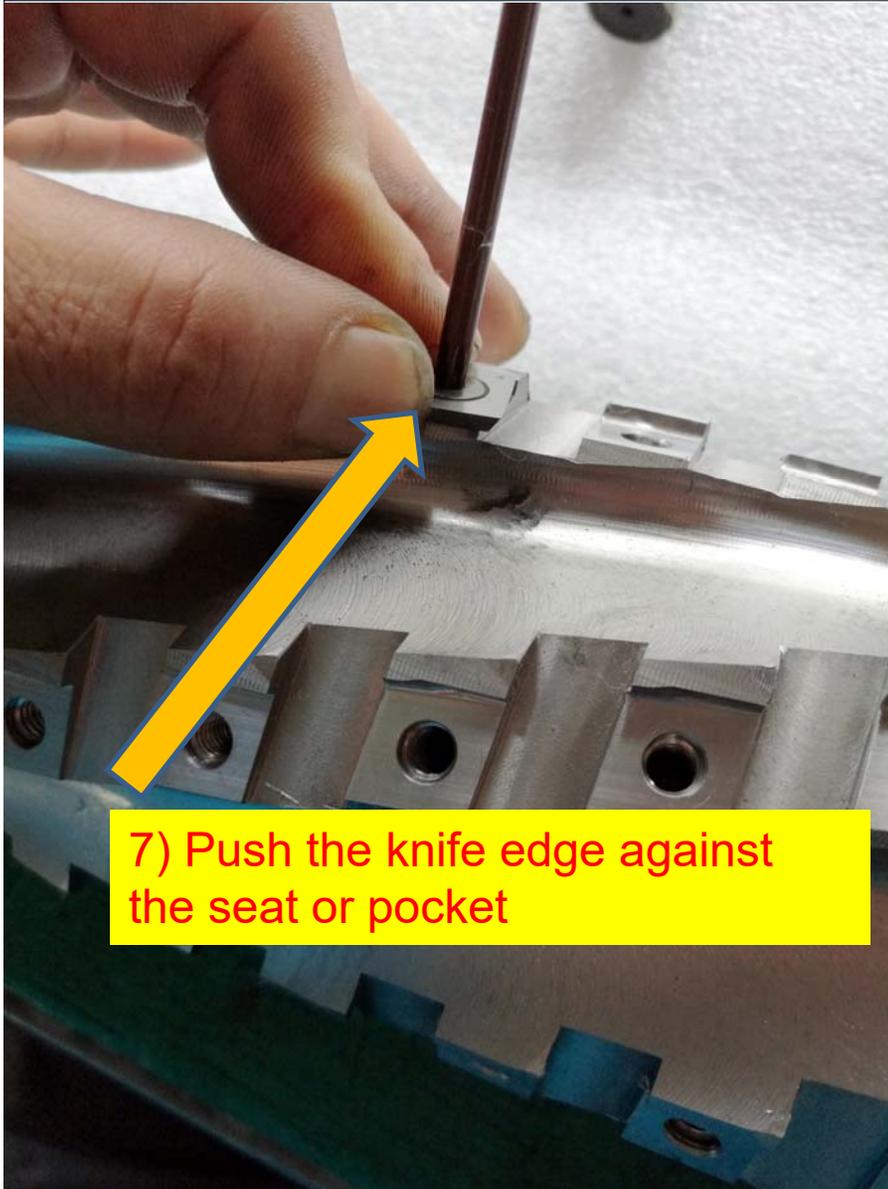
Use T20 or T25 Torx head wrench



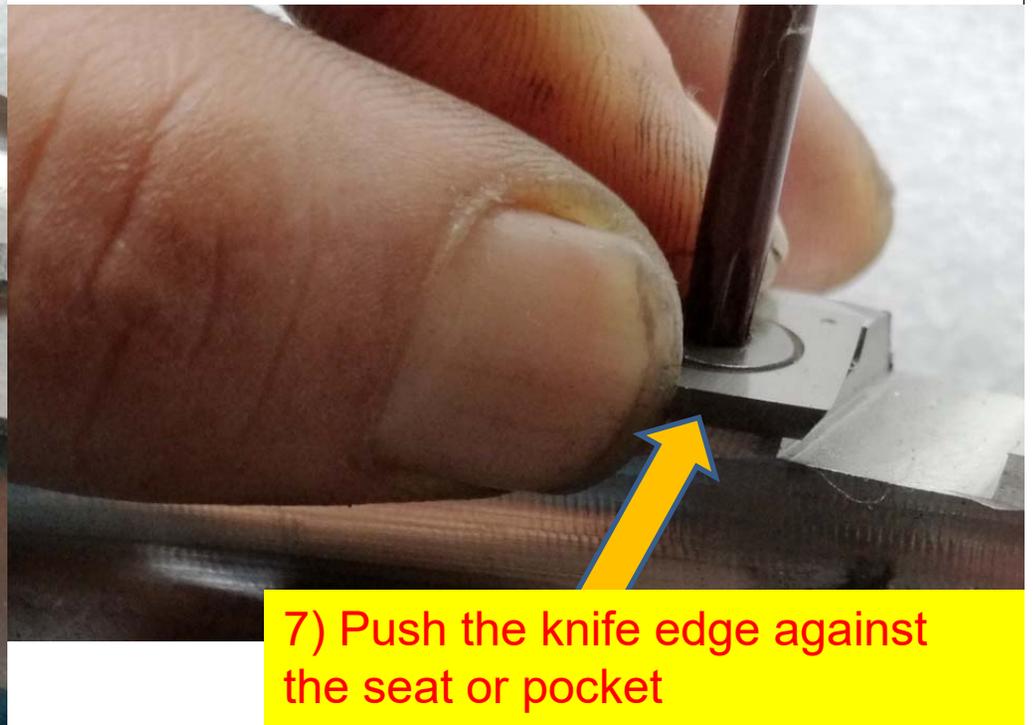
6) Turn the screw to taper hole of the knife. But don't tighten



How To Replace Knives



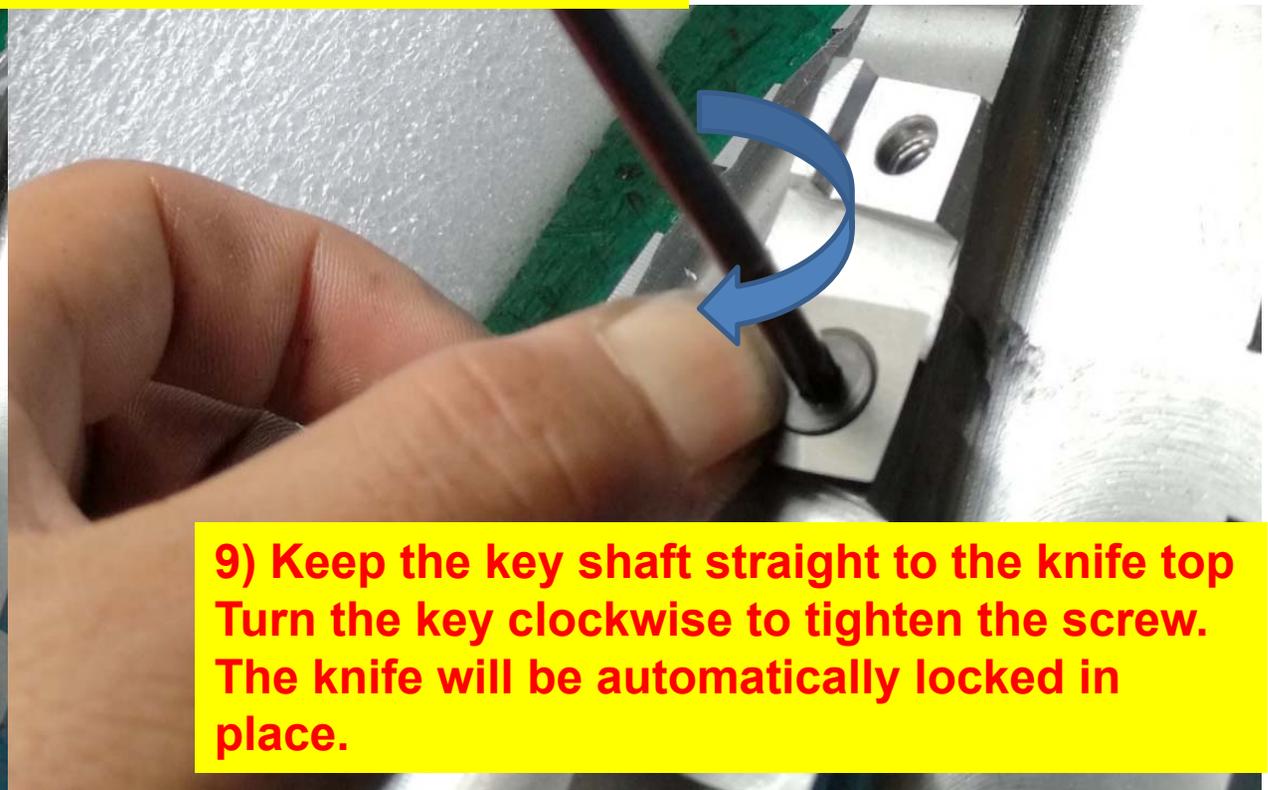
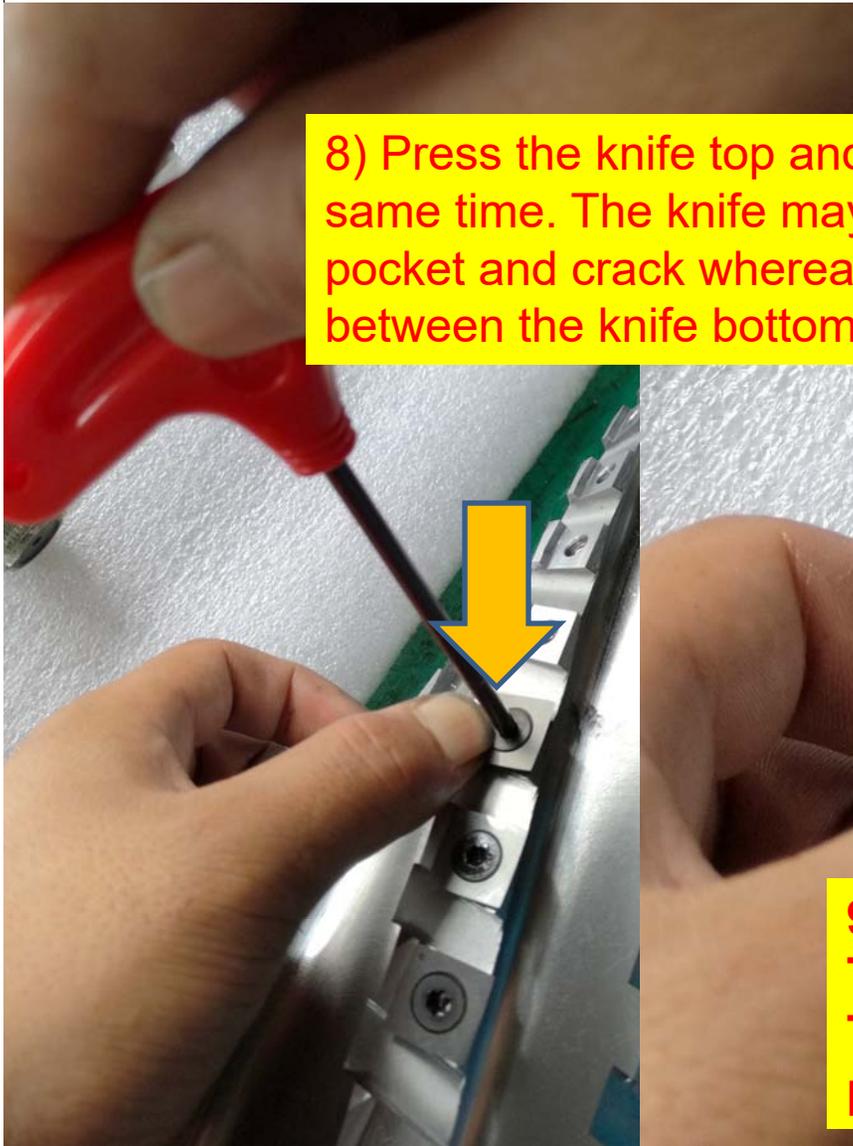
7) Push the knife edge against the seat or pocket



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How To Replace Knives

8) Press the knife top and the seat top the same time. The knife may lift up from the pocket and crack whereas there is gap between the knife bottom and the pocket top.



9) Keep the key shaft straight to the knife top
Turn the key clockwise to tighten the screw.
The knife will be automatically locked in place.

How To Replace Knives

Recommend Torque 48—52 pound Inch or 5.42—5.88Newton Meter. Over-tightened screws may explode the tungsten knives.

This torque wrench is optional. We torqued each screw with this tool to maintain the same clamping of the screws.



9.1) Tighten screws



9.2) The drive stops rotating when set torque is achieved.

How To Replace Knives



The top of the screw is not parallel to the knives due to design and manufacturing purpose.



Contact Us



If you have any question or need help, feel free to contact us. Your satisfaction is guaranteed.

Thank you for your business.

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