

## ROUNDING CUTTER WITH MECHANICAL FIXING, WITH INTERCHANGEABLE KNIVES

Wirutex ID-no. S15166\_F10FB01AR011

### INSTRUCTIONS FOR ASSEMBLING AND DISASSEMBLING THE INTERCHANGEABLE KNIVES

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#### 1. GENERAL INFORMATION

The rounding cutter with mechanical fixing, with interchangeable knives, complies with European Standard EN 847-1.

**Before handling or using the tool, carefully read the instructions in this document.**

#### 2. USE

- The maximum number of rotations (max rpm) indicated on the tool must never be exceeded.
- Always check the rotation direction specified by the manufacturer.
- The rounding cutter with mechanical fixing, with interchangeable knives, may only be used on machines with mechanical feed (MEC).



#### 3. ASSEMBLING ON THE MACHINE

- Before using the tool, check that the cutting parts, screws and locking elements are correctly inserted in their seatings.
- The tool must be assembled, locked and used on the machine in accordance with the instructions given by the machine manufacturer.
- All the locking surfaces must be thoroughly clean: remove all traces

of dust, grease, oil and water.

- It is forbidden to start up the machine while the tool or the interchangeable knives are being changed.
- The cutting edges must never come into contact with the machine locking elements or with machine parts.

#### 4. REPLACING THE KNIVES

**ATTENTION:** the interchangeable knives must be assembled, removed and replaced in full accordance with the instructions given in the sections **Removing the knives (4.1)** and **Assembling the knives (4.2)**. **Failure to respect the instructions will reduce machining safety to an unacceptable degree, and will increase the risk of injury.**

- Always wear safety gloves when handling the tool.
- Risk of injury due to sharp cutting edges.
- Use only original spare parts from Wirutex hi-tech tools.
- The cutting parts and clamping areas must be perfectly clean and free of resin or glue deposits.
- Always make sure the knives and assembled components are firmly locked in their relative seats.
- **IMPORTANT: the tightening force of the screws must be 3.5 Nm-**
- To tighten the screws, **use the \*torque screwdriver - Wirutex ID-no. Q07VA01DB364 - with T15 bit - Wirutex ID-no. Q07VA01DB364.**

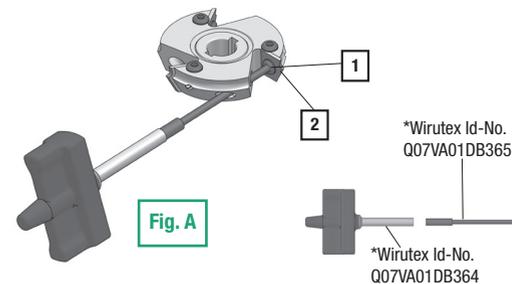
##### 4.1. REMOVING THE INTERCHANGEABLE KNIVES (see Fig.A)

- Remove the screw (1) using the torque screwdriver recommended by Wirutex.
- Carefully clean the knife (2) and its seat.
- Replace the knife and check the screw is not damaged.

##### 4.2. ASSEMBLING THE INTERCHANGEABLE KNIVES (see Fig.A)

**ATTENTION: before inserting the knives, make sure their seats are clean!**

- Insert the knife with the cutting edge facing in the cutting direction.
- Insert the screw (1) with the aid of the torque screwdriver recommended by Wirutex.
- **Tighten the screw with a force of 3.5 Nm.**

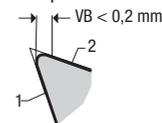


#### 5. CARE AND MAINTENANCE

**⚠ The use of damaged or worn knives increases the risk of injury and reduces the cutting quality.**

To ensure workplace safety, the knives **must be replaced when:**

- The wear on the cutting edges, as indicated by VB (see Fig.B) is greater than 0.2 mm. Pay special attention to the main areas of wear.
- The cutting quality of the tool is drastically reduced.
- The tool becomes much noisier.
- Broken cutting edges are visible.
- The power intake of the machine increases considerably.



- Clean the cutting parts regularly to remove resin and glue, to increase the lifespan and safety of the tool.
- Only use detergents that do not corrode the material.
- Follow the instructions given by the detergent manufacturer.
- Tools and locking systems must be protected from humidity, to avoid corrosion; use appropriate products and oils.

#### 6. WARNINGS

- Check the cutting part, locking elements, screws and tool body regularly for defects.
- Any damaged or worn elements (cutting parts, screws or locking elements) must be immediately replaced with original spare parts.
- Pay attention when packing or unpacking the tool.
- **⚠ Risk of injury due to sharp cutting edges!**
- **Suitable packaging must always be used for transportation!**
- **The cutting parts of the tool must never come into contact with each other or with machine parts!**