

## Technical datasheet # 54

### How do I replace my cutting blade?

#### Servo-Torq® belt drive cutting machines only!

Keeping your knife blade sharp is vital for optimum cut quality.

A sharp blade ensures a clean, swarf-free, cut edge. So remember to replace blades when they become worn!



#### 1. Blade changing instructions:

##### 1) Tools required (supplied with the machine):

- 36 mm spanner (wrench).
- 13 mm box spanner.

##### 2) Isolate the machine from the power supply.

##### 3) Gillard strongly recommend wearing safety gloves. Use the utmost care as the blades are very sharp and can cause injury.

##### 4) Slide the cutter head away, lock in-place & then open the cutter lid guard (see photo below).



##### 5) Use the 36 mm spanner (wrench) supplied with machine.

Locate the spanner head onto the flats to the rear of the blade holder.

##### 6) Rotate the spanner arm downwards onto the cutting area casting block to lock the cutter head.

This is important!

It will stop the blade head rotating when you come to unlock the blade locking bolt.

Please refer to the photo below.



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- 7) Use the 13 mm box spanner supplied with machine.

Locate onto the blade cap locking bolt.  
Turn anti-clockwise to release the bolt.  
See the photo below.



- 8) Remove the blade locking bolt, washer & blade cap.

This will allow you to release the knife blade.



- 9) Remove the blade.

You may need to have to move the blade slightly sideways to clear the blade location pins.

Take care when handling the blades as they are very sharp!



- 10) Fit the new knife blade.

You will need to line-up the hole in the new blade with the hole for the central locking bolt.

If there is a second hole in the blade, this will need to fit over one of the location pins on the blade head.

- 11) Replace blade cap onto the location pins.

Tighten the locking bolt clockwise using same method as removal.

- 12) Remove all the tooling.

- 13) Close the cutter lid & the slide-a-way cutter head assembly.

- 14) Reconnect the power & re-start the machine.

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For more information & technical assistance.

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