

INSTRUCTIONS FOR RE-ADJUSTING THE SIDE GUIDES ON AN HDS CUTTER

- 1.** Level the entire machine with the ground. This will ensure the top jaw is hanging correctly when the guides are loosened.
- 2.** Turn the cutter on and extend the top jaw down as far as it will go. Turn the cutter off afterwards.
- 3.** Loosen all of the Allen head bolts and lock nuts on each side guide. Back off the side guide adjusters from the guides. The guide should be able to move now.
- 4.** Check to make sure the top and bottom teeth are lined up relative to each other. Each top tooth should be centered directly above a bottom tooth. It is important to check this after every step. To do this, look down at the top jaw tooth bar edge and match it up with the bottom jaw teeth. An alternative is to use a mirror to look down the length of the teeth.
- 5.** Wipe each guide bearing surface free of all grease and debris.
- 6.** Slide the two guides on the outbound table side flat against the top jaw.
- 7.** Tighten only the top and bottom bolts on each side guide with only a snug fit. Check alignment per step 4. Tap the top and bottom in to get the top jaw in correct alignment.
- 8.** Slide the other two guides flat against the top jaw and snug down the same two bolts. Check for air spaces between the guides and top jaw. All guides should be contacting the top jaw. The top teeth should still be aligned with the bottom teeth. Readjust as necessary by tapping the guides in.
- 9.** Turn the cutter power on and power up the top jaw until it is flush with the top of the guides. This may push them out some if they are not in alignment. Readjust the guides as necessary by tapping them in.
- 10.** Move the top jaw down until it is in the center of the side guides. Check for tooth alignment and if there are any gaps between the guides. Re-adjust as necessary.
- 11.** Once you are satisfied with the guide fit and jaw alignment, tighten down all of the Allen head bolts and locknuts, wrench tight.
- 12.** Run the top jaw up and down to check for smooth movement. If it sticks or gouges the guides, find the problem area and readjust the guides. Listen to see if the engine is working

harder as the top jaw moves along the guides. This is an indicator of tighter spots between the guides.

- 13.** Once the guides are positioned and the top jaw is able to move smoothly through its' entire stroke, the bolts can be tightened to 150 ft-lbs.
- 14.** The side guide adjusters can finally be screwed in position. They are only used to help keep the guides in position under heavy loads. Screw the bolts in until they are against the guides, finger tight, and then tighten the jam nuts to lock them in position.
- 15.** Check the stroke once again for fluid movement, no gaps between the guides, and alignment of the top and bottom sets of teeth. Once satisfied, thoroughly grease the guides at the zerks.



