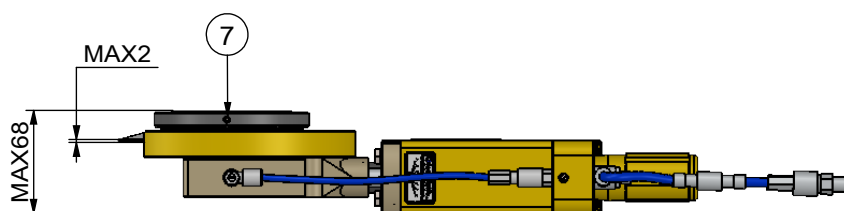
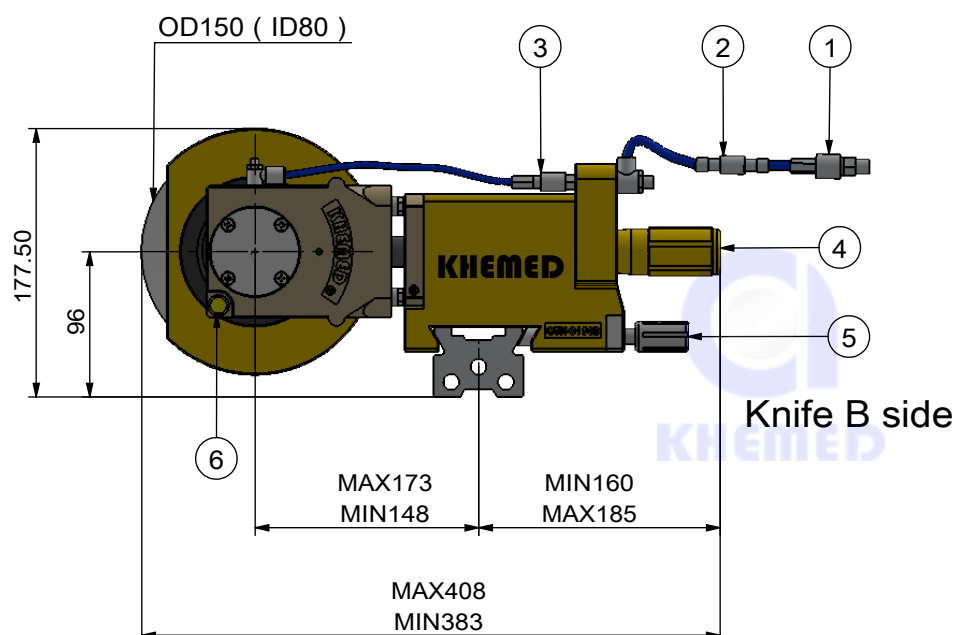


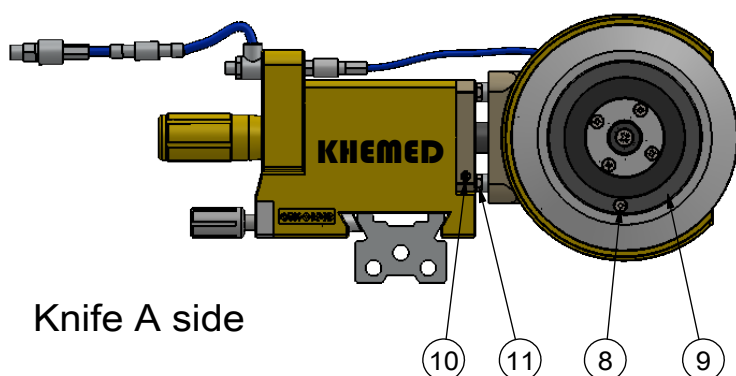
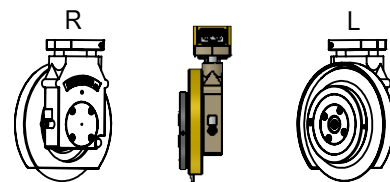
KHEMED OTK-C150B Instruction manual (1)



- Series OTK-C150B technical parameters:
1. Diameter of round blade: 150 mm
 2. Cutting stroke: 25mm
 3. Knife stroke: 2mm
 4. Minimum cutting width: 70mm
 5. Air source pressure: 3-5kg / cm²
 6. Cutter speed: 1200m / min
 7. Blade specification: OTK-OD150x ID80x2.5T
 8. Blade material: SKH-51, M2, SKD11
 9. The knife head deflection angle is adjustable



Series OTK-C150B Knife head deflection angle adjustment diagram



S/N	Detailed explanation of Series OTK-C150B pneumatic knife set
①	PT1 / 8 quick plug connector
②	Knife feed hand pull valve (∅ 6 two way pull valve)
③	Pull valve by knife hand(∅ 4 one way pull valve)
④	Cutting depth, adjusting handle, digital display with scale
⑤	Swallow tail fixed handle
⑥	Remove the tool locating pin
⑦	M5 stop screw (loosen and lock when disassembling blade)
⑧	M4 flat head screw (loosen and lock when disassembling blade)
⑨	Remove the knife lock nut
⑩	Tool head angle adjusting screw M4 top thread
⑪	External hexagon screw with cutter head

Tolerances Level	0<10	±0.005	Projection		Description	OTK-C150B-DSM		Drawing No.	OTK-C150B
	10<50	±0.01	Drawn by	XCS	Name	OTK-C150B Dimension diagram of pneumatic shearer knife set			
	50<100	±0.02	Material		Scale	1:5	Weight		
	100<200	±0.025	Surface Treatment		Unit	mm	Date		
	200<500	±0.03							

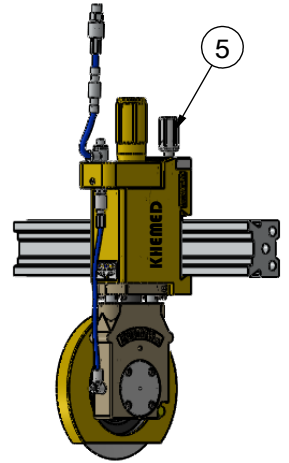
KHEMED OTK-C150B Instruction manual(2)

1. Install the knife set (Pic. 1)

Hook the knife set from the bottom to the top onto the dovetail seat track and gently swing it to the left and right. At the same time, turn the No.⑤ (dovetail fixed handle) clockwise by hand to make the knife set cling to it vertically, and then tighten the No.⑤ (it can be tightened with an 8mm inner hexagon wrench)

be careful:

- <A> After the swallow tail fixed handle is released, the knife set can be easily moved and positioned by hand. Do not strike the knife set with hammer or heavy objects to move, so as to avoid damage to the knife set.
- The swallow tail fixed handle only has the positioning function of the tool rest, which can be slightly locked, without using too much force to lock.
- <C> When fixing the knife set, the upper knife edge and the lower knife edge are staggered to facilitate the subsequent debugging of the knife set.



Pic. 1

2. Adjust the knife set (Pic. 2)

Step 1: close the No. ② (ø 6 two way pull valve) and the No. ③ (ø 4 one way pull valve).

Step 2: connect the No.① (PT1 / 8 quick connector) to the air source.

Step 3: tighten the No. ④ clockwise (Adjusting handle for the down knife).

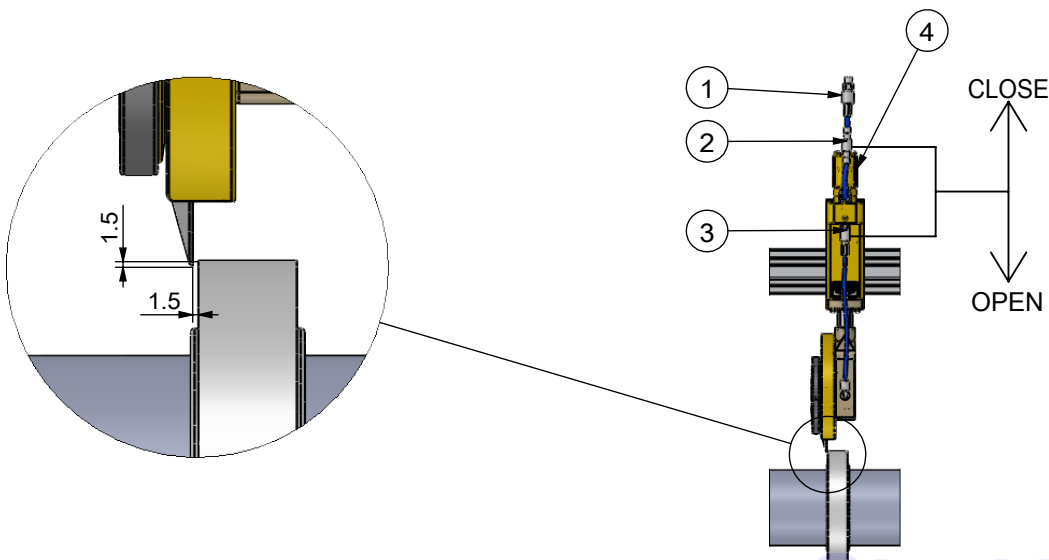
Step 4: open the No. ②, then release the No. ④ anticlockwise, and adjust the feed depth of the knife group. The best feed depth of the knife group is 1-2mm between the upper blade and the lower blade.

Step 5: loosen the No.⑤, move left and right on the dovetail seat track, and adjust the position of the knife group. The best position of the knife group is 1-1.5mm between the upper and lower knife edges

Step 6: after locking the No. ⑤, open the No.③ for leaning

Step 7: after the above six steps are completed, the No.(3) can be kept in the open state all the time, and then the knife group feeding and leaning can be controlled by switching the No. ② with one key.

(Pay attention to the position of upper and lower blades in this process to prevent the upper blade from hitting the lower blade and causing damage to the blade edge)

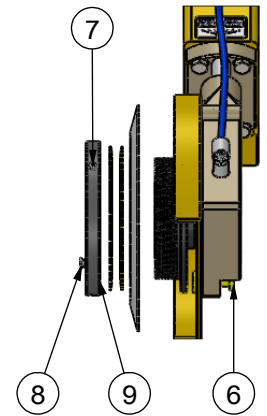


Pic. 2

KHEMED OTK-C150B Instruction manual(3)

3. Disassembly and assembly of blade (Pic. 3)

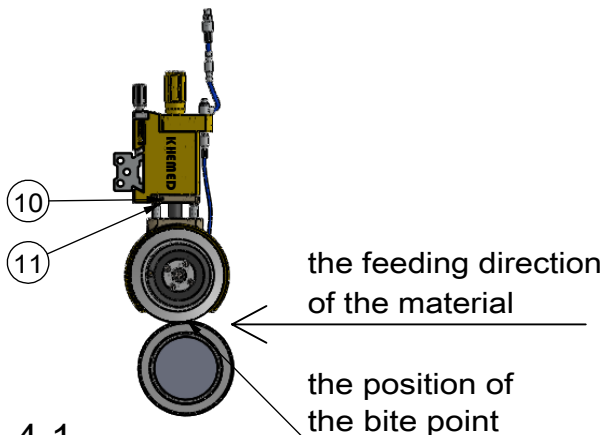
- Step 1: press and hold the No. ⑥ (remove the tool locating pin), and loosen the No. ⑦ (top screw m5x6, with 2.5mm inner hexagon wrench)
- Step 2: press and hold the No. ⑥ and loosen No. ⑧ (hexagon flat head screw M4x8, with 2.5mm hexagon wrench)
- Step 3: press and hold No. ⑥ and rotate it anticlockwise to loosen No. ⑨ (round nut m80xp2.0)
- Step 4: take out the round nut and disc spring, (when replacing the blade, take out the old blade first), install the blade, and then install the disc spring and round nut.
- Step 5: press and hold No. ⑥, tighten No. ⑨ clockwise, and then lock No. ⑦ and No. ⑧



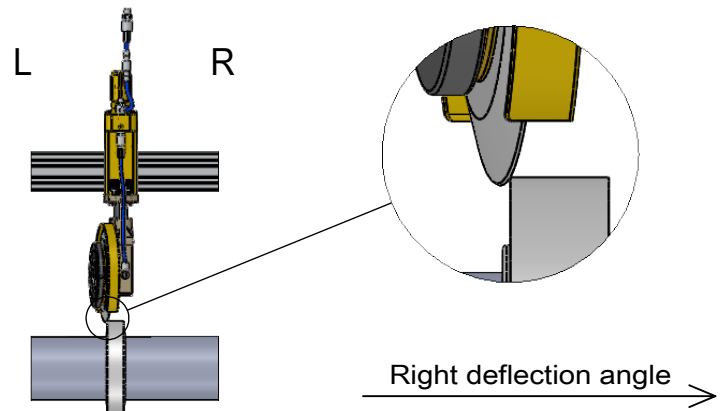
Pic. 3

4. Adjustment of knife head deflection angle(Pic. 4):

- Step 1: loosen No. ⑩ (one top screw m4x5 on the left and right sides, with a 2mm inner hexagon wrench)
- Step 2: loosen No. ⑪ (four external hexagon screws m6x25, use external hexagon open-end wrench of 10mm specification).
- Step 3: with the middle line as the benchmark, the left and right can be adjusted by three degrees.
- Step 4: when adjusting the deflection angle of the knife head, pay attention to the bite point of the upper blade and the lower blade, and the position of the bite point and the feeding direction of the material are on the same side.
- Step 5: after adjusting to the best position, lock No. ⑪ and No. ⑬ .
(for example, when there is burr in material cutting, it can be solved by adjusting the angle of the knife head when the upper blade is not sharp.)



Pic. 4-1



Pic. 4-2

