SHOK BLOK®

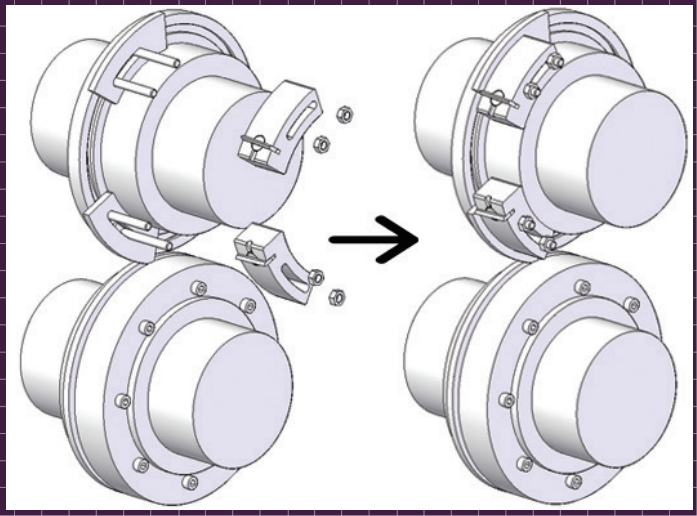
FITTING INSTRUCTIONS
& TROUBLESHOOTING GUIDE

SERIES I & II

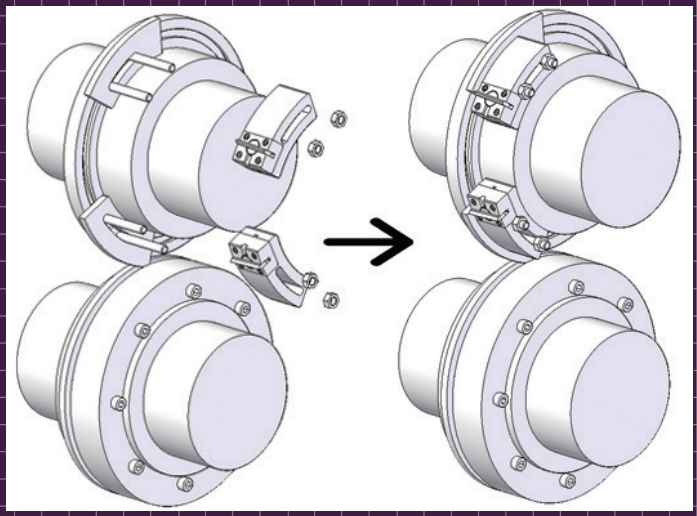
MADE IN
GREAT BRITAIN

SET-UP (SERIES I & II)

STEP 1



SERIES I



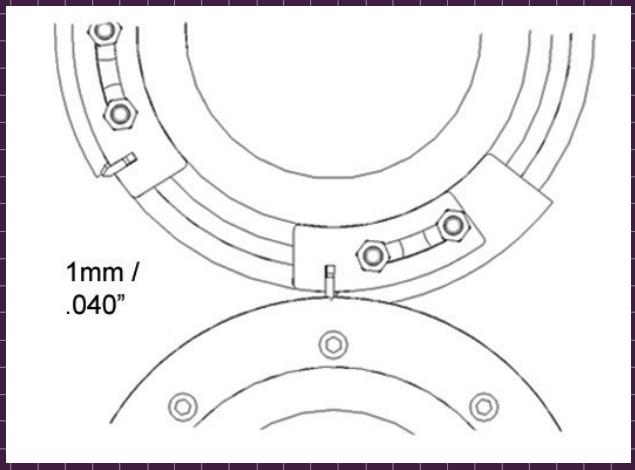
SERIES II

Remove existing stitch / glue flap blocks (and anvil if applicable) from the heads and open the shafts apart to maximum gap.

Fit the new lead and trail Shok Blok®s in the same position as original, using same fixings unless alternative or additional screws are required.

If applicable, fit new steel anvil(s) too.

STEP 2



SERIES I & II

With the appropriate height blade fitted for the board type (see chart), manually rotate the slotting head so that the trailing (T) Shok Blok® is at the cutting position on the anvil.

Adjust the shafts closer so that the blade compresses approx. 1mm or .040”.

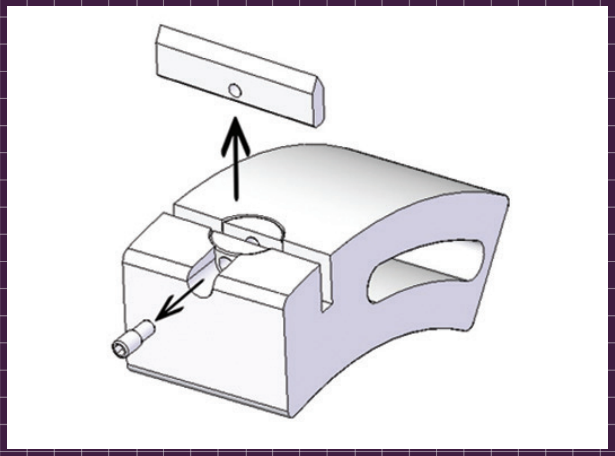
Slowly rotate the heads and test the cut of both Shok Blok®s.

Change blade height up or down to suit nip pressure.

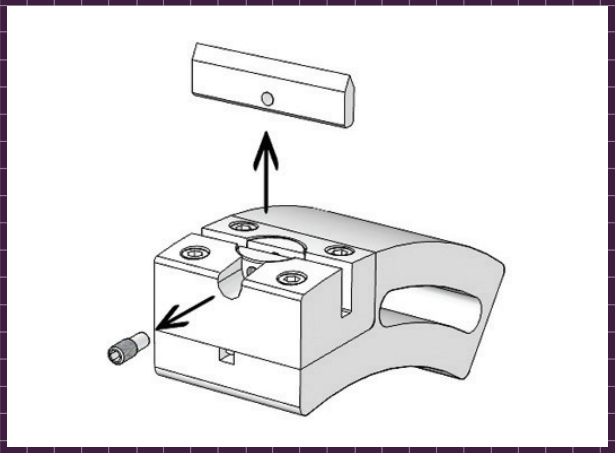
Do not exceed 4.5mm or 3/16” blade compression.

Run machine at normal speed.

STEP 3



SERIES I

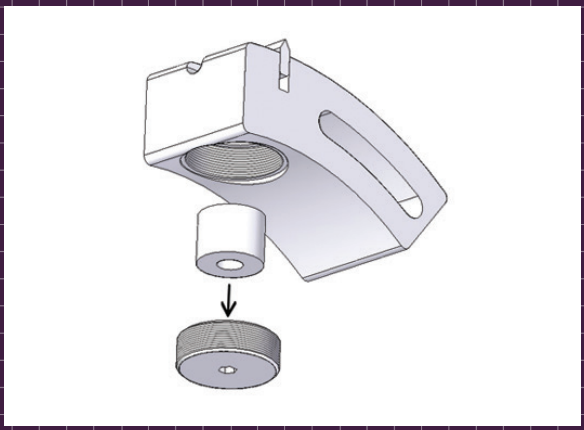


SERIES II

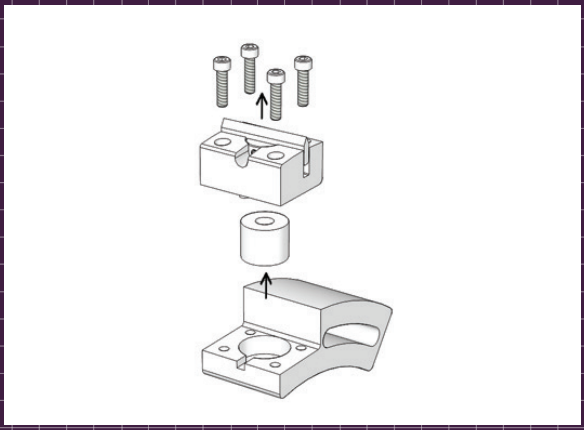
Blades can be changed using the T key and removing the blade screw. When replacing the blade, do not over-tighten the screw as it does not clamp the blade.

Replace blade when blunt and cutting fails.

STEP 4



SERIES I



SERIES II

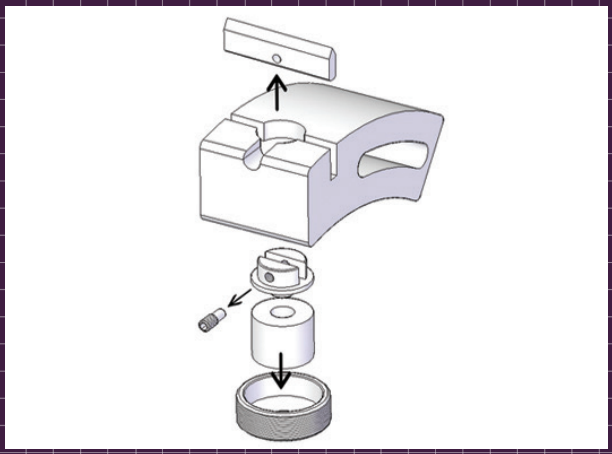
To access the spring and blade holder: remove Shok Blok® from head and unscrew the spring cap underneath using the T Key or pin spanner provided. The blade holder will only remove if blade is out.

With blade holder aligned to access blade screw, fit blade, refit spring and spring cap and tighten until it stops, do not over-tighten.

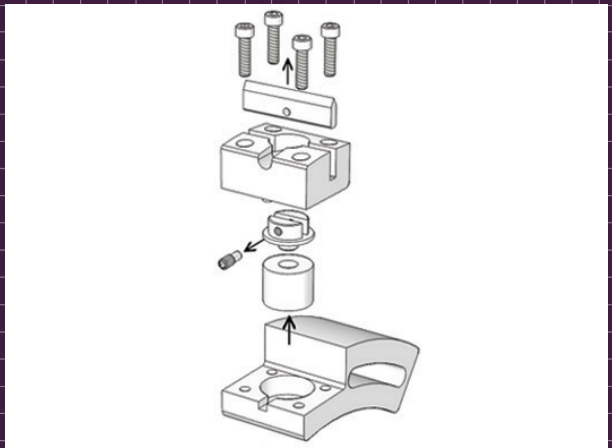
To access the spring and blade holder: while fixed to head (or removed from head) unscrew the cassette screws (4) and lift off to access spring. The blade holder will only remove if blade is out.

To refit cassette, with blade holder aligned to access blade screw, refit blade, refit spring and tighten 4 screws evenly, keeping cassette central.

STEP 5



SERIES I

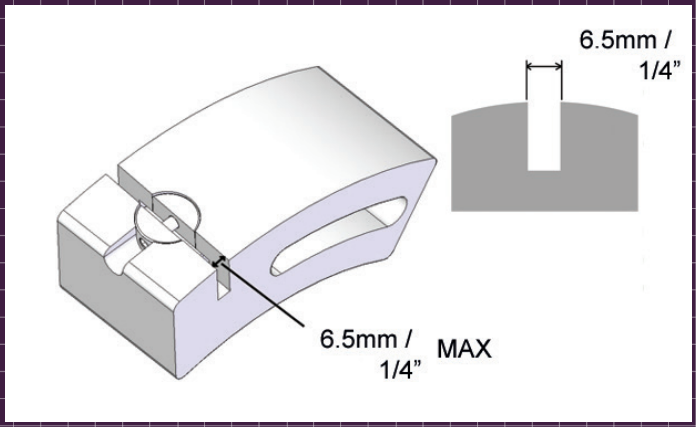


SERIES II

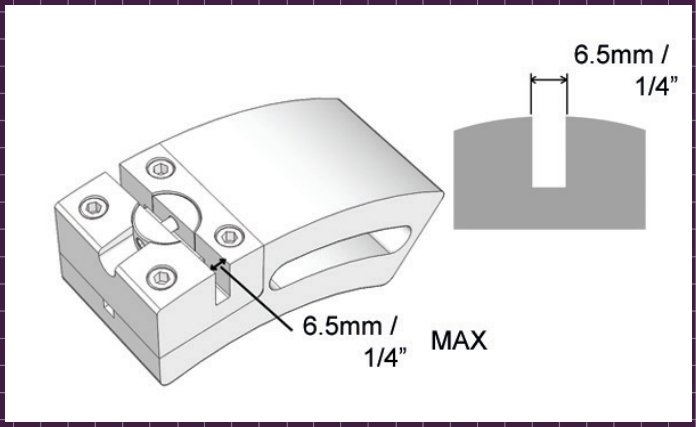
Regularly inspect and replace badly worn blades, springs and holders if performance is affected.

See Troubleshoot / Best Practice guide.

STEP 6



SERIES I



SERIES II

Periodically inspect the blade slot for wear.

When there is evidence of a widened slot in excess approx. 6.5mm or ¼” the Shok Blok® body or Shok Blok® cassette needs replacing.

See Troubleshoot / Best Practice guide.

TROUBLESHOOTING

1. LEAD BLOCK CUTS OK, TRAIL NOT OK.

Run a red PU spring in trail block for more pressure, or 1mm higher blade in trail block.

2. TAB WASTE STAYS CONNECTED TO BOX IN THE CORNER.

If blade and spring change does not remedy, check condition of blade slot. Change cassette (S2) or body (S1) if beyond 6.5mm/1/4”. Check block is securely fixed to head and there is no gap between blade and slot knife. Ask about FCO male slot knife modification.

3. TAB WASTE STAYS CONNECTED TO BOX IN THE CORNER.

Check blade is compressing against anvil. Replace if very blunt. Check spring is intact, replace if undersize or split.

BEST PRACTICE

1. When cutting fails, replace both blade and PU spring absorber at same time to maximum benefit. This avoids cycles of new blade / worn spring or new spring/ worn blade.

2. Always keep blade compression / deflection to minimum for optimum life.

3. Use a Teflon® lubricant in blade slot to prolong life (MBM Pt no. 300913).

4. Change blade holder when visibly worn around top diameter as this allows excessive play of blade.

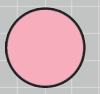
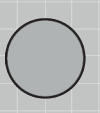
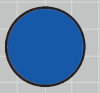
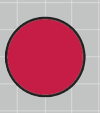
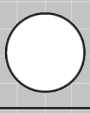
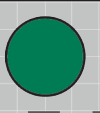
SHOK BLOK BLADE CALCULATION

Correct blade height is determined by:

Board thickness **+** 10.5mm **=** Blade height (for 4mm hole centres).

Board thickness **+** 8.5mm **=** Blade height (for 3mm hole centres).

BLADE HEIGHT CHART

BLADE HEIGHT mm/ inches	COLOR CODE	TYPICAL BOARD GRADE
11mm .433”		Single wall light e.g. E/B
12mm .472”		Single and light double wall e.g. B/ C/ EB Flute
13mm .511”		Single and double wall e.g. C/ A/ BC
14mm .551”		Hole centre 3mm= Double wall e.g. BC/ AC Hole centre 4mm= Single wall light e.g. E/B
15mm .590”		Single and light double wall e.g. B/ C/ EB Flute
16mm .629”		Single and light double wall e.g. A/ C/ EB/ BC
17mm .669”		Double wall e.g. BC/ AC
18mm .708”		Double wall heavy
19mm .748”		Triple wall

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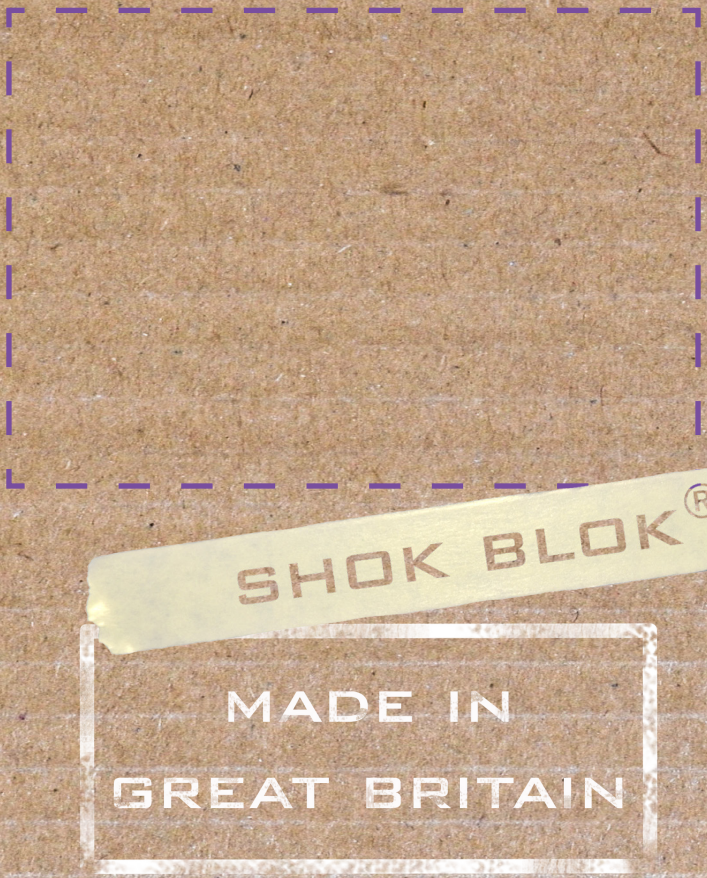

US Patent No. US8196500 GB Patent No. GB2451459