



	Mansfield Board Machinery Ltd.
Since 1978	Units 1-2 Horsley Road Northampton NN2 6LJ England +44(0)1604 713656
Quality Tooling	

SHOK BLOK®

FITTING INSTRUCTIONS



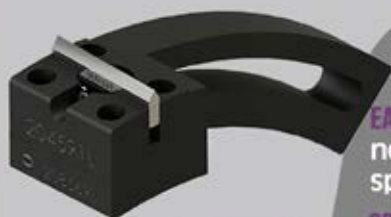
SHOK BLOK®

A unique patented spring action blade design that delivers the perfect flap cuts and instantly increases your productivity!

- ✓ Brilliantly simple spring action blade design
- ✓ Simple fitting and set-up
- ✓ Simple parts replacement and re-order identification
- ✓ Variable design options to accommodate different machine makes/models
- ✓ Precision made from quality materials
- ✓ Industry proven worldwide



SERIES 1



SERIES 2



SERIES 2 DESIGN BENEFITS

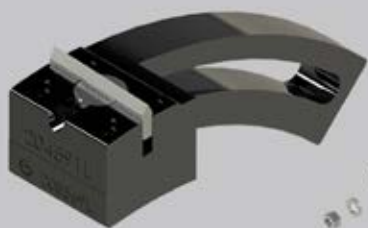
EASIER MAINTENANCE - Only the cassette needs to be removed to change the spring, leaving the block in place.

COST EFFECTIVE - The cassette can be replaced at a lower cost than a new S1 body and spares can be held in stock minimising downtime.

PARTS COMPATIBILITY - The S2 design will fit most machines and use the same spares (blades, holders & springs) minimising the need for different parts for each machine.



PRODUCT INFORMATION	2
FITTING INSTRUCTIONS	4-8
KNIFE / PART STOCK	9
TROUBLESHOOTING	10
BEST PRACTICE	11
SERIES 1 COMPONENTS	12
SERIES 2 COMPONENTS	13
BLADES	14
BLADE HOLDERS	15
SPRINGS	16
SPRING CAPS	17

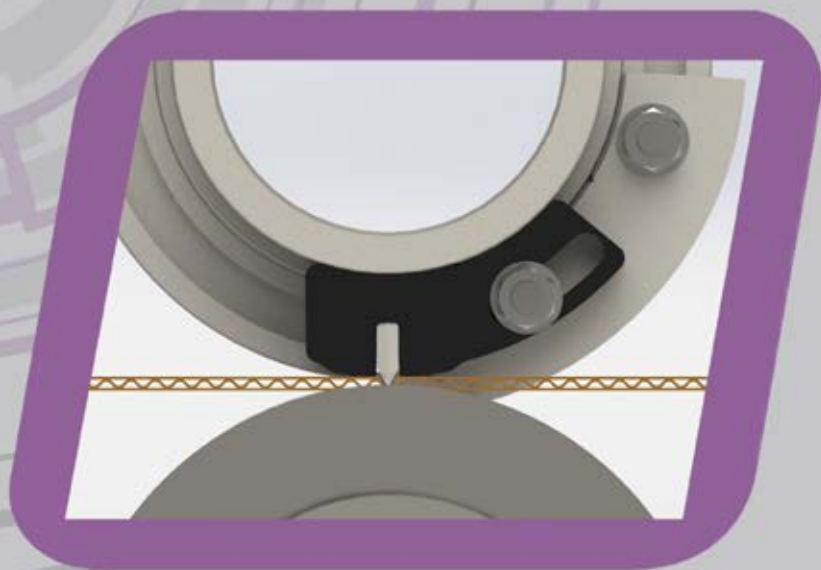




Remove existing stitch / glue flap blocks (and anvil if applicable) from the heads and open the shafts apart to maximum gap.

Fit the new lead and trail Shok Bloks® in the same position as original, using same fixings or alternative screws if required. If applicable fit new steel anvil(s) too.





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

Adjust the shafts closer so that the blade compresses approx 1mm or 0.040".

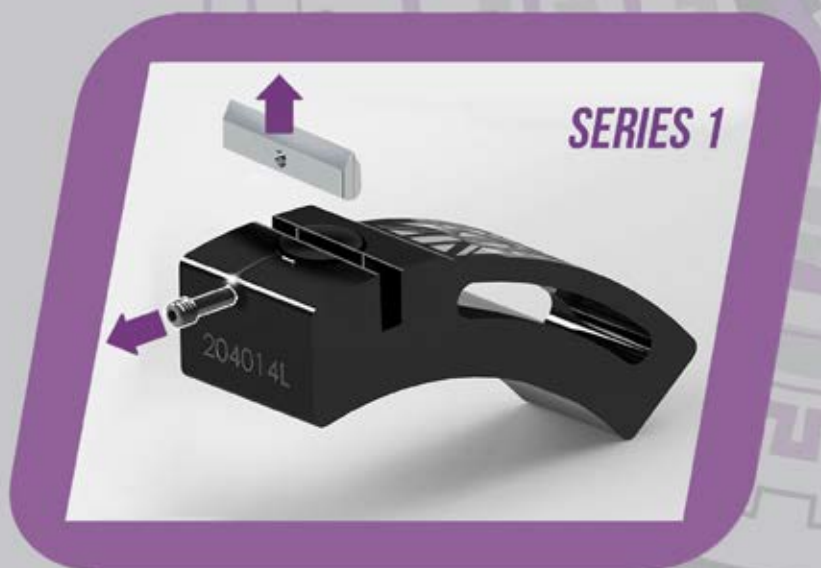
Slowly rotate the heads and test the cut of both Shok Bloks®.

Change blade height if necessary to suit nip pressure.

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

Run machine at normal speed.





Blades can be changed by using the T key to remove the blade screw. When replacing the blade, do not overtighten the screw as it does not clamp the blade.

Replace blade when blunt and cutting fails.





SERIES 1 - 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 the blade is out.

With the blade holder aligned to access blade screw, fit blade, re-fit spring and spring cap and tighten until it stops. *Do not overtighten.*

SERIES 2 - 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 the blade is out.

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



6.5MM / 1/4" MAX

**SERIES 1**

6.5MM / 1/4" MAX

**SERIES 2**

INSPECTING

Regularly inspect and replace badly worn blades, springs and holders. If the performance is affected, periodically inspect the blade slot for wear.

When there is evidence of a widened slot in excess of approx. 6.5mm / 1/4" the Shok Blok® body / cassette needs replacing.

See trouble shoot / best practice guide.
Or contact your supplier for additional help.



1. LEAD BLOCK CUTS OK, TRAIL NOT OK

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

2. TAB WASTE STAYS CONNECTED TO BOX IN THE CORNER

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

B. Check blade is compressing against the anvil. Replace the blade if it's blunt. Check the spring and replace if undersized or split.

3. IF THE SHOK BLOK® (SERIES 1 ONLY) DOES NOT FIT CORRECTLY ON THE BOSS

Check to see if the spring cap has been fully tightened.

**IF IN DOUBT CONTACT
MBM OR
YOUR LOCAL SUPPLIER
TODAY!**

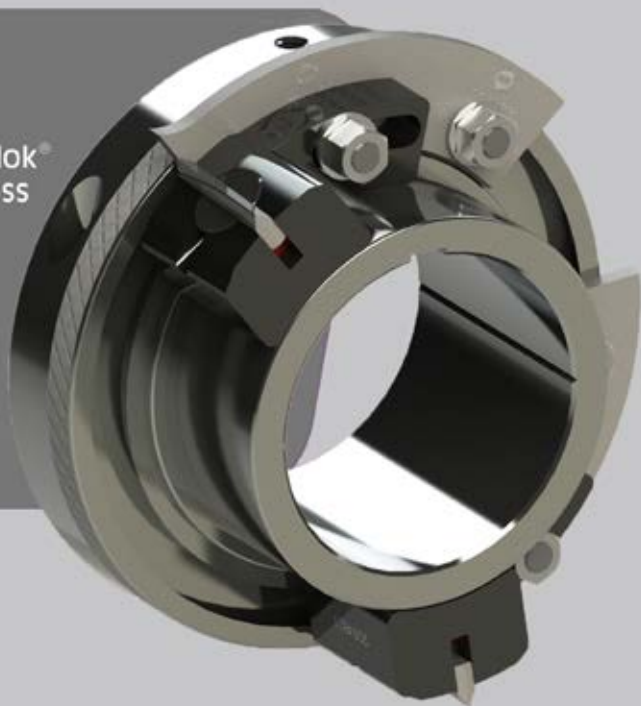


SHOK BLOK®

11

1. When cutting fails, replace both the blades and spring at the same time to maximise benefits. This avoids the cycles of new blades / worn springs or new springs / worn blades.
2. Always keep the blade compression / deflection to a minimum for optimum life performance.
3. Use a Teflon lubricant in the blade slot to prolong life. (MBM PN:300913)
4. Change blade holder when visibly worn around the top diameter as this prevents excessive movement of the blades.
5. Make sure the correct blade height is being used. Using the wrong blade may cause excessive wear on the components and reduce their working life, leading to downtime and increased costs.

Assembled Shok Blok® with upper slot boss and knives.



SHOK BLOK - BEST PRACTICE



SERIES 1

SHOK BLOK® SERIES 1 COMPONENTS

- 1 Blade
- 2 Body
- 3 Blade holder
- 4 Blade screw
- 5 PU spring
- 6 Spring cap



SERIES 2

SHOK BLOK® SERIES 2 COMPONENTS

- 1 Cassette screw
- 2 Blade
- 3 Cassette
- 4 Blade holder
- 5 Blade screw
- 6 PU spring
- 7 Body

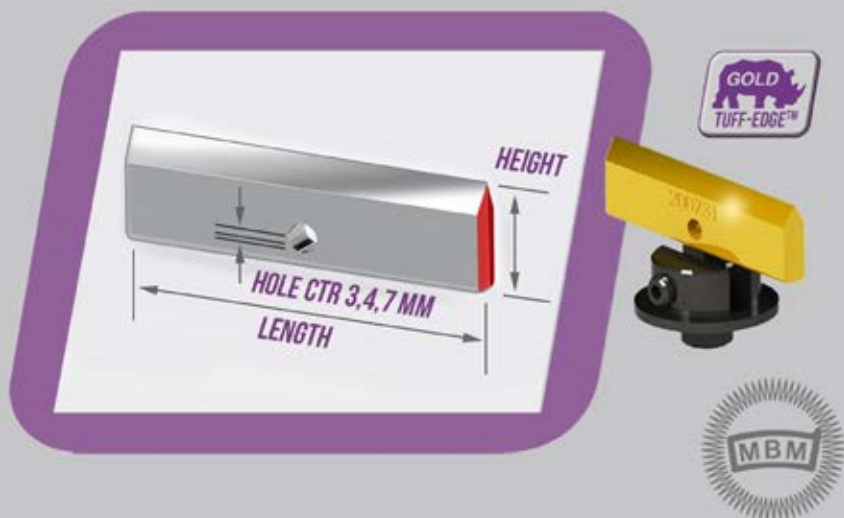


Blades are precision made from High Quality tool steel for trouble free performance and longevity.

BLADE COLOUR		BLADE HEIGHT (MM)	BOARD/NIP THICKNESS (MM)		
			TYPE		
			3	4	7
	BROWN	11	2.5		
	ORANGE	12	3.5		
	PINK	13	4.5	2.5	
	GREY	14	5.5	3.5	
	BLUE	15	6.5	4.5	
	RED	16	7.5	5.5	
	YELLOW	17		6.5	
	WHITE	18		7.5	
	GREEN	19		8.5	
		20			3
		22			5
		23.5			6.5
		24			7
		25			8
		27			10

Blades come in a variety of different sizes ranging from 11 - 27mm height to accommodate all cutting needs.

Tuff-Edge™ GOLD treatment available - enquire for details.



TYPE 3



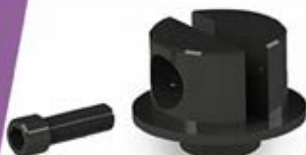
3mm Hole Centre

TYPE 4



4mm Hole Centre

TYPE 7



7mm Hole Centre

**TORX
SCREW**





PU - SPRINGS

RED - HEAVY DUTY

ORANGE - STANDARD



STEEL - SPRINGS

GREEN - MEDIUM

BROWN - HEAVY DUTY



SHOK BLOK®

17

Spring caps are only used in our Shok Blok® Series 1 to hold the spring and blade holder in place.



SPRING CAPS - GUIDE

To remove the spring cap from the Shok Blok®, first remove the Shok Blok® from the machine if it is attached. Insert the supplied hex key and unscrew the cap.

Unscrewing the cap will allow access to the spring and the blade holder for maintenance.

Please make sure the cap is fully tightened to ensure a perfect fit and cut with your machine.

