Burris Machine Co. Shear Cut Knife Holder
Model 6610-SC
Installation and Adjustment Instructions

[#1] Knife Holder Mounting:

Mount the bottom knife rings (female) in the positions required to achieve the cut widths desired.

On the Knife Holder, slide valve [B] up and valve [A] down (see Figure 3.)
Mount the Burris Machine Model 6610-SC on the dovetail bar so the blade will clear the bottom ring substantially and apply minimal air pressure (approximately 30 PSI) to the supply manifold and attach the supply hose to the quick connect coupling. **Caution! – Make sure everything is clear of the knife holder blade!**

Slide valve [B] down slowly.
Position the knife holder on the dovetail bar above each bottom ring so that the blade is approximately 1.5 to 2.0 mm (0.06" [approximately the thickness of a penny] to 0.08") away from the bottom ring as shown in Figures (1 & 2 below) and tighten the Lock-Nut [C] as shown in Figure 3. The slide valve [B] may have to be cycled up to release the Lock-Nut.

Adjust the depth of the upper knife so the overlap with the bottom ring is approximately 1.0 to 1.5mm (0.04" to 0.06"), depending on the material being cut. Minimal air pressure may be used to help in adjusting the Model 6610-SC (30
PSI or less – see pneumatic diagram.)

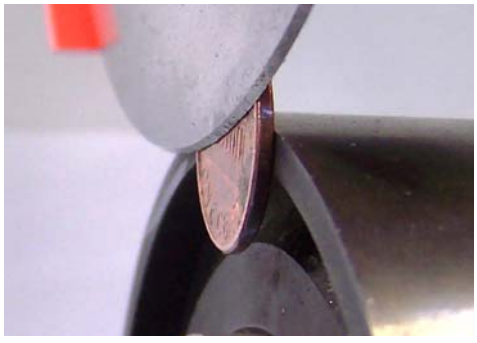

Figure 1.

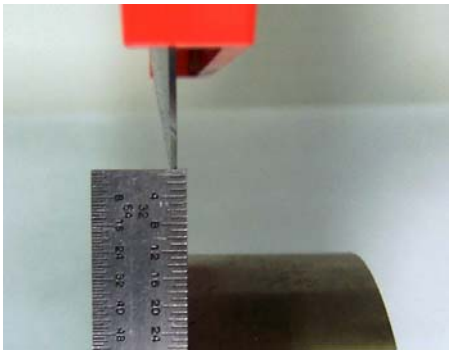

Figure 2.

[#2] Blade Depth Adjustment: Refer to Figure 3.

Apply minimal air pressure to the supply manifold and attach the supply hose to the quick connect coupling.

Slide valve [A] down, so the blade will remain shifted away from the bottom ring.

Slide valve [B] down, so the blade carriage is extended toward the bottom ring.

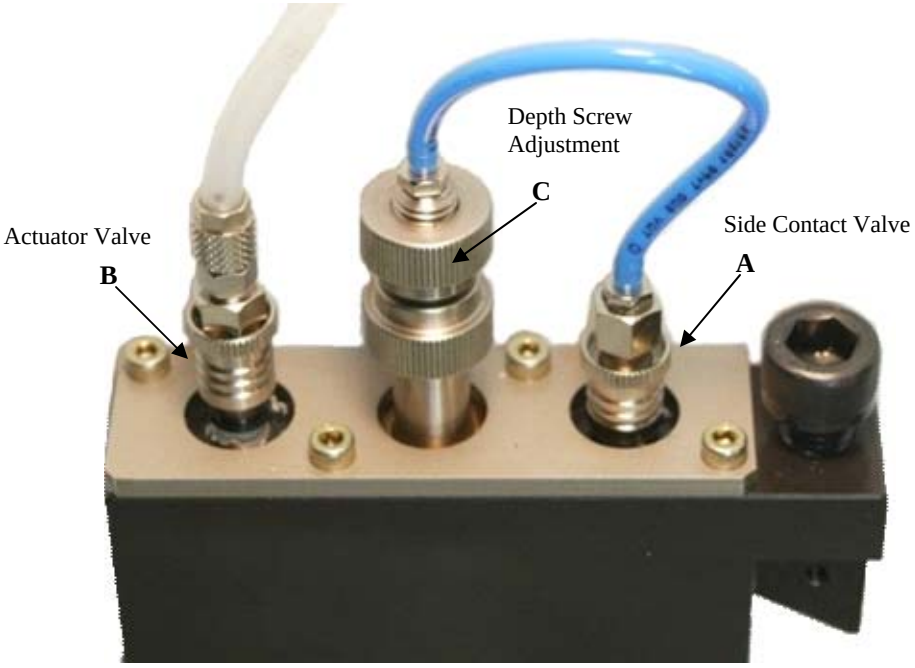

Figure 3

Adjust the Depth Adjusting Nuts to achieve the desired overlap of the top blade to the bottom ring. If necessary, slide valve [B] up to loosen the top nut while holding the bottom nut. Turn both nuts counter-clockwise to increase the stroke or clockwise to decrease the stroke. Check for proper depth of stroke and clearance by sliding valve [B] up and down. Once the desired overlap is achieved, hold the bottom nut and tighten the top nut against it.

While valve B is down, double-check the gap between the blade and the lower ring. It should be 1.5mm to 2.0mm away from the bottom ring.

Slide valve B up, then slide valve A up. Making sure that nothing interferes with the movement of the blade, slide valve B down. The upper blade should extend and move toward the bottom ring at the bottom of the stroke. If the blade does not contact the bottom ring, move the knife holder toward the bottom ring until it touches. Additional movements may be necessary later, after the *cant angle* is adjusted.

#[3] CANT Angle Adjustments:

Loosen the two 8mm hex head bolts (1) front, (1) rear, as shown in Figure 4.

Figure 4.

Figure 5.

Pivot the blade carriage, as shown in Figure 5, clockwise or counterclockwise, depending on the direction of the web travel. Generally, 1 to 2 degrees is sufficient.

Re-tighten the bolts and re-check the blade clearance by actuating valves Ⓐ and Ⓑ, re-adjusting, if necessary. Refer to Figures 1 & 2.