



1ST
STAINLESS
FLESHING &
SHAVING
BLADE

EXCALIBUR
FOR WORLD LEADING TANNERS



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EXCALIBUR USER GUIDE

EXCALIBUR blades are made of stainless, high-alloy, hardened, nickel-free chrome steel.

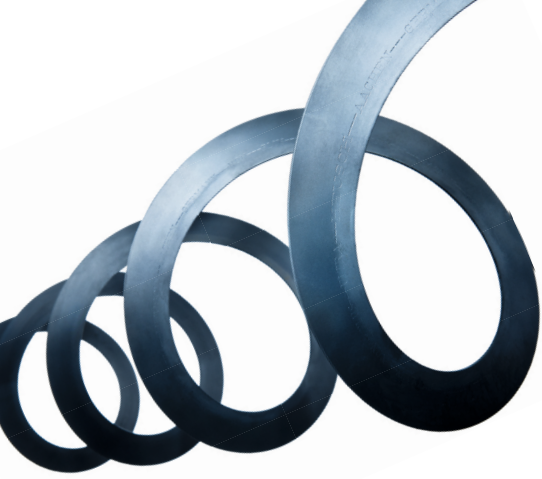
This steel is corrosion-resistant and extremely resistant to wear and deformation.

This results in some special aspects for installation and use - in particular for the shaving blades.

We have compiled the respective information for you in this user guide.

Our recommendations are based on extensive testing under industrial conditions and on representative field tests at our customers' premises.

Legend	
low	↘
middle	○
high	↗



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GRINDING COMPOUNDS FOR EXCALIBUR

EXCALIBUR blades cannot be used with standard grinding wheels or blocks. They do require our recommended specifications for selected manufacturers.

Ideally, start with the lowest possible in-feed and determine the optimal sharpening process for EXCALIBUR by slowly increasing the in-feed.

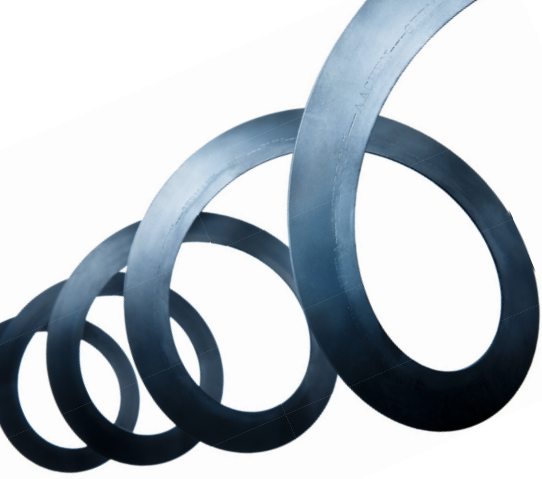
GRINDING WHEELS FOR BEVELLING

The following grinding wheels must be used for beveling:

Specification	Manufacturer	Bonding	Grinding wheel rotational speed*
A96 46 J 6V	Parini	Ceramic	low-medium
34A 46/3 J/8 VS2	Sebald	Ceramic	low-medium
23A 467 J8 V450	Norton	Ceramic	low-medium

Grind the blades carefully to avoid development of high temperatures. Do not cool the blades with water or emulsion!

* Please note the manufacturer's instructions



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ABRASIVES FOR LEVELING OUTSIDE THE FLESHING MACHINE AND THE SHAVING MACHINE

These grinding stones guarantee achievement of leveling in best possible time and with low-level heat development.

Use the following abrasives:

Specification	Manufacturer	Bonding	Chip volumes	Abrasive wear
23A 467 J8 V450	Norton	Ceramic	↗	○
34A 46/3 J/8 VS2	Sebald	Ceramic	↗	○
A96 46 J6V	Parini	Ceramic	↗	○



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ABRASIVES AFTER INSTALLATION IN THE FLESHING MACHINE

Use the following abrasives:

Specification	Manufacturer	Bonding	Abrasive wear
A99BR 46 K 6V	Parini	Ceramic	↘
34A 46/3 J/8 VS2	Sebald	Ceramic	↘

For leveling set the machine on “leveling mode”.

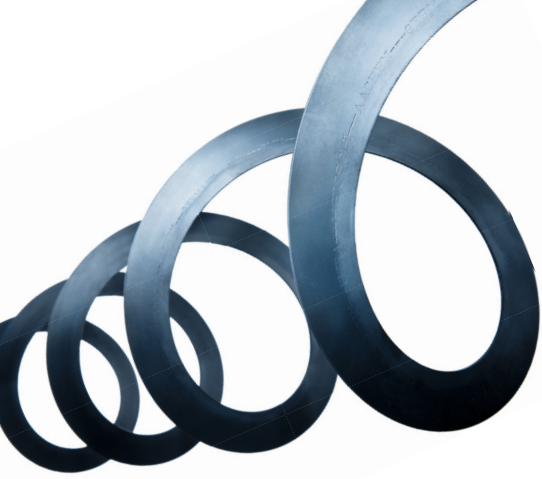
ABRASIVES AFTER INSTALLATION IN THE SHAVING MACHINE

Use the following abrasives:

Specification	Manufacturer	Bonding	Leather Surface	Abrasive wear	Blade Levelling	Need for adjustment when grinding
23A 467 J8 V450	Norton	Ceramic	fine	○	○	○
34A 46/3 J/8 VS2	Sebald	Ceramic	fine	○	↗	○
A96 46 J6V	Parini	Ceramic	fine	○	↘	○
72A 46/3 J/8 VS2	Sebald	Ceramic	fine	○	↘	○
A96 60J 6V	Parini	Ceramic	very fine	○	↘	↗
34A 60/3 J/8 VS2	Sebald	Ceramic	very fine	○	↘	↗
257 AH 606 J8 V450	Norton	Ceramic	very fine	↘	○	○
72A 60/3 J/8 VS2	Sebald	Ceramic	very fine	↘	↘	↗

For leveling set the machine on “leveling mode”.

After leveling the grinding setting of the machine must be on “0” and only then switch to the shaving mode.



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GRINDING WHEEL INFEED

How can I find the optimal grinding wheel in-feed depending on the type of leather to be processed?

Set the machine to run at the lowest possible grinding wheel in-feed and increase the in-feed in small increments until the required “permanent sharpness” of the blades is achieved.

Note

The following applies for correct setting of the grinding wheel in-feed:

The finer the granularity of the grinding wheel, the smaller is the amount of flying sparks during the grinding process in the shaving machine.

Contact between the blades and the grinding wheel is perceptible practically only by the sound.



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CAULKING

Settings of the caulking machine

Use the pneumatic hammer optimally at 8 to 10 bar / 116-145 psi pipeline pressure.

After caulking there should be a gap of approximately 0.5 to 1.5 mm between the copper and the upper groove edge. If you don't have the possibility to work with sufficient pressure, you shall decrease the feed of the hammer so far that the copper remains 0.5 to 1.5 mm below the groove edge.

**These dimensions are based on the Heusch-specific copper calculations.
For further information, please visit our website: www.heusch.de**

SHAVING PROBLEMS

What do I have to do if the leather surface is not fine enough?

Use abrasives with finer granularity.

See also table: "Abrasive after installation in the shaving machine"

Leather surface fine → Leather surface very fine.

After change of the grinding wheel run the grinding wheel in counter direction (machine's "leveling mode") for approximately 10 to 15 minutes. Change thereafter back to "shaving mode".

What do I have to do if the blades are no longer sufficiently sharp after operation in shaving mode?

Let the grinding wheel rotate briefly in counter direction (machine's "grinding-in mode") until the desired sharpness of the blades is restored.

Switch thereafter back to machine's "shaving mode".