

Aachen, March 3rd, 2016

Dear SIRIUS* user,

By design all types of SIRIUS* spirals differ from regular concave spirals. SIRIUS* spirals are manufactured utilizing an innovative and patented hardening process. Instead of tempering the complete width of the spiral, SIRIUS* spirals are purposely only hardened at the front. The spiral's back is comparably soft. This segmentation in a hard and a soft layer is essential to the self-sharpening function of SIRIUS* spirals.

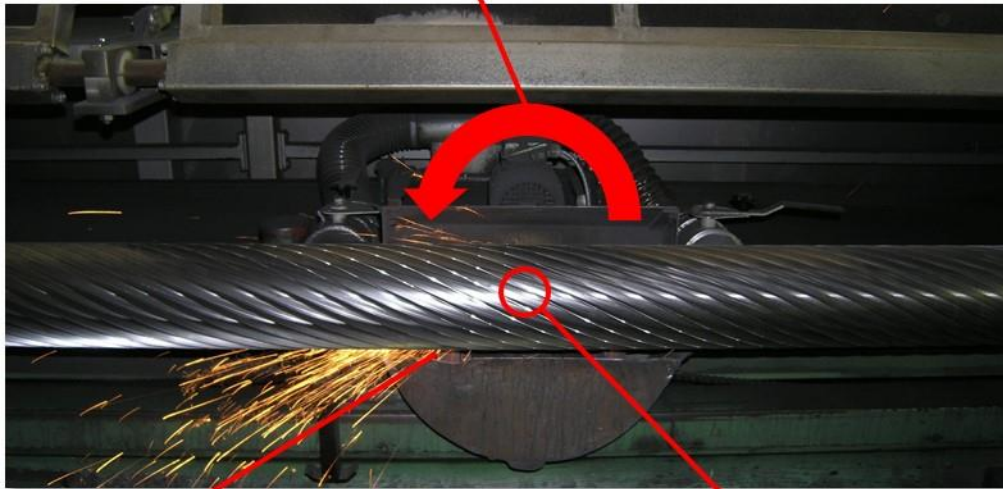
Generally speaking there is no handling difference between regular spirals and SIRIUS* spirals. Nevertheless we would like to clarify some issues that need your kind attention. For experts in re-blading and maintenance of shearing machines these points are probably trivial but to some who do re-blading not very often they might be helpful:

1. The SIRIUS spiral comes at a height of about 21.5mm. During the levelling and circular grinding (**picture#1**) the spiral is ground to a height of 19.5mm. At this level the spiral's file cut is fully formed and provides best cutting performance. Actually this process is no different to the treatment of the traditional concave spiral. Please see **picture#2** below.
2. For those having problems to establish the correct height of the spiral, Heusch will soon provide a feeler gauge. Please contact your Heusch representative to get your gauge.
3. For the levelling operation of SIRIUS spirals Heusch recommends the use of grinding cup wheel, disk or block coming with a 34A 46J/8 VS2 grinding compound or similar. In any case it is strongly recommended to use ceramic bound compounds. All grinding powders used for later finishing are the same as with the current spirals. The grinding powder quality "Finish" is most common.
4. At the end of the levelling operation the spirals might be left with a burr on the top. **Picture #3** shows a typical burr. This burr is created by the softer back section of the blade. This is normal and is strictly limited to the levelling process. For easy removal of the burr either use a wire brush or if possible give it some more grinding but ensure the cylinder rotates in **reversed direction** until the burr disappears.

As long as these 4 instructions are followed during the installation of SIRIUS* spirals success is very much warranted. Should you have further questions please contact your nearest Heusch representative or email us: sales@heusch.de

Picture#1

direction of rotation of the grinding cup wheel



direction of rotation of the cylinder

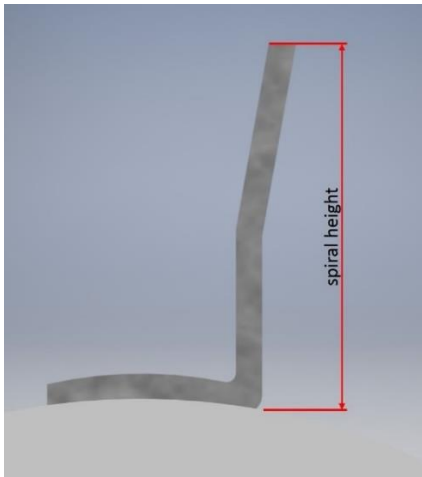


grinding cup wheel



burr

Picture#2



Picture#3

