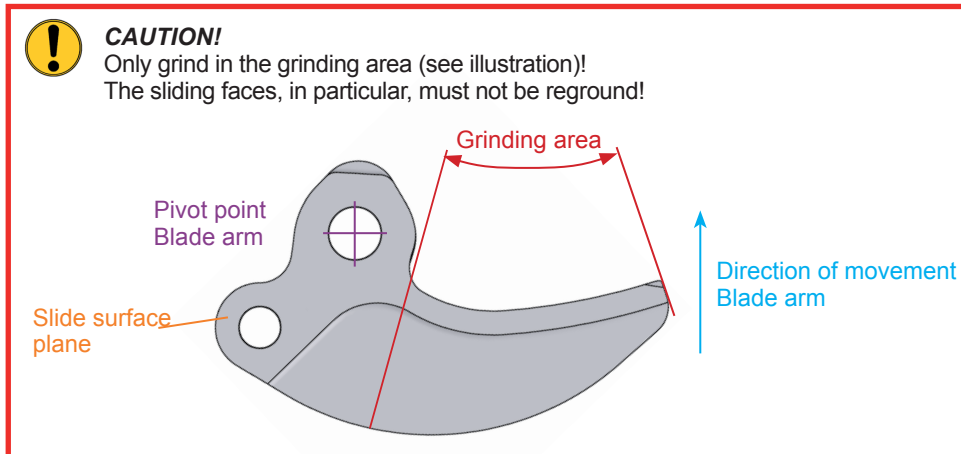


## Sharpening the blades

Only remove and smoothen any burrs!

Chips or deep grooves cannot be ground away. The blades must be replaced in these cases.



### CAUTION!

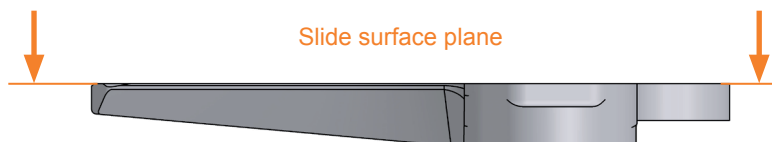
Only grind in the grinding area (see illustration)!  
The sliding faces, in particular, must not be reground!

### Tools required:

1. Use jaw protection on clamping device (e.g. vice) in order not to damage the blades
2. Grinder (e.g. angle grinder or belt grinder) with abrasive having a grain size of 80.

### Procedure:

1. Clamp the blade securely into the clamping device so that it cannot move, but with the grinding area exposed.
2. Carefully grind the burr away evenly until you reach the sliding surface level. (see illustration)



In addition, when grinding, you must make sure that the inclination of the cutting surface in the direction of the blade arm movement is not changed. Check the incline and smoothness of the ground surface, using a suitable measuring tool.



### CAUTION!

If you have not maintained the smoothness or incline, the proper operation of the blade is no longer guaranteed and the blades must be replaced.

**LUKAS**  
Because you never get a second chance

**LUKAS** Hydraulik GmbH  
Weinstraße 39, D-91058 Erlangen  
Tel.: (+49) 0 91 31 / 698 - 0  
Fax.: (+49) 0 91 31 / 698 - 394  
e-mail: lukas.info@idexcorp.com

Edition: 06.2010

Page: 1 of 1