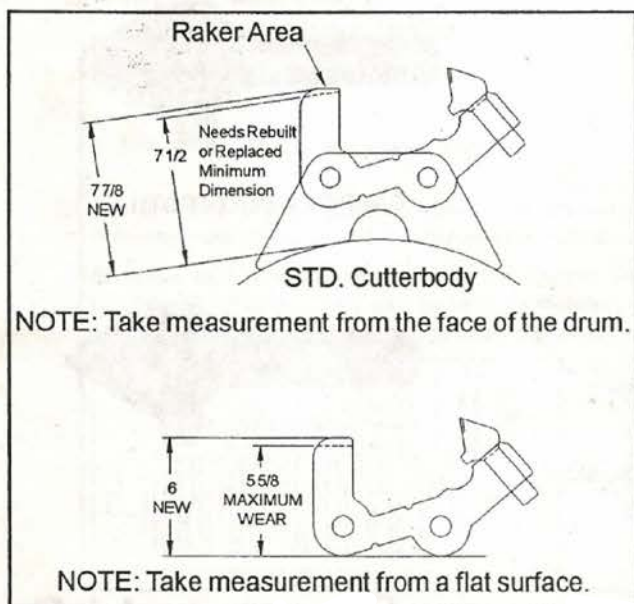


## CUTTERBODY

The Cutterbody used in the Beast has a leading edge referred to as the "raker". The raker is designed to control the depth of cut that the Cuttertooth will take. As the Raker wear it allows the Cuttertooth to take larger and larger cuts. If using a small hole screen taking large cuts means that the material has to beat around inside the Cutterhead housing until small enough to exit through the screen. This robs horsepower that could be used at the Cuttertooth. Also, taking bigger cuts puts undue stress on the Cutterhead shaft leading to possible shaft failure.

When new, the Cutterbody has a hard surface weld applied to the raker area. It is imperative that this area be maintained. The diagrams below show the height of the raker area when new and the maximum allowable wear. While in the machine these measurements are taken from the face of the Cutterhead drum. When worn, remove the Cutterbody from the Cutterhead and build up the raker area with a hard surface weld using the dimensions below as a guide. You could also lay a worn Cutterbody on a new one to see the amount of buildup necessary. If using a wire feed welder it is suggested using a Lincoln Lincore 60-0 or a Stody 101HC wire. In a stick rod try the Lincoln Wearshield 60 or the Stody Stoodite 2134. If you have excessive wear it is recommended that the Cutterbody be replaced with a new one. Be careful not to buildup above the height as when it was new as this will affect how the machine feeds.

**Never weld on the Cutterbodies while in the machine, as there is the potential for fire. It pays to have several extra Cutterbodies as replacements and weld up worn ones at your leisure.**



## CUTTERBODY BOLTS

The Cutterhead of the Beast uses a replaceable Cutterbody that is designed to fail should something foreign get into the machine. They take an enormous amount of abuse with the bolts that hold the Cutterbody in place being one of the critical components. During the initial design and testing of this machine a bolt was developed that is made special for Smoracy, LLC just for this application. The tolerances and the length of the shank make it unique to any other bolt on the market. Maintaining the proper torque of 700 ft.-lbs. on this bolt is also extremely critical. Using the wrong bolts or not keeping them tight allows for movement between the Cutterbody and the Support Arms which in turn leads to fatigue and failure. Once the Cutterbody is allowed to run loose the integrity of the hole in the Support Arm is lost and must be replaced. Other wise the bolt will never be able to keep tight again. If using an air wrench, check it to make sure that it is capable of reaching the proper torque.

A few customers have had Cutterbodies break loose from the Cutterhead. In every case it was because they were not using the proper bolt. A lot of lost time and money will occur if there is a failure due to using inferior parts. Any warranty claims will be denied if the Cutterhead was run with anything other than parts supplied by Smoracy, LLC.

When ordering new Cutterbodies new bolts must be ordered as well. Order extra to have on hand for future use. For the bolt, order part number 900-4904-45 and the nut is part number 900-4904-92.

