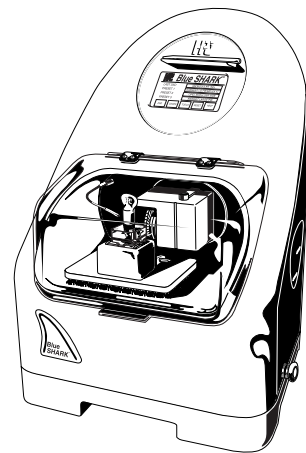


2. Cutter Wheels

- 2.1 *Cutter Wheel Descriptions*
- 2.2 *Replacing Cutters*
- 2.3 *Changing Cutters*



Count on quality. Count on HPC.
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2.1 Cutter Wheel Descriptions

The Blue SHARK™ is supplied with 6 standard cutter wheels.

CW-1011:	used for cabinet, padlock, and most vehicle applications
CW-14MC :	used for most standard cylinder keys
CW-90MC:	similar to the CW-14MC, but makes cuts with a steeper slope for special applications
CW-20FM:	76 degree cutter used for Sargent keys
CW-47MC:	87 degree cutter used for certain automotive keys
CW-1012:	for Medeco® keys

Flat Steel cutters, the Emhart cutter (CW-1013), the ASSA Cutter (CW-32MC), as well as others, are optional cutter wheels that are available for use with the Blue SHARK™ . Refer to the HPC website, www.hpcworld.com for a complete list of cutters and applications.

2.2 Replacing Cutter Wheels

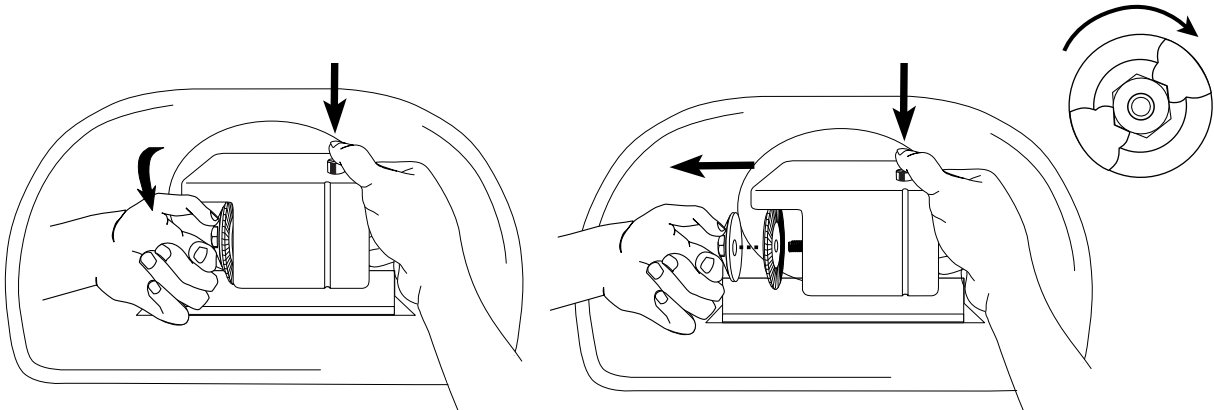
Cutter wheels eventually wear out and become dull. The life expectancy of a cutter wheel is dependent on the quantity and types of keys you are cutting and the composition of your key blanks.

HPC does **not** recommend sharpening cutter wheels. Each time a cutter is sharpened, a small amount of material is removed and the diameter is slightly reduced. This reduction in diameter will result in cuts shallower than the manufacturer's specifications.

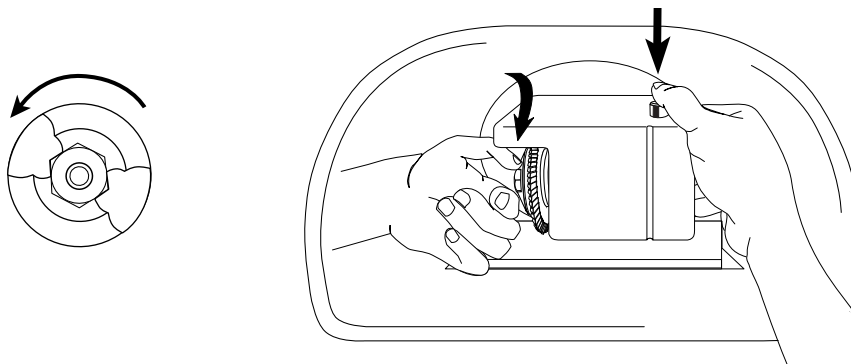
2.3 Changing Cutter Wheels

The Blue SHARK™ is equipped with the HPC Quick Nut; **tools are not required to change cutters**. The following procedure is recommended when changing cutter wheels:

1. Turn the Blue SHARK™ off. Hold the cutter head assembly and press down the shaft-lock button.



2. Turn the Quick Nut **clockwise** (toward the front of the machine) and remove it. Note: The locknut is reverse thread.
3. Remove the cutter. Slide the new cutter onto the shaft. **IMPORTANT NOTE:** Be sure the cutter is installed for a clockwise rotation, with the arrow facing the outside, so it can be seen.
4. Reinstall the Quick Nut, turning **counterclockwise** (toward the rear of the machine) onto the cutter shaft.
5. Hold the cutter head assembly securely and press down the shaft-lock button.



6. Tighten the Quick Nut. Note: Do not overtighten the nut.