

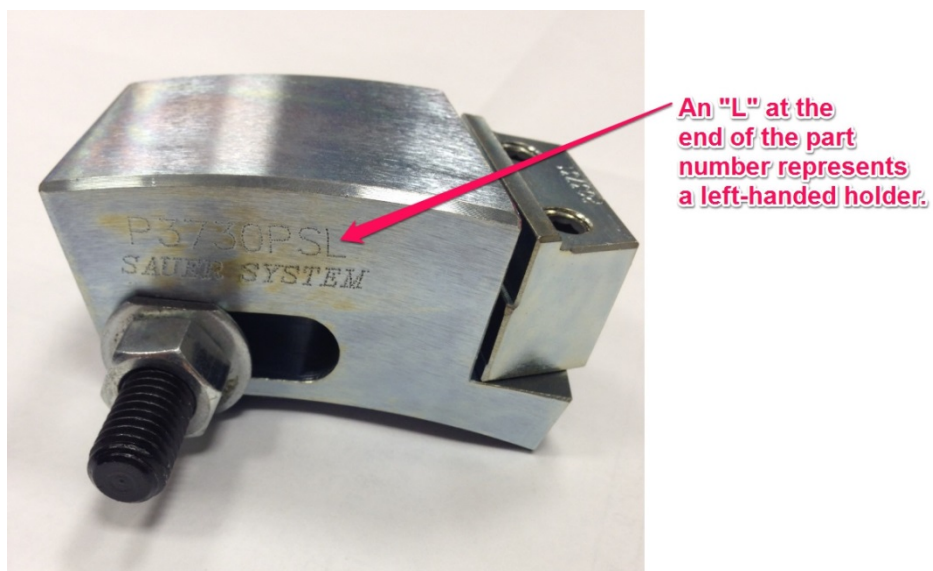
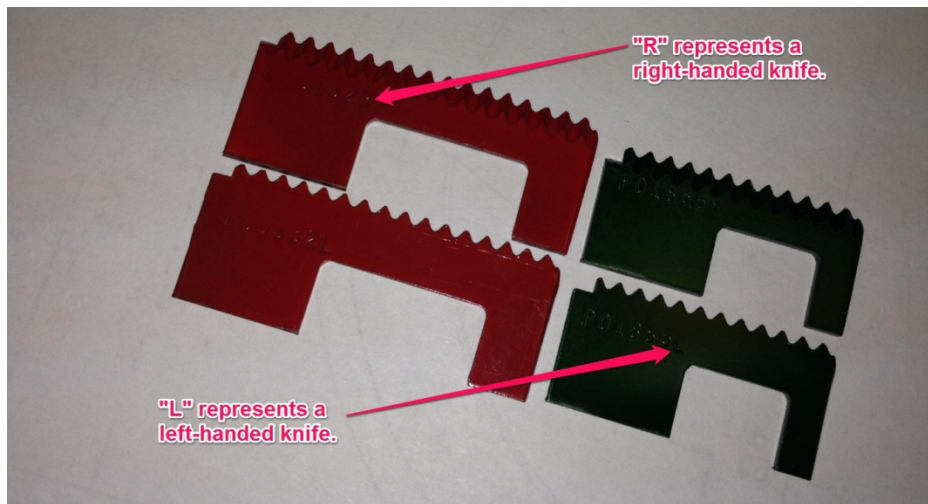
Proper installation of Sauer System stitch lap knives

1) Make sure to select the correct knife.

- a. Select the correct **handed** knife. Left-handed knives must go in left-handed (trail) holders and the right-handed knives must go in the right-handed (lead) holders.

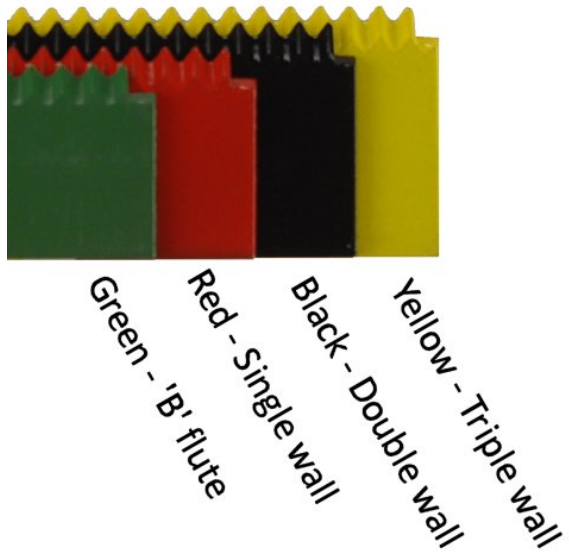
Pay attention to the markings on the knives and the holders. Knife part numbers ending in an "L" are left-handed and knife part numbers ending in an "R" are right-handed. The holders are similarly marked with "L" and "R" designations.

As noted above, and with few exceptions, the right-handed holder is the **lead** holder and the left-handed holder is the **trail** holder.

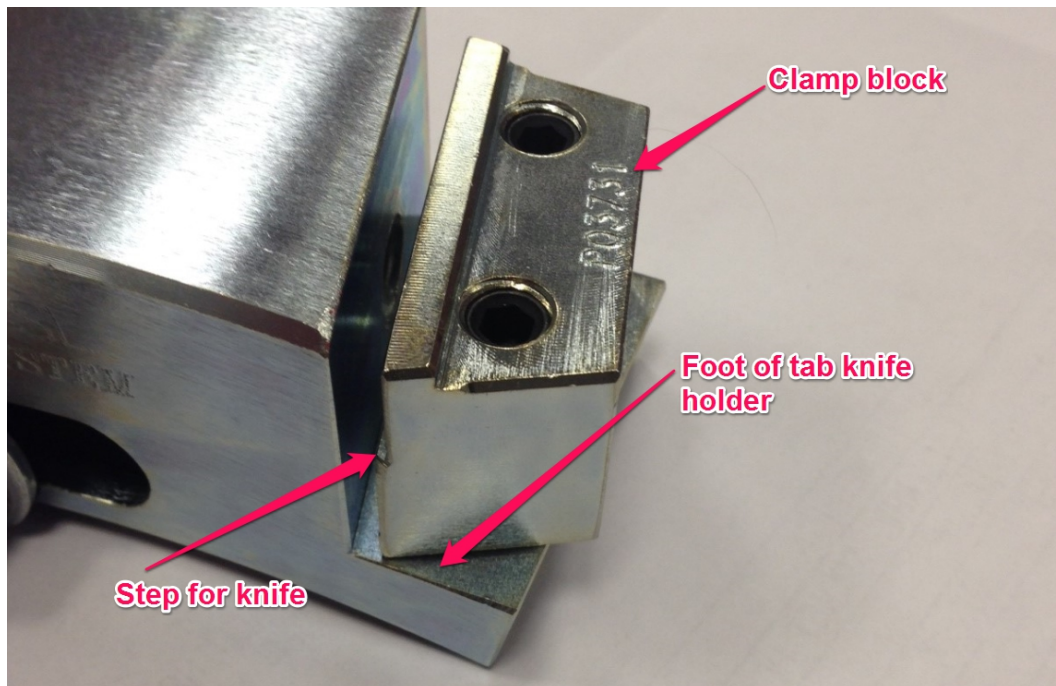


- b. Select the correct **height** knife.

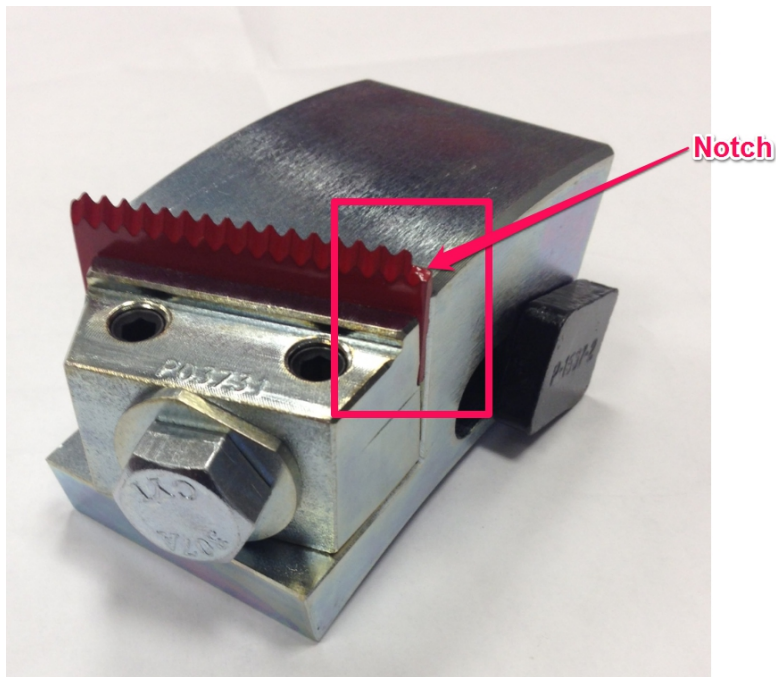
Green knives are designed for cutting B-flute and red knives are designed for cutting C-flute. Black knives are designed for cutting heavy single wall and double wall, yellow knives are designed for cutting double wall and certain grades of triple wall.



- 2) Ensure that the clamp block is seated on the foot of the tab knife holder. Insert the knife on the step of the clamp block, between the clamp block and the holder.



- 3) Ensure the knife is mounted such that the notch is flush with the edge of the holder and therefore butts up to the male slotting blade.



- 4) Jog the upper slotting shaft around one time and ensure the notch on the tab knife just “kisses” the 3/32” (thin) blade on the lower glue tab cutting head. If the knife “misses” the blade, loosen the clamp block and use the jacking screws to raise the block until the correct contact is made. Both screws should be tightened the same amount, 1/4 turn at a time.

