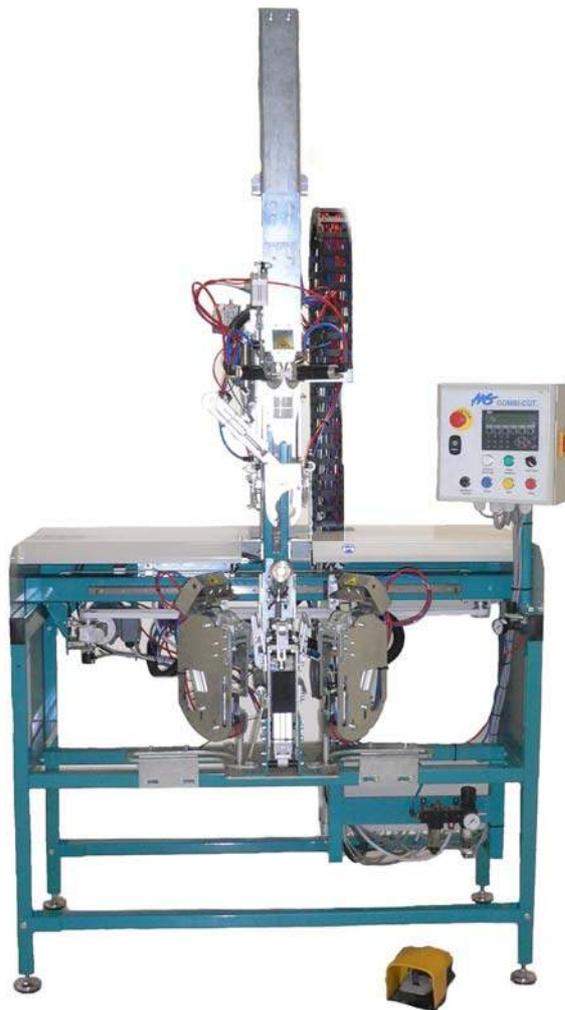


USERS MANUAL



HG COMBI CUT

Slicing machine with update



We thank you for buying the new HG Combi Cut.

Hedensted Gruppen A/S always try's to produce quality products, which you can count on. We are sure that you will be pleased with your new machine. To make sure that you get the most advantages from the machine from the start, it is important to study the functions very carefully.

The users manual contains, all the technical details and diagrams, an examination of the basis adjustments, a schedule with trouble shooting and mending of these, and a new section called "often asked questions" – or FAQ.

There are also small sections of spare parts with item numbers, which can be very useful.

There are pictures at the back of the manual of the machine and its parts. If you need service, it can be a great help both to you and our service team that we jointly according to the pictures can trace, where the problems are at the machine.

Therefore it is important that you always know, where the users manual is. We suggest that you keep it in the electric cupboard at the back of the machine.

From the factory the machine is rough adjusted, but because of the difference in mink, it is not sure that it fits 100 % to your mink.

An employee from Hedensted Gruppen will make the fine adjustment.

Before you get a visit for a start up, we will ask you, and the operator to read the users manual thorough, and to make sure, that the persons, who are going to work with the machine are present during the visit.

You also must make sure, that there are supplies of air and power 380V, and that it is lead to the machine.

Hedensted Gruppen A/S wishes you great pleasure with your new HG Combicut.

Kindly regards

HEDENSTED GRUPPEN A/S

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2. Machine information.

HG Combi Cut TYPE:.....

MACHINE NO.:..... YEAR:.....

CUSTOMER:.....

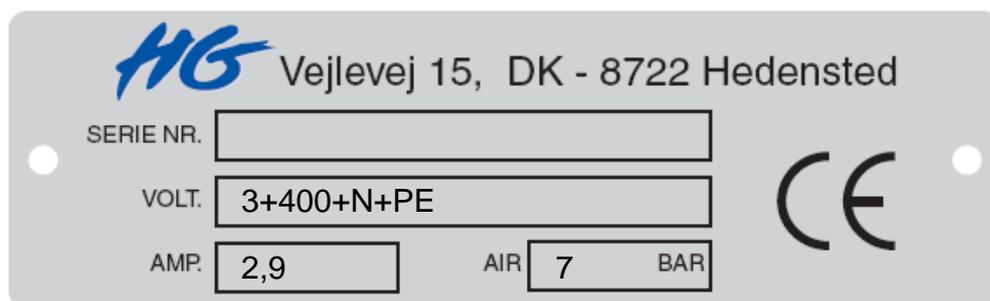
DEALER:.....

.....

.....

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Type Sign:



3. Introduction.

HG Combi Cut is used for cutting up mink.

The slicing machine is constructed to carry out a correct cutting of the male/female mink combined with loosen the behind legs in one working operation.

The capacity of the machine with the leg loosener are up to about 180 pieces of mink pr. hour, and without the leg loosener up to about 350 pieces pr. hour (Both values are with trained users).

At the same time the machine has a flexible working area, which ensures a correct slicing of mink of variable sizes.

3.1 Construction

HG Combi Cut is constructed in surface treated steel with painted shield. All the components are of the highest quality, and this combined with a well-arranged operation indicates, that this is a machine of high quality. Vertical and horizontal movements run on precision ball shears, which ensures a good repeatability.

3.2 Warranty.

There is 1 year of warranty on the HG Combi Cut.

Defect parts can be replaced, if the defect can be assigned to a fabrications error. Errors, which can be assigned to freight is not included in this warranty.

In cases of irresponsible treatment of the HG Combi Cut, no warranty is given, either on the machine or on damaged skins.

4. Warning.

Read this users manual **thoroughly** before using the machine.

Avoid staying too close to the machine, when you connect air and electricity, because the moveable parts can react quickly.

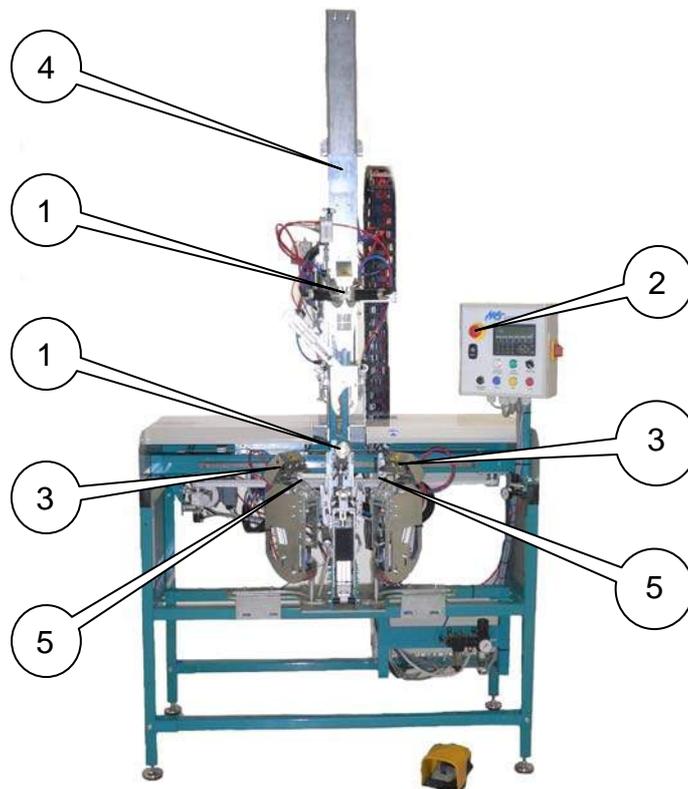
The operator must have instructions in use of the machine.

The slicing must only be used for slicing of mink.

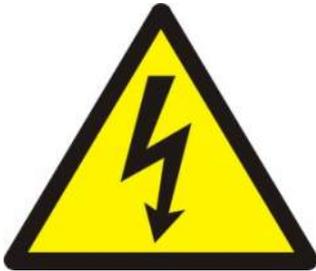
Wrong use or ignorance of the security instructions can cause damages on the body or breakdown of the machinery.

Pay attention in following sectors:

1. Look out the machine contains rotating knives. (1)
2. Emergency stop must not be covered or put out of function. (2)
3. The slicing machine contains vertical and horizontal moveable knives. (3)
4. Look out the slicing machine contains vertical moveable parts.(4)
5. There is a risk of jamming your fingers in the paw holder. (5)
6. By use of the machine you have to use eye protectors.



4.1 Hazed signs.



DANGER – HIGH VOLTAGE

The operating box of the machine contains high voltage. Because of the danger, the box must not be opened by unauthorized employees.



DANGER – ROTATING PARTS.

Avoid touching the moveable parts of the machine with fingers or clothing, this can cause damages on the body.



DANGER – SHARP KNIVES.

The machine contains more sharp knives, both rotating pneumatic moveable. Avoid touching with fingers and clothing, this can cause damage of the body.



EAR- AND EYE-DEFENDERS DEMANDED.

During operation of the machine glasses must be used, because hair, sawdust and other objects can be thrown out.

During operation ear defenders must be used, because the sound level of the machine exceeds the normally allowed.

5. Setup of the Combi Cut.

The HG slicing machine has to be placed on a solid and plane floor, so that the machine can be operated standing or sitting on a special chair.

The height of the room must minimum be 3,00 cm.

The legs of the machine have to be adjusted, so that it stands in level and is steady without tipping. After setup you can remove the transport fittings on the legs of the machine by help of the 4 bolts, if they annoy the user.

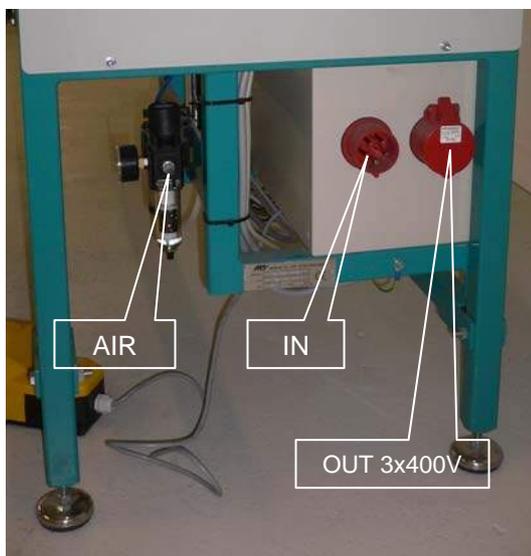
Notice that the weight of the machine is 300 kg.

Attention: Keep the transport fittings, if the machine has to removed.

5.1 Connection

Electricity:

The HG Combi Cut is fit with a 16A CEE-socket to which 400 volt is connected with zero and earth. The machine has a maximum power consumption on 2,9Amp during running.



Air:

The slicing machine demands a compressor pressure on min. 7 bar, and an air supply on min. 500 l/min. The air is connected with an air coupling of the Cejn 320.

To avoid stop in the slicing, it is important that the air, which is used in the slicing machine is free of water and dirt, as well as rust from old pipes.

Warning: The moveable parts will react quickly by connection of air.

Air tube and electric cable must not lay loose on the floor, because of risk of personal damage.

5.2 Connection of extra equipment.

The HG Combi Cut is fit with a 16A CEE socket with 3x400V. The socket is switched on and off on the main switch on the operation panel of the slicing machine. Extra equipment, such as HG Grid conveyor or HG Transport belt, which has to run at the same time as the slicing machine, can with advantage be connected to the socket.

5.3 Relocation

Before moving the machine you have to disconnect the air- and electricity connection. Pay attention, the moveable parts of the machine can change position, when the machine vents.

Mount the transport fittings on the legs of the machine, and move it with a palletizer. Pay attention that the cables and the tubes of the machine are not squeezed.

Warning:

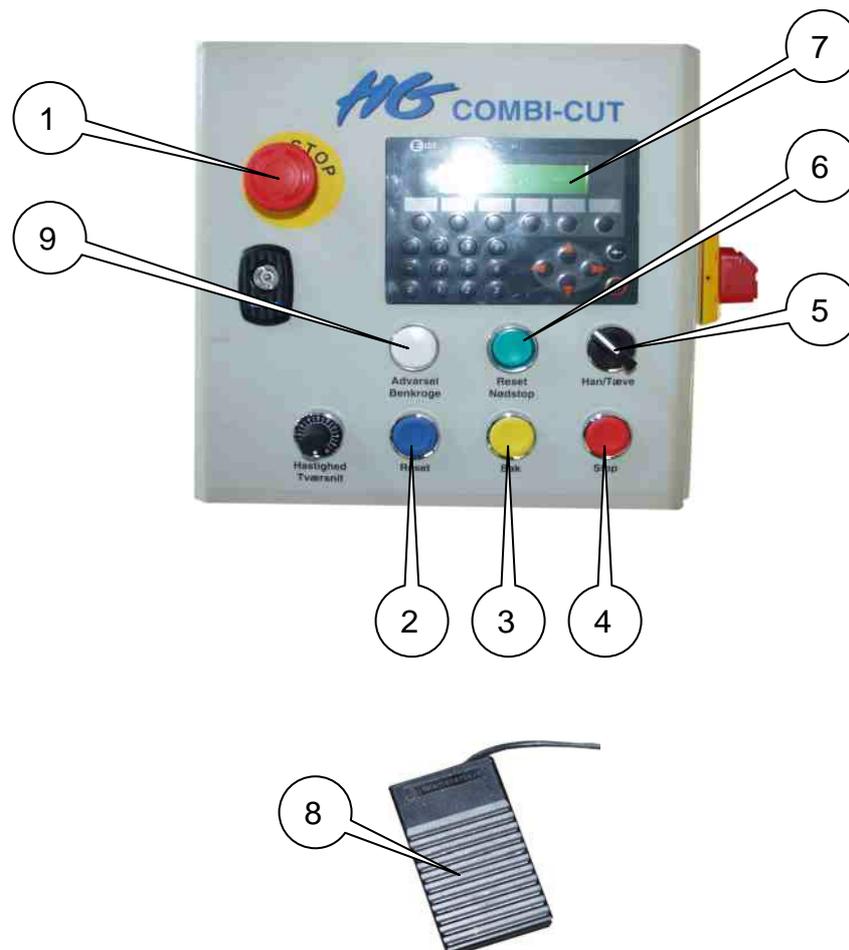
Do not lift the machine in the moveable tower.

Notice that the weight of the machine is 300 kg.

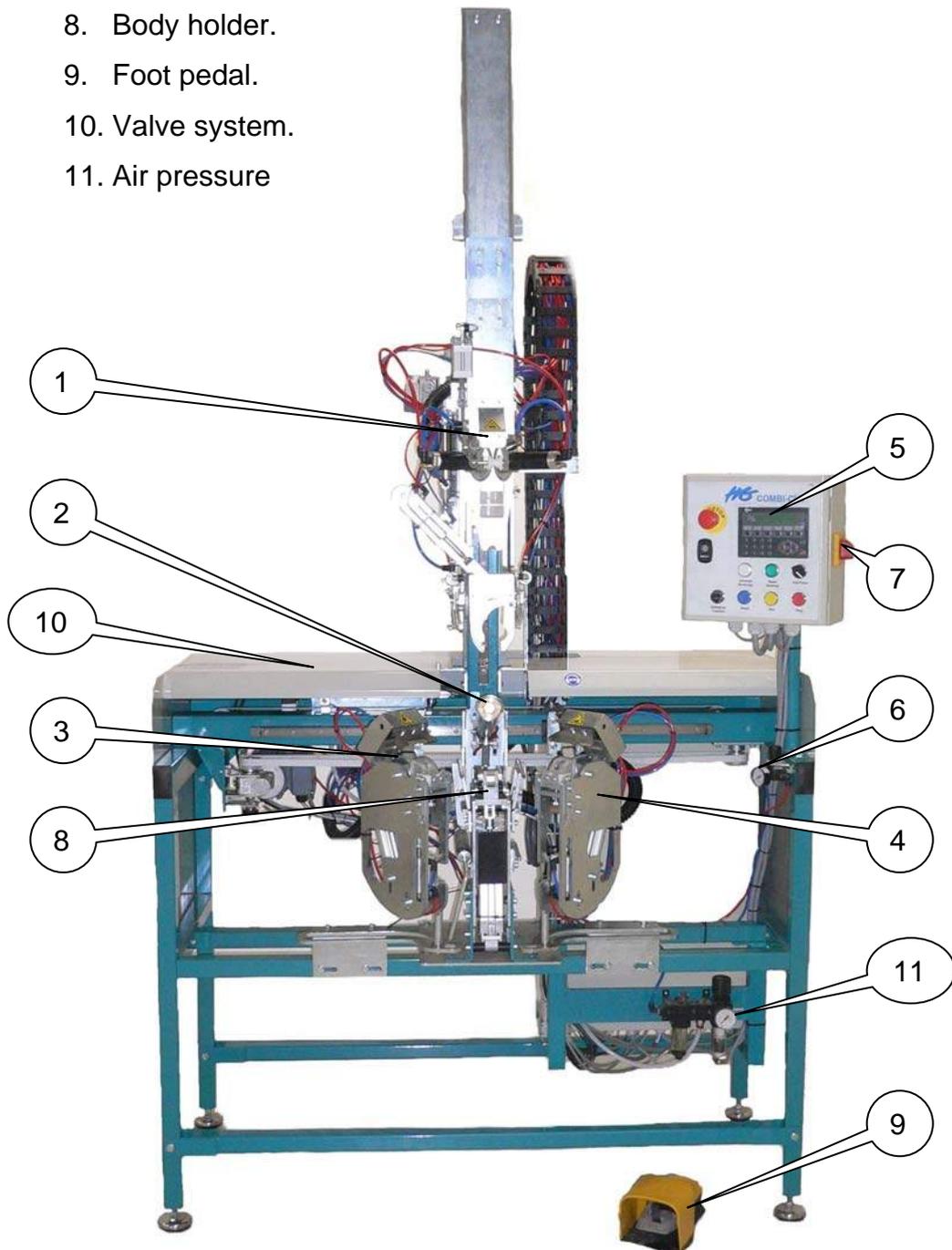
By setup on a new location repeat the procedure, which is described under section 5.

6. Operation terms.

1. Emergency stop.
2. Reset.
3. Reverse – use by wrong inserted animal at the behind leg loosener procedure. By activating and simultaneous press on the foot pedal you can reverse in this sequence.
4. Stop – possibility for stopping between every sequence.
5. Male/Female reverser.
6. Reset emergency stop. After activation of emergency stop use this.
7. Mac panel. (See the section about programme)
8. Foot pedal.
9. Lamp – blinks before hooks to the hind leg loosener closes.

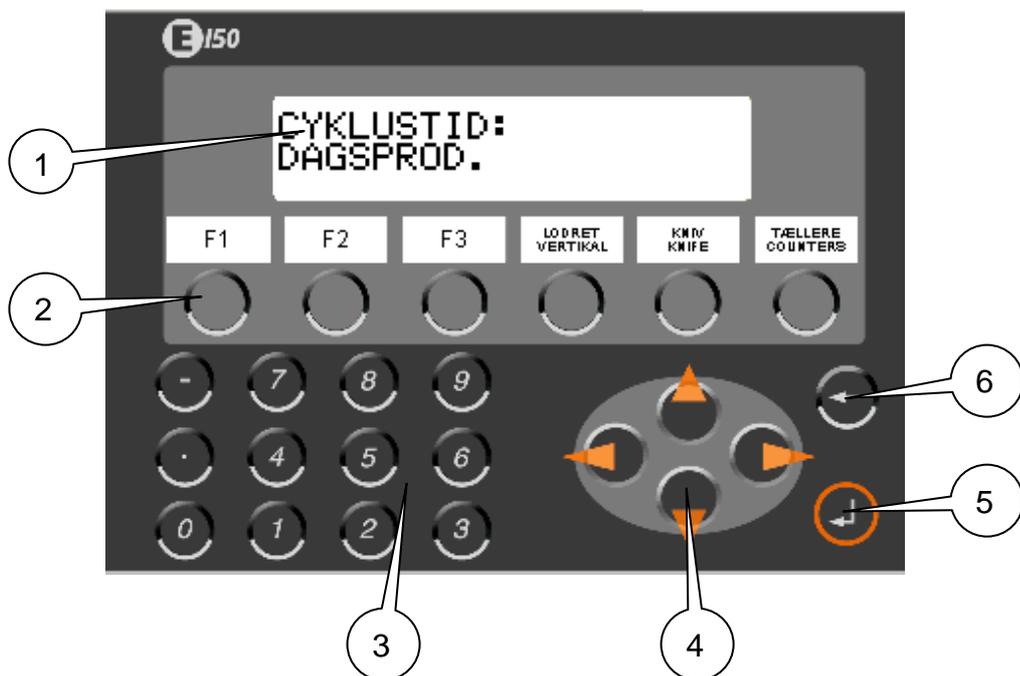


1. Tower with tail roll, tail slicing and spade for belly.
Spade for back and tail, and pull off hooks for hind legs.
2. Cross knife.
3. Left paw holder/clip/cut system.
4. Right paw holder/clip/cut system.
5. Operation panel (MAC Panel).
6. Adjustment of stretch pressure.
7. Main switch.
8. Body holder.
9. Foot pedal.
10. Valve system.
11. Air pressure



7. Operation of the Mac panel

On the operation panel of the slicing machine there is a Mac panel with following function buttons. The panel is used to adjust the machine to the user, but it can also inform the operator with different statistical information.



1. Screen.
2. Data buttons – press to enter the individual menu.
3. Numeric pad – for data entry and change of values.
4. Arrow keys – you can move the cursor in the direction of the arrow.
5. Enter – press after changing of value.
6. Delete – erase the typed values.

7.1 Programme specifications

The pictures of the Mac panel below, are divided in the different menu, after which the specific screen pictures can be found with the arrow keys.

The numeric values can be changed by pointing out the value with the cursor. Write the wanted value and press Enter.

By starting up the machine following screen pictures appears:

EMERGENCYSTOP NOT READY
PRESS GREEN RESET

Screen picture by starting up the machine or when emergency stop has been activated. Press the green reset button in order to zero fill the security function.

RESET THE MACHINE
PRESS BLUE RESET

The screen picture shows if the machine is not in reference position. Press the blue reset button and the machine will run a reset cycle.

Warning: The machine moves by reset.

Main menu (counter menu):

CYCKLE TIME:
DAILYPROD.:

CYKLE TIME: Shows time for last sequence in seconds.

DAILYPROD.: Shows number of sequences.
Operator can change the counter



TOTAL PROD:

TOTAL PROD: Shows total production of the machine.
Cannot be changed.

Key F1:

LANGUAGE:
PROGRAM DATE

Here you can change the language of the display.
Press 0 for Danish or 1 for English.

Program date shows which program version there is in the PLC



LOGIN LOGOUT

Can only be used by a HG Service man.

Key F2:

Can only be used by a HG Service man.

Key F3:

STR.POS Knife M: (mm)
STR.POS Knife F: (mm)



Extra stretch: (sek)

Adjustment of stretch length for Male and Female before the knife starts running. If you type 50mm, the machine has to stretch the animal 50 mm from the starting position before the knife moves to the right.
If you a high stretch pressure, you can type a small value, because the knife starts to position earlier.

Adjustment of extra stretch time. Increasing this value makes it easier for the machine to find the correct cross cut position. At 0.1 sec the machine runs as fast as possible, and are default settings. If the stretch pressure is very low, it may be necessary to increase this time, so that the operator gets more time to put the animal correctly in before the knife reads its cutting position.

If the cross knife runs left and will not continue running, the knife has found its position before stretching of the animal is done, and margin between stretch and cross sections are too large. Reset the machine and set up stretch time a bit.

Key Vertical:

Spade down Male:
Spade down Female



Leg hook close MA:
Leg hook close FE:



Tail roll in: (s)
Step vertical: ON/OFF



Step Tailhook: ON/OFF



Adjust how deep the belly spade has to run down by respectively Male and Female.

Adjust how far down the hind leg hooks has to run before they close together.
You can also adjust for respectively Male(MA) and Female(FE).

Number of seconds from the belly spade runs to bottom and before the tail roll runs in and the spade runs up again.
You can disconnect the foot pedal to the tail spade and the tail hook. After the tail hook is down, the machine finish without step.

Step tailhook is only active when vertical step is set to OFF. Here you can select if the operator wants a step between the tailhook close and the tower going up. The feature can protect against pelting error at the tailhook when running without vertical steps.

Leg hook: ON/OFF

You can switch off the hind leg loosener module. Now the machine will run as a ordinary slicing machine.

Adjust the machine to run with paw clip (AF) or paw cut (PAA).

Belly spade speed:
Skinloosener speed:

Adjust the speed the belly spade runs down with.

Adjust the speed the tower runs up with, when you loosen the skin on the legs and the tail.

Leg hook speed:

Adjust the speed the leg hooks run down with.

Startposition M: mm
Startposition F: mm

Setting the tower's starting position in Male and Female program. The distance calculated from the tower's top position.

Open Bodylock M: mm
Open Bodylock M: mm

Setting the position in the Male and female program where the skinloosen sequence is completed, and ii releases the animal. This way the machine does not have to run all the way to the top if it is not necessary. When the tower has reached the position, it releases the animal, and the next cycle may begin. The distance is calculated from tower top and down.

Key knife:

Knife corr. L:
Knife center:

Correct the movement of the cross knife towards left.
The higher value the longer the knife runs towards left.

Correct the centre position of the cross knife.



Knife corr. R:
Paw cuts male:

Correct the movement of the cross knife towards right.
The higher value the longer the knife runs towards right.

Number of cut the paw knife has to cut in male setting.



Paw cuts female:
Knife stop - L ON/OFF

Number of cut the paw knife has to cut in female setting.

Here you can turn on and off, the stop of the cross knife.
At stop, the knife only drives on by activation of the foot pedal. If you keep down the foot pedal after start the knife runs without stopping.



Grinding ON/OFF

Grinding function. Press this button to turn the knives on and off manually.



Paw blow: ON/OFF
Paw OF/ON

Blow of paws can here switched on and off. Blow can only be turned ON, when running with option Paw OFF.

Adjust the machine to run with paw clip (OF) or paw cut (ON). When paw on function is used, paw blow cannot be turned ON.



Cutting speed M: %
Cutting speed F: %

Setting the cross cut speed for Male and Female program.

Speed entered in % of max speed.

Key counter:

Return to counter menu (main menu).

8. Starting up the HG Combi Cut

The below procedure is made without mink.

1. Connect Electricity 3x400V+0+PE
2. Connect air Min. 7 bar

Warning: The moveable parts will react quickly an run to starting position.

3. Check input pressure (7 bar) - Page 11, point 11
4. Adjust the input pressure (7 bar) - Page 11, point 11
5. Emergency stop has to be disengaged - Page 10, point 1
6. Press the button Reset Emergency stop – page 10, point. 7
7. Press the button Reset - Page 10, point 3
8. Press the foot pedal - Page 10, point 9

Warning: Now the machine will run a cycle.

8. Watch the stretch pressure - Page 11, point 6 (min. 1 bar - max. 4 bar)
9. After running a cycle the machine returns to starting position.
 - 9.1 You can adjust the stretch pressure (page 11, point 10)
 - 9.2 Adjust other things in program.
10. Repeat this procedure point. 7 to 9, until the machine has the wanted pressure.

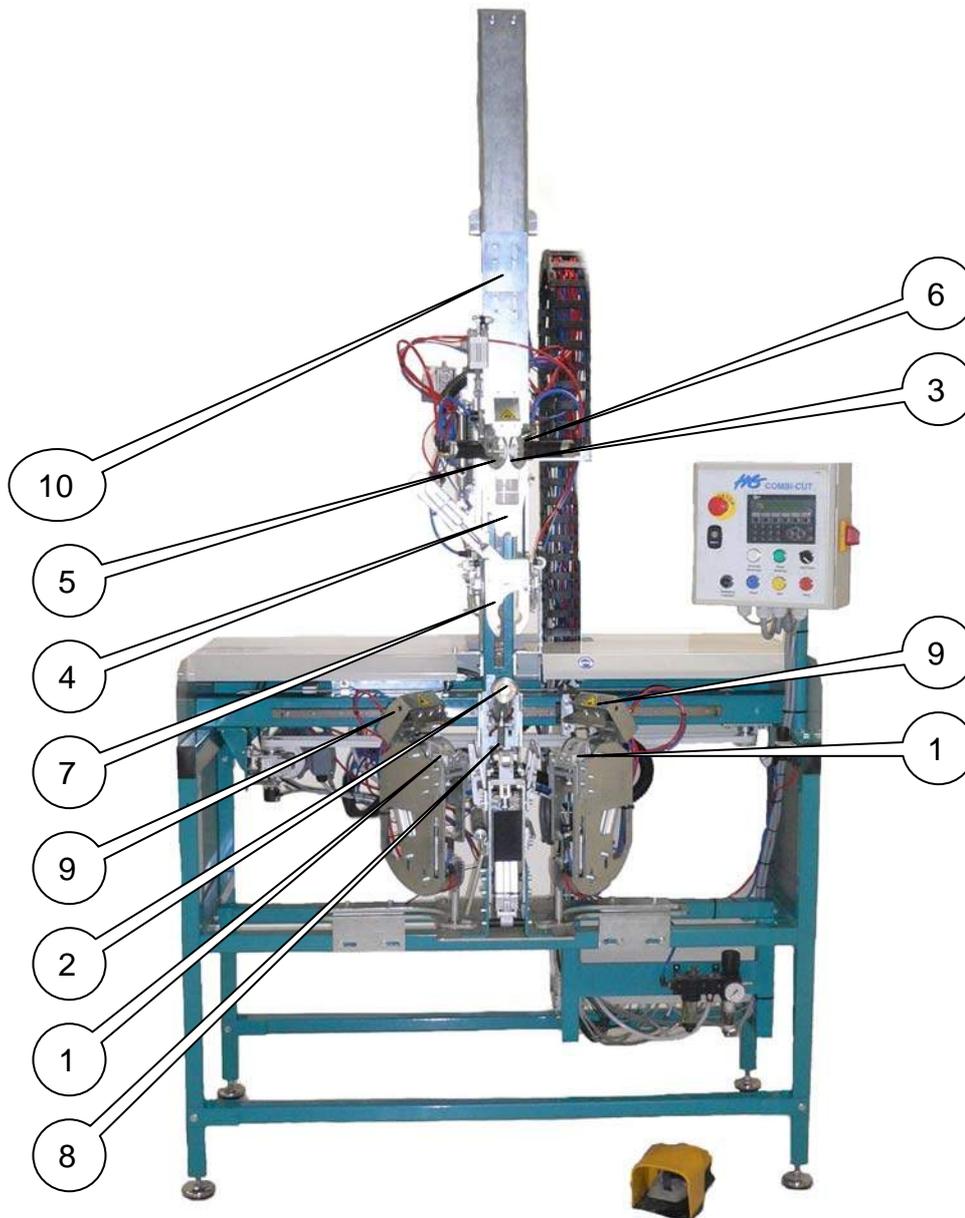
Warning: Only adjust the machine when it does not run, or you risk to get squeezed between the moveable parts of the machine.

When you adjust the machine, do not activate the foot pedal.

9. Operating the HG Combi Cut

The slicing machine can be adjusted so that it fits to the need of the operator. The below description of the operation take basis in the factory adjustments, where the machine runs with hind leg loosener and step functions.

If the machine is adjusted to work as a ordinary slicing machine without hind leg loosener then skip point 10 – 15.



- 1 Take the rear paws of the mink between forefinger and thumb, so that the belly points against the machine.
- 2 Place the paws in the paw holders (1)
NOTICE! Do not place the paws too deep in the paw holders, this can cause that the slicing do not get optimal.

Warning: Avoid putting your fingers between the paw holders.

- 3 Lock the paw holders by activating the foot pedal.
- 4 Then the machine pulls the paws from each other, and at the same time the knife (2) runs against left.
- 5 Before you start to slice:
 - a) Fetch the tail of the mink with the right hand.
 - b) Turn the hand so that it is placed right under the tail root and the skin.
 - c) Decide the cut by pulling or pushing the body.
- 6 The Ø50 knife (2) to the long running cut now cuts from left against right. When the knife reaches the right hind leg, the knife returns to starting point.
- 7 The spade (4) runs down and loosens the skin on the belly.
- 8 The Ø80 knives (5) cut the V-cut by a down going movement.

- 9 Under the V-cut you lift the tail point to vertical position and you put the tail into the tail roll (3), and this will pull the tail against the nylon roll and cut the tail, while the spade runs up with a vertical movement. Now the tail is cut up. The spade returns to starting point.

- 10 The hind leg hooks runs out with a horizontal movement.

- 11 Step foot pedal. The tail is pulled, so that the cross cut opens up. You steer with the tail of the mink, so that the back hook is about 75 % free of the hind leg. Step pedal. Then the hook runs down with a vertical movement and stops with an open hook. Activated the foot pedal. Next step closes the hook around the thighbone.

- 12 Activate the foot pedal. Then the tail loosener spade (7) runs with a horizontal movement. Pull hard in the tail, and the spade runs down on the back of the mink.
Activate the foot pedal. Back hook closes.

- 13 Activate foot pedal. Body holder (8) is activated around the mink and is kept.

- 14 Paws are clipped (9) or cut – release the mink. (Section 13.3)

- 15 The tower (10) runs up vertical, at the same time hind leg and tail are loosened.

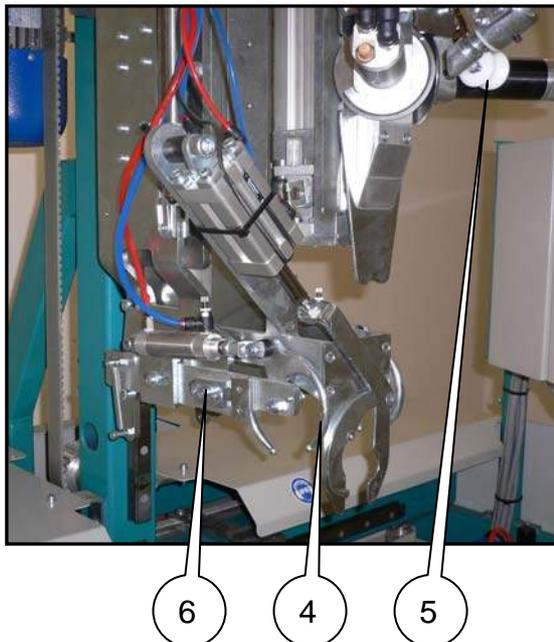
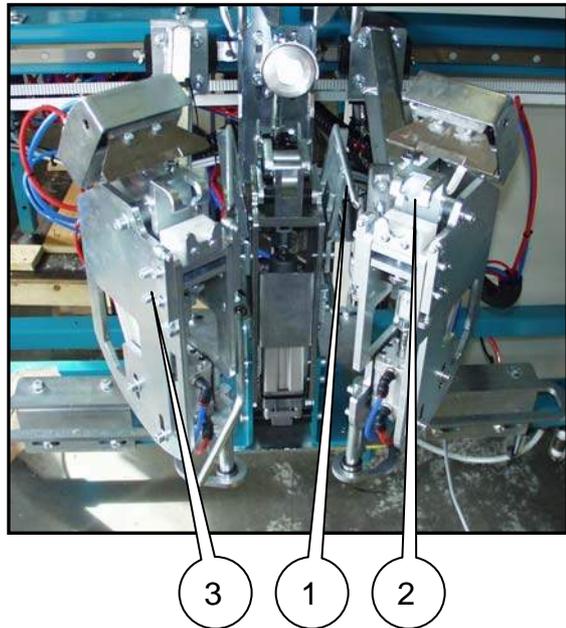
- 16 Body holder returns to starting position, and the mink dumps down on the conveyor belt.

- 17 The operator takes a new mink, and the machine returns to starting position.

10. Adjustment

To obtain the optimal slicing it is necessary to adjust the machine individual to each operator.

1. Adjustment of the thigh supporter (1), so that they give a good support.
2. Adjust the paw clamp (2), so that the paw is properly tightened during the slicing.
3. Adjust the paw knife (3), so that it cuts or clips paw.
4. Adjustment of the hind leg hooks (4). These have to be adjusted in the MAC panel, so that they run 3 mm past the thigh supporter immediate after the hooks close. If they run too far you risk to spoil the hind leg skin.



5. Adjust the tail roll (5), so that the centre of the two 80 mm knives are right outside the upper edge of the tail roll.
6. Adjustment of the hooks to the hind leg loosener (6), it has to go down a 1/3 into the backside of the cut up hind legs.

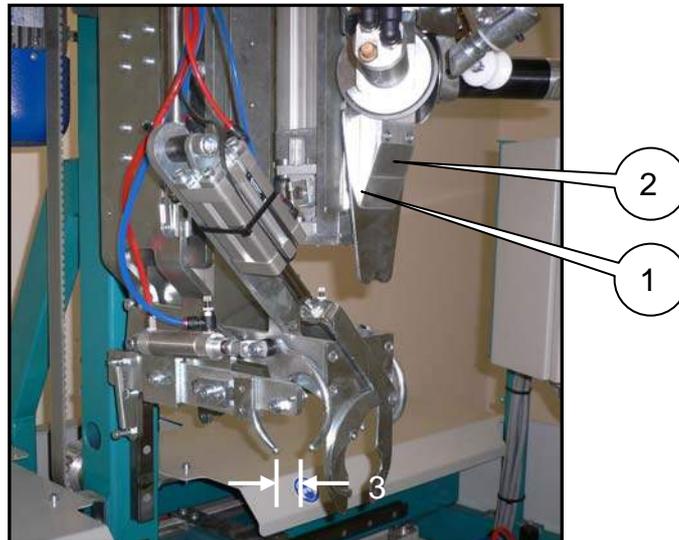
10.1 Change between male and female.

In the Mac panel you distinguish, as earlier mentioned, between male and female values for the position of the tower. The Male/Female reverser on the operation panel changes between these typed values.

To obtain the optimal slicing you also have to change between the wedges on the belly spade. The wedge positioned the mink correctly in proportion to the triangular cut.

By slicing of MALE mink wedge 1 has to be mounted alone.

By slicing of FEMALE mink the wedges 1 and 2 have to be mounted.



The hind leg hooks (3) have to be adjusted, so that the hooks close around between the skin and the thigh on the mink.

The opening on the hind leg hooks have to be adjusted to about 32 mm for MALE mink.

For FEMALE mink the opening has to be adjusted to about 16 mm.

The stretch pressure on the paw stretch also has to be changed between MALE and FEMALE.

By Male mink the stretch pressure is adjusted to about 3 bar.

By FEMALE mink the stretch pressure is adjusted to about 2 bar.

11. Maintenance/Cleaning

To make the slicing machine work optimal, you have to clean and maintain it after following description.

11.1 Daily cleaning and maintenance

Before you start cleaning, disconnect electricity and pneumatic air.

- 1 After use only clean the machine with pneumatic air.
- 2 Remove slicing rests and sawdust from the moveable parts of the machine, so they can run freely and easily.
- 3 Empty the water separator (1).

Cleaning: Only use pneumatic air in the area of the circle.



11.2 Weekly cleaning and maintenance

Before cleaning the machine disconnect electricity and pneumatic air.

1. After use clean the machine with pneumatic air.
2. Empty water separator (1).
3. Check the oil level in the pneumatic lubricator and replenish after need (2).

Always use the right air oil: Statoil NUTO H 15.

Hedensted Gruppen – item no. 476550

4. Shears and slippery surfaces are dried clean and oiled with fine oil.
Hedensted Gruppen – item no.476590
5. The lubricating nipples of the shears are oiled with grease.
Hedensted Gruppen – Item no. 476570 (Patron 400g)

11.3 Storing of the HG Combi Cut

To obtain a long lifetime and good reliability by starting up, it is necessary to clean the machine well and make an extra oiling. The slicing machine is cleaned as described under daily/weekly cleaning.

Shears and slippery surfaces are dried and oiled with fine oil

Hedensted Gruppen item no. 476590

The lubricating nipples of the shears are oiled with grease.

Hedensted Gruppen item no. 476570 (Patron 400g)

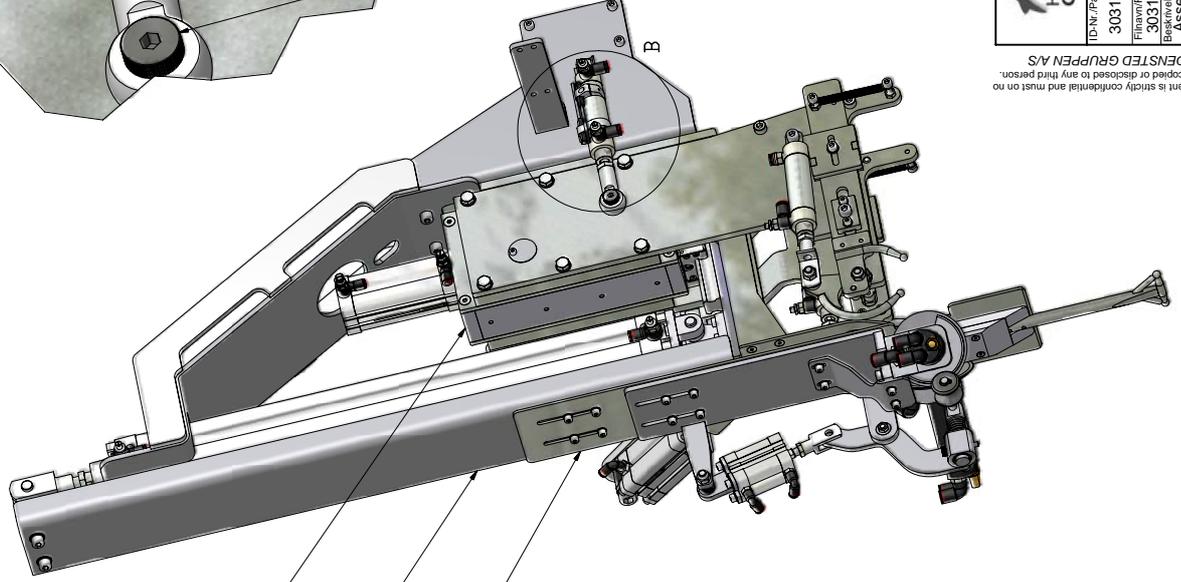
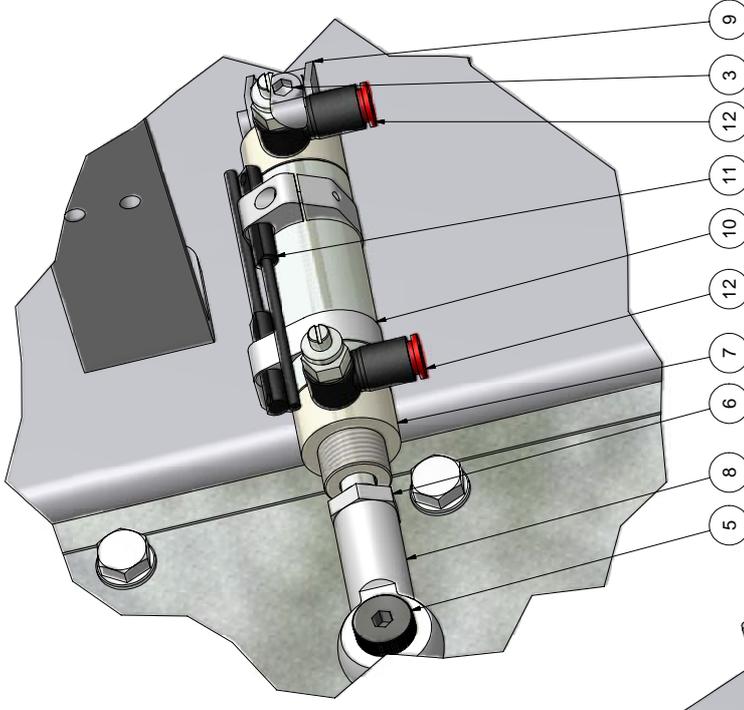
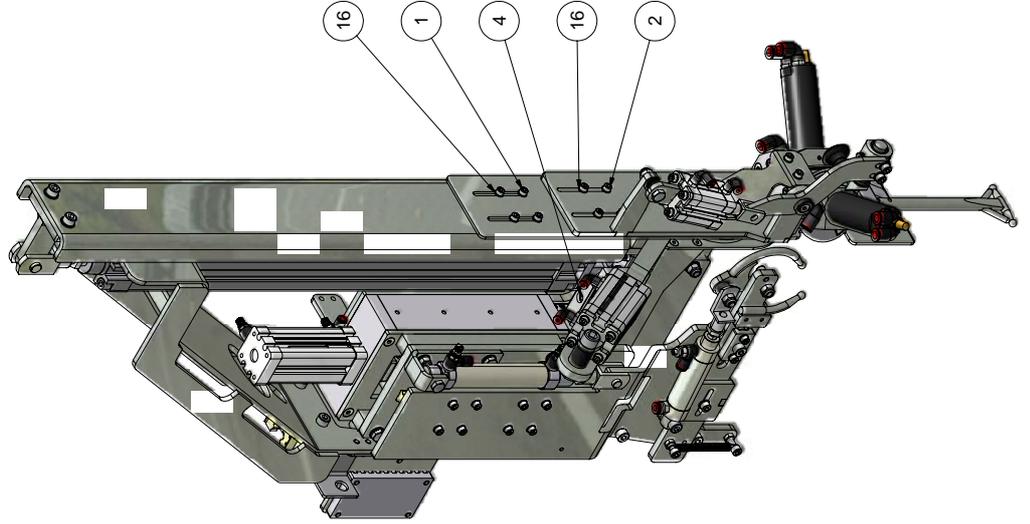
Oil the air engines extra well by opening the pneumatic lubricator and run a couple of times with the machine.

Remember: To close completely for the pneumacit lubricator again, and then open 1 round then it is ready for next season.

Always use the right air oil: Statoil NUTO H 15.

Parts List

ITEM	QTY	PART NUMBER	DESCRIPTION
1	4	10205020	Bolt unbrako cyl 5x20 FZB
2	4	10205025	Bolt unbrako cyl 5x25 FZB
3	2	10206010	Bolt unbrako cyl 6x10 FZB
4	3	10206020	Bolt unbrako cyl 6x20 FZB
5	1	20208020	Fitting bolt M8-10x20mm
6	1	210427	Lock nut MP150189 M10x1,25
7	1	211616	Cylinder RT 57225/M/50
8	1	214116	UF-Joint QM-8025-32
9	1	214140	L-Joint QM-57025-24
10	2	214185	Clamp for reed contact Ø25
11	2	214310	Reed contact M/50/EAP/5V
12	2	215110	Banjo flow control Ø6 1/8"
13	1	30317	Frame for spade lift
14	1	30318	Assembly leghook and tailroll system
15	1	30426	Assembly tailroll system
16	8	82105900	Washer M5 FZB

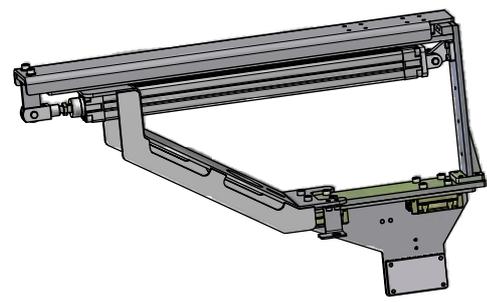


HEDENSTED GRUPPEN
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 This document is strictly confidential and must not be copied or disclosed to any third person.

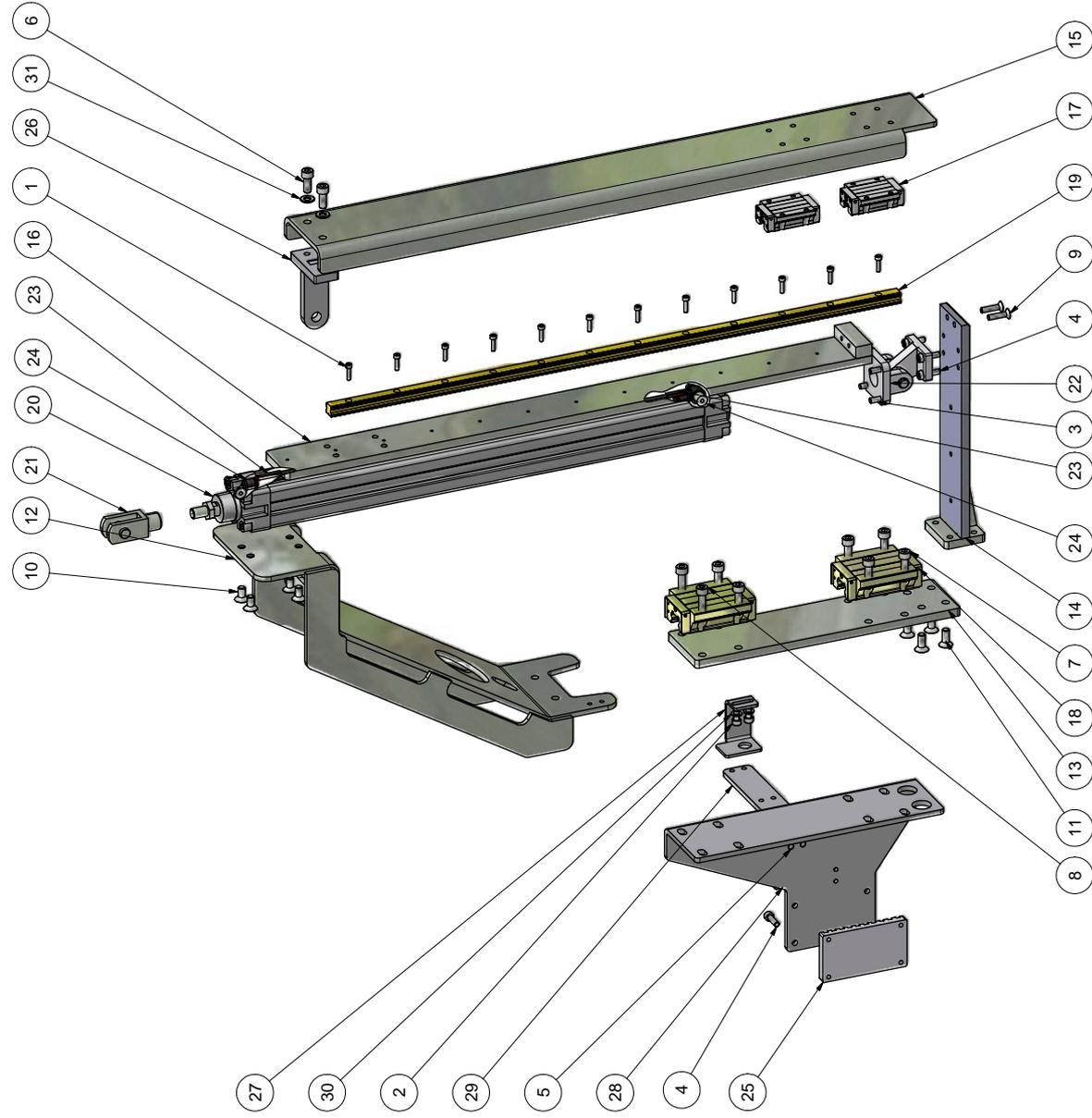
Scale/Scale:	1:2	Material/ Material:	Overfl. beskaffenhed/ Surface properties:	Weight/Weight:	kg
TD-Nr./Part No.:	30316	Conformity/Conforming according to:	DS/ISO 2768-m	Const./Designed:	KL
File name/Filename:	30316 Assembly lower.iam	Like angivet tolerance int./ Not specified tolerance according to:	Thomas Vittrup	Techn./Drafted:	
Block name/Block name:	Assembly lower	Released int./ Unfolding according to:	DS/ISO 2768-m	Date/Date:	12-05-2004
Drawn/Drawn:	Combi cut	Scale gemt/Last saved:	16-05-2004	Part number/Sheet size:	A2
Sheet gemt/Last saved by:	TV	Sheet 1 of 1			

Parts List

ITEM	QTY	PART NUMBER	DESCRIPTION
1	12	10204016	Bolt unbraco cyl 4x16 FZB
2	2	10206012	Bolt unbrako cyl 6x12 FZB
3	4	10206016	Bolt unbraco cyl 6x16 FZB
4	8	10206020	Bolt unbraco cyl 6x20 FZB
5	2	10208012	Bolt unbraco cyl 8x12 FZB
6	2	10208020	Bolt unbraco cyl 8x20 FZB
7	6	10208030	Bolt Unbrako cyl. 8x30 FZB
8	2	10208035	Bolt Unbrako cyl 8x35 FZB
9	2	20406025	Hexagon countersunk head 6x25 FZB
10	4	20408016	Hexagon countersunk head 8x16 FZB
11	4	20408020	Hexagon countersunk head 8x20 FZB
12	1	207880	Reinforcement for tower model ES
13	1	207885	Console for tower model 2008
14	1	207887	Horizontal console for tower_M2008
15	1	207890	Connectionplate-spade cylinder_ES
16	1	207895	Horizontal console model ES
17	2	207906	Ball runner block / SHS15CSS
18	2	207912	Ball runner block / SHS25CSS
19	1	207917	Ball guide rail / SHS15+710mm
20	1	212129	Cylinder PRA/182040/M/500
21	1	214120	F-Joint QM-8040-25
22	1	214160	L-Joint QA-8040-24
23	2	214310	Reed contact M/50/EAP/5V
24	2	215992	Banjo flow control Ø6 1/4"
25	1	30268	Clamping plate for AT10
26	1	30291	Bracket assembly for tower lift
27	1	30560	Sensorbracket for tower
28	1	30700	Connection plate for belt
29	1	30820	Bracket for energi chain
30	2	82106000	Washer M6 FZB
31	2	82108000	Washer M8 FZB



(1 : 4)

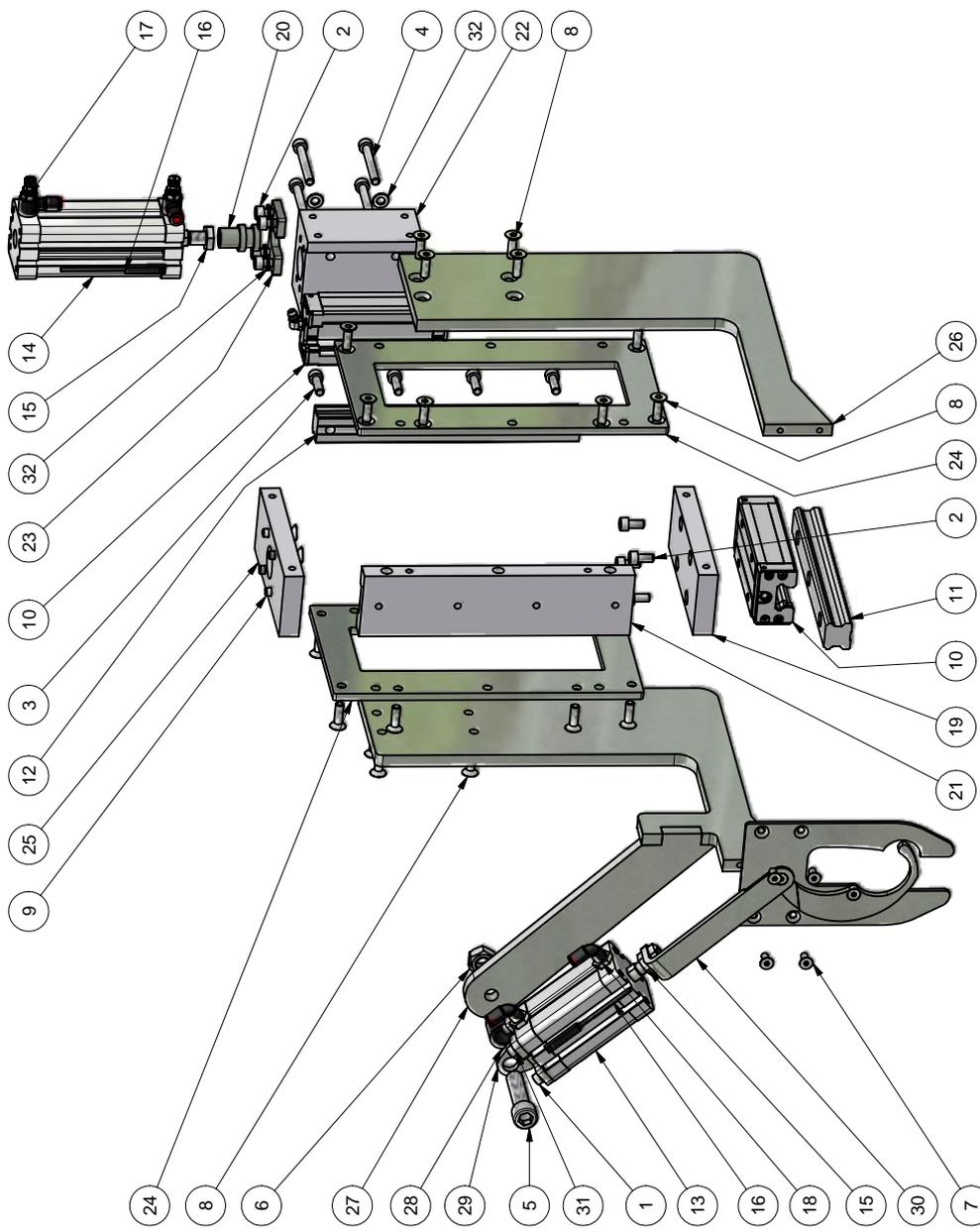


Break all edges
Alle kanten reifen

Scale: 1:4
 This project is a work in progress. No specific dimensions according to Normen/Design
 DSI/ISO 2768-m
 Drawn: [Name]
 Checked: [Name]
 Part No.: 30317
 Description: Frame for spade lift
 Date: 13.12.2007
 Drawn by: [Name]
 Checked by: [Name]
 Date: 21.05.2010
 Name changed

REV	DESCRIPTION	DATE	APPROVED
A	New drawing	05-05-2008	[Signature]
B	Parts changed for model ES	13-12-2007	[Signature]
C	Name changed	21-05-2010	[Signature]

Parts List			
ITEM	QTY	PART NUMBER	DESCRIPTION
1	4	10205016	Bolt unbrako cyl 5x16 FZB
2	8	10206012	Bolt unbrako cyl 6x12 FZB
3	4	10206020	Bolt unbrako cyl 6x20 FZB
4	4	10206050	Bolt unbrako cyl 6x50 FZB
5	1	10212050	Bolt unbrako cyl 12x50 FZB
6	1	1512000	Nut M12 FZB
7	4	20405012	Hexagon countersunk head 5x12 FZB
8	20	20406020	Hexagon countersunk head 6x20 FZB
9	4	20406025	Hexagon countersunk head 6x25 FZB
10	2	207911	Ball runner block / SHS25V
11	1	207913	Ball guide rail / SHS25+170mm
12	1	207915	Ball guide rail / SHS25+200mm
13	1	210305	Cylinder RM/192032/M/50
14	1	210340	Cylinder RA/192032/M/80
15	3	210427	Lock nut MP150189_M10x1,25
16	2	214310	Reed contact M/50/EAP/5V
17	2	215105	Banjo flow control Ø6 1/8"
18	2	215755	Swirvel elbow Ø4 1/8"
19	1	30500	Connecting piece - tower
20	1	30504	Bush for cylinder
21	1	30505	Plate for vertical rail - tower
22	1	30510	Connecting piece-vertical rail
23	1	30512	Plate for connection piece
24	2	30525	Bearing plate for vertical rail
25	1	30535	Top for tower
26	1	30615	Right plate for back spade
27	1	30620	Assembly - plate for back spade
28	1	30625	Spacer for tail hook cyl.
29	1	30641	Assembly bracket for ø32cylinder
30	1	30698	Tail spade system C.Cut tail spade and hook
31	4	82105900	Washer M5 FZB
32	8	82106000	Washer M6 FZB



Break all edges
Alle kanter reifes

	Scale:	1:4		Like angivet tolerance iht./ Not specified tolerance according to:	Konst./Designed:
	DS/ISO 2768-m	Overfl. beskaffenhed/Surface properties:		KL	
Part No.: 207849	Material:		Utkastet iht./ Unkasted according to:	KL	Date:
Beskrivelse: Tailspadesystem				KL	12-05-2004
Description: Combi cut					
Revision: KL					
Date: 01-03-2007					
Sheet: A3					
Page: 1 / 1					

REV	DESCRIPTION	DATE	REVISION HISTORY
A	New drawing	01-03-2007	APPROVED
			KL

Parts List

ITEM	QTY	PART NUMBER	DESCRIPTION
1	4	10205008	Bolt, unbrako cyl.5x8 FZB
2	4	10205012	Bolt unbrako cyl 5x12 FZB
3	2	10206010	Bolt unbrako cyl 6x10 FZB
4	2	10206020	Bolt unbrako cyl 6x20 FZB
5	4	10504005	Stop screw 4x5 black
6	1	11408035	Hexagon bolt m8x35 FZB
7	1	1506000	Nut M6 FZB
8	1	17908000	Self-locking nut M8 FZB
9	1	20205025	Fitting bolt M5-6x25mm
10	8	20404010	Hexagon countersunk head 4x10 FZB
11	2	20404016	Hexagon countersunk head 4x16 FZB
12	4	20405012	Hexagon countersunk head 5x12 FZB
13	2	20405016	Hexagon countersunk head 5x16 FZB
14	2	20406020	Hexagon countersunk head 6x20 FZB
15	1	20406025	Hexagon countersunk head 6x25 FZB
16	2	206070	Lock for knives Ø70-Ø80
17	2	206071	Hub for knives Ø70-80
18	1	206084	Air motor LZB 22A049-55
19	1	206091	Air motor LZB 22A049 Links
20	1	207820	Bushing for tailroll
21	2	207828	Knife f. slicing machine 80 mm
22	1	207832	Wedge for belly loosener 2007
23	1	207834	Belly loosener - long
24	1	207838	Plate for belly loosener 2007
25	1	207855	Bush for tailroll - endpiece
26	1	207860	Tail roll combi cut
27	1	207931	Compression spring 1.8-16-20
28	1	210310	Cylinder RA/192025/M/25
29	1	210421	Lock nut M/P1501/60
30	1	211100	F-Joint QM-8020-25
31	2	215750	Swirvel elbow Ø4 M5
32	4	216536	Swirvel elbow Ø8 1/8"
33	2	216537	Swirvel elbow Ø8 1/4"
34	2	216796	Silencer 1/8" T40C-1800
35	1	30330	shaft for tail roll
36	1	30340	Arm for swing - tailroll
37	1	30345	Shaft for tailrolli adjustment
38	1	30425	Consol for tailroll
39	1	30436	Plate ammenbly - tailroll system
40	1	30437	Distance bush f.cyl R/M192000
41	2	30511	Screen for 80mm knife
42	1	30515	Coverplate for knives
43	2	30516	Bracket for air motor
44	1	30518	Baseplate for air motor
45	1	30520	Wedge for female
46	1	30647	Mounting bracket for ø25 cyl.
47	8	82105900	Washer M5 FZB
48	4	82106000	Washer M6 FZB
49	1	88712100	Shim washer ø12x18x1.0
50	2	89708000	Seeger ring for shaft Ø8 din 471



TD-Nr./Part No.: 30426

Filename: 30426 Assembly tailroll system.iam

Release date: 15-04-2005

Drawn by: Combi / Quick cut

Status: gemt/last saved by: TV

Skala/Scale: 1:2

Material: Material

Overfl. beskaffenhed/ Surface properties:

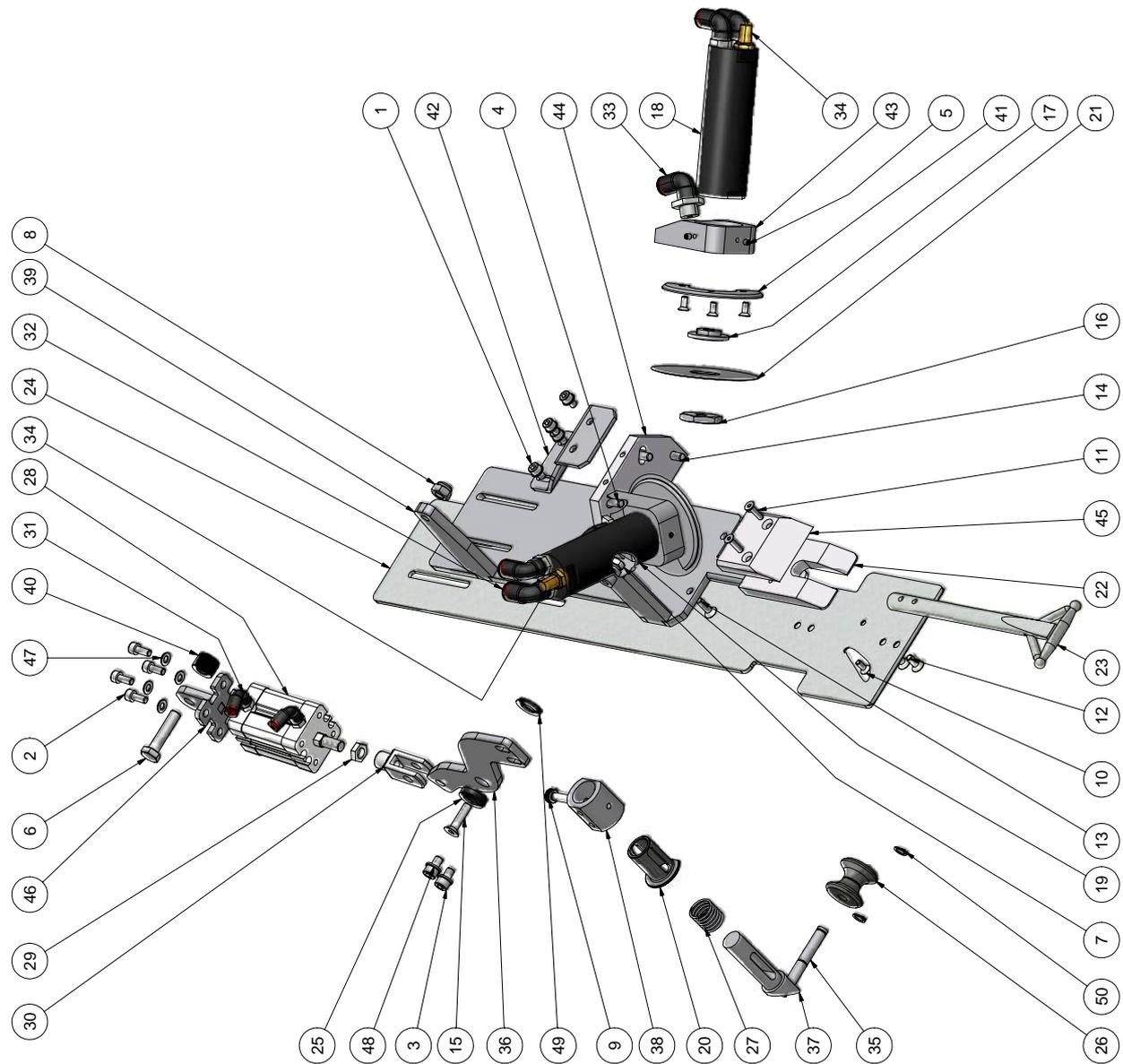
Ikke angivet tolerance iht./ Not specified tolerance according to: DS/ISO 2768-m

Vejrt/Weight: kg

Konst./Designed: Thomas Vittrup

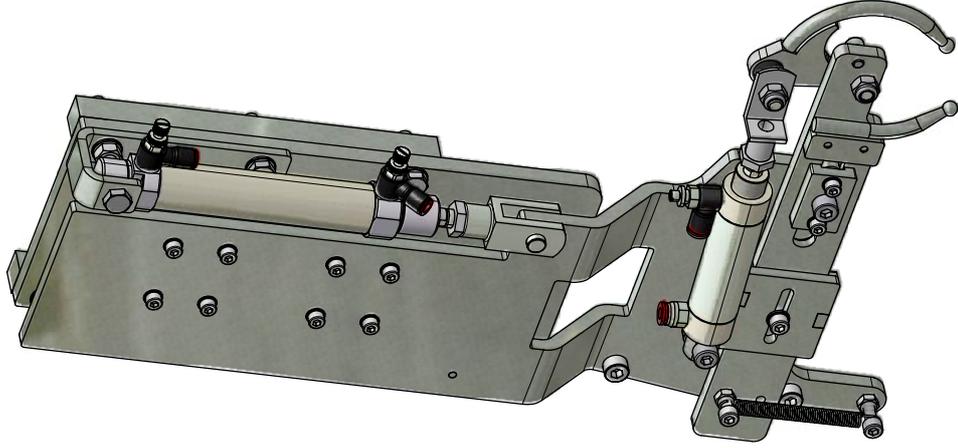
Dato/Date: 13-06-2004

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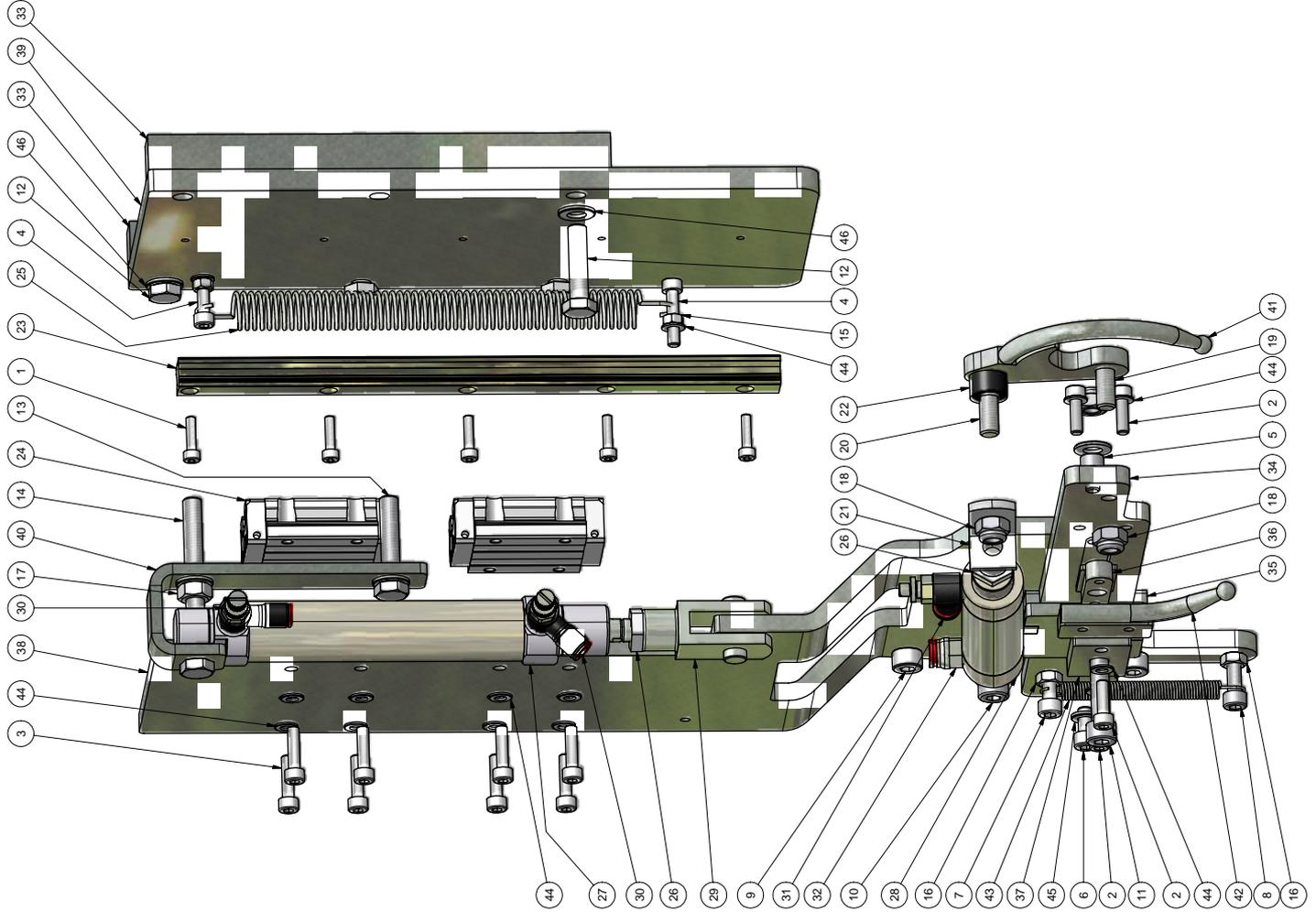
REV	DESCRIPTION	DATE	APPROVED
A	Belly loosener changed	15-04-2005	KL
B	Name changed	21-05-2010	KL

ITEM	QTY	PART NUMBER	DESCRIPTION
1	5	10204016	Bolunbrako cyl 4x16 FZB
2	4	10206016	Bolt unbrako cyl 5x16 FZB
3	8	10206020	Bolt unbrako cyl 5x20 FZB
4	2	10206025	Bolt unbrako cyl 5x25 FZB
5	1	10206010	Bolt unbrako cyl 6x10 FZB
6	1	10206012	Bolt unbrako cyl 6x12 FZB
7	1	10206020	Bolt unbrako cyl 6x20 FZB
8	1	10206025	Bolt unbrako cyl 6x25 FZB
9	2	10208010	Bolt unbrako cyl 8x10 FZB
10	1	10208025	Bolt Unbrako Cyl. 8x25 FZB
11	1	10208035	Bolt Unbrako cyl 8x35 FZB
12	4	11408035	Hexagon bolt m8x35 FZB
13	1	11408040	Hexagon bolt m8x40 FZB
14	1	11408075	Hexagon bolt m8x75 FZB
15	2	1505000	Nut M6 FZB
16	2	1506000	Nut M6 FZB
17	2	1508000	Nut M8 FZB
18	3	17908000	Self-locking nut M8 FZB
19	1	20408025	Hexagon countersunk head 8x25 FZB
20	1	20408035	Hexagon countersunk head 8x35 FZB
21	1	207856	Bracket for leghook
22	1	207870	Spacer for leghooks
23	1	207905	Ball guide rail / SHS15+260mm
24	2	207906	Ball runner block / SHS15+260mm
25	1	207944	Extension spring 1,6-13,5x120
26	2	210427	Lock nut MP 150189 / M10x1,25
27	1	211038	Cylinder RM/6026M/60
28	1	211616	Cylinder RT 57225M/50
29	1	214115	F-Joint OM-8025-25
30	2	215105	Banjo flow control Ø6 1/8"
31	1	215110	Banjo flow control Ø6 1/8"
32	1	215900	Straight connector Ø6 1/8"
33	2	30240	Distance block for tower
34	1	30245	Arm for leg hooks left side
35	1	30252	Adjustable bracket left leg hooks
36	1	30255	T-bolt for arm leg hooks
37	1	30265	Block for T-bolt
38	1	30324	Left carrying plate leghook
39	1	30327	Support for carrying plate
40	1	30329	Bracket for cylinder
41	1	30657	Left back-hook - big moveable
42	1	30662	Shaft with ball for small hook
43	1	470580	Extension spring 1-9x60,5
44	14	82105900	Washer M5 FZB
45	1	82106000	Washer M6 FZB
46	7	82108000	Washer M8 FZB



Break all edges
Alle kanten reifen

Scale: 1:3
 This drawing is a technical drawing. For specific information according to the drawing, please refer to the drawing.
 DSI/ISO 2768-m
 Drawing: 101052004
 Part No.: 207946
 Description: Left leghook system
 Drawing: 101052004
 Date: 01-03-2007
 Drawn by: AZ
 Checked by: T / J

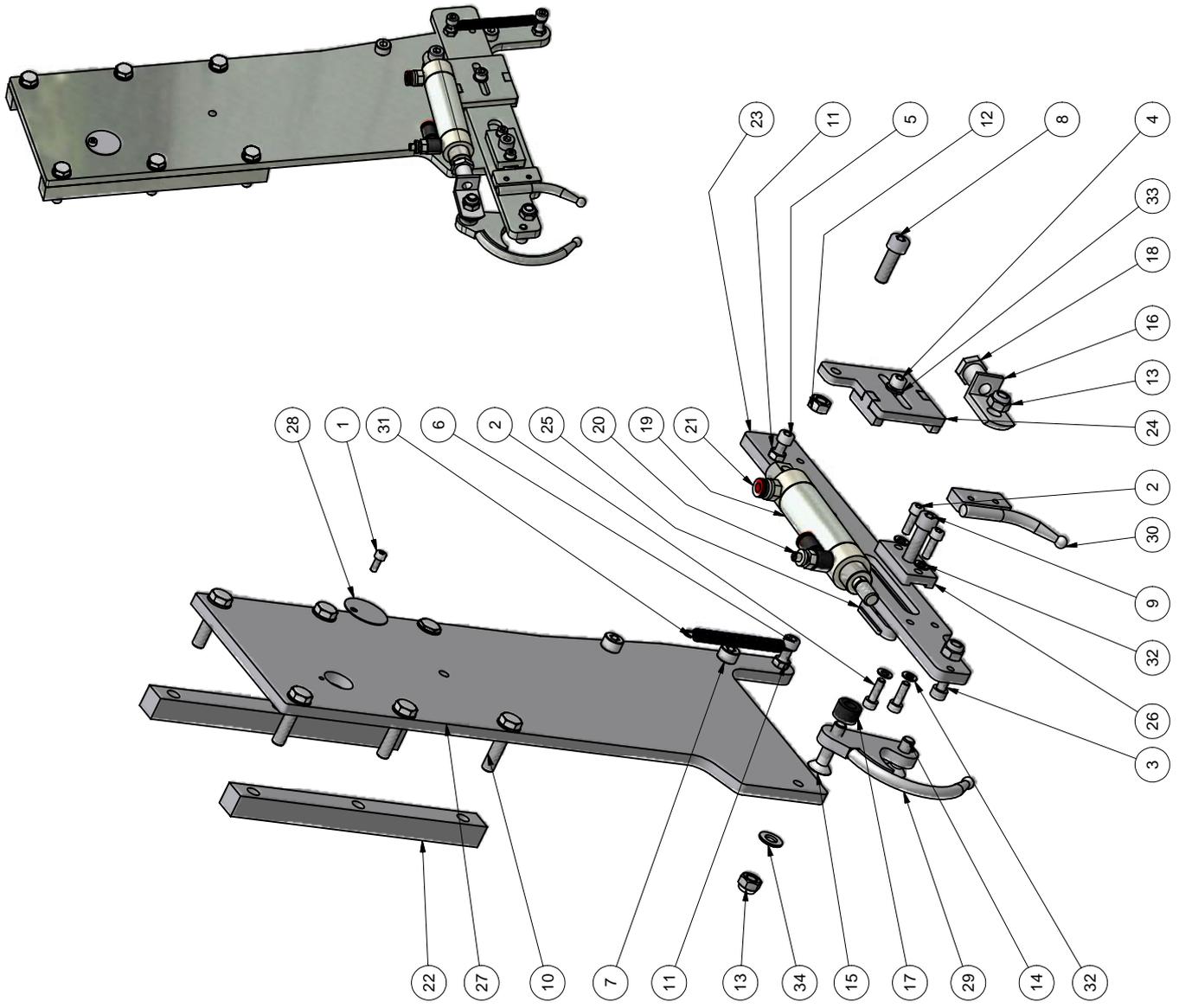


REV	DESCRIPTION	DATE	APPROVED
A	New drawing	17-03-2010	

REV	DESCRIPTION	DATE	APPROVED
A	New drawing	17-03-2010	

Parts List

ITEM	QTY	PART NUMBER	DESCRIPTION
1	1	10204010	Bolt.unbraco cyl 4x10 FZB
2	4	10205016	Bolt.unbrako cyl 5x16 FZB
3	1	10206010	Bolt.unbrako cyl 6x10 FZB
4	1	10206012	Bolt.unbrako cyl 6x12 FZB
5	1	10206020	Bolt.unbrako cyl 6x20 FZB
6	1	10206025	Bolt.unbrako cyl 6x25 FZB
7	2	10208010	Bolt.unbrako cyl 8x10 FZB
8	1	10208025	Bolt.unbrako Cyl. 8x25 FZB
9	1	10208035	Bolt.unbrako cyl 8x35 FZB
10	6	11408035	Hexagon bolt m8x35 FZB
11	2	1506000	Nut M6 FZB
12	1	1508000	Nut M8 FZB
13	3	17908000	Self-locking nut M8 FZB
14	1	20408025	Hexagon countersunk head 8x25 FZB
15	1	20408035	Hexagon countersunk head 8x35 FZB
16	1	207856	Bracket for leghook
17	1	207870	Spacer for leghooks
18	1	210427	Lock nut MP150189_M10x1,25
19	1	211616	Cylinder RT 57225/M/50
20	1	215110	Banjo flow control Ø6 1/8"
21	1	215900	Straight connector Ø6 1/8"
22	2	30240	Distance block for tower
23	1	30246	Arm for leg hooks right side
24	1	30249	Adjustable bracket right leg hooks
25	1	30255	T-bolt for arm leg hooks
26	1	30265	Block for T-bolt
27	1	30325	Right carrying plate
28	1	30328	Coverplate f. lubricating nipple
29	1	30658	Right back hook - big moveable
30	1	30663	Right back-hook - small steady
31	1	470580	Extension spring 1-9x60,5
32	4	82105900	Washer M5 FZB
33	1	82106000	Washer M6 FZB
34	7	82108000	Washer M8 FZB



Break all edges
Alle kanter reifes

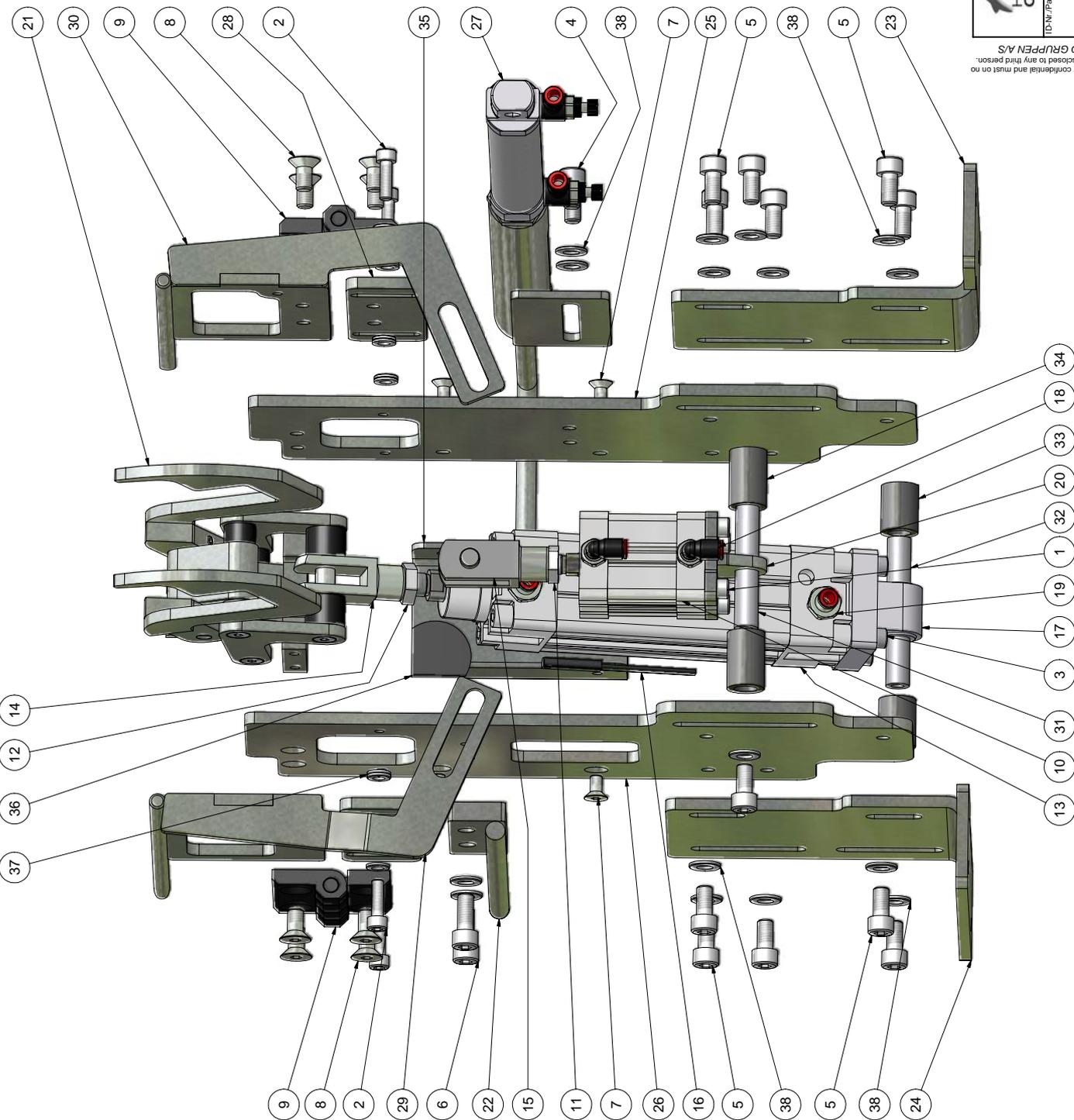
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 DS/ISO 2768-m
 Overfl. beskaffenhed/Surface properties: Tegnet/Drafted: KL
 Utkastet iht./Unkasted according to: Material: Date: 12-05-2004

Part No.: 207848
 Beskrivelse: Right leghook system
 Description: Combi cut
 Revision: KL
 Date: 01-03-2007
 Rev. A
 Size: A3
 Sheet: 1 / 2

REV	DESCRIPTION	DATE	REVISION HISTORY	APPROVED
A	New drawing	20-05-2010		KL

Parts List

ITEM	QTY	PART NUMBER	DESCRIPTION
1	4	10206016	Bolt. unbraco cyl 6x16 FZB
2	4	10206020	Bolt unbraco cyl 6x20 FZB
3	4	10206025	Bolt unbraco cyl 6x25 FZB
4	2	10208012	Bolt. unbraco cyl 8x12 FZB
5	12	10208016	Bolt. unbraco cyl 8x16 FZB
6	2	10208020	Bolt. unbraco cyl 8x20 FZB
7	4	20406012	Hexagon countersunk head 6x12 FZB
8	8	20408016	Hexagon countersunk head 8x16 FZB
9	2	207940	Hinge GN237-60-60
10	1	210330	Cylinder RA/192032/M/20
11	1	210427	Lock nut MP150189_M10x1,25
12	1	210428	Lock nut MP150190_M12x1,25
13	1	212123	Cylinder PRA/182040/M/80
14	1	214108	F-Joint QM-57040-25
15	1	214115	F-Joint QM-8025-25
16	1	214310	Reed contact M/50/EAP/5V
17	1	214905	R-Joint QA-8040-27
18	2	215760	Swivel elbow Ø6mm 1/8"
19	2	215930	Straight connector Ø6 1/4"
20	1	30641	Assembly bracket for ø32cylinder
21	1	30667	Ass. unit eccentric bodyholder
22	1	30702	Stop axle complete
23	1	30705	Body holder for outer plate
24	1	30706	Body holder for outer plate
25	1	30710	Body holder for inner plate
26	1	30711	Body holder for inner plate
27	1	30716	Assembly bodyholder
28	2	30740	Lower plate for tigh-support
29	1	30756	Assembly tigh-support right
30	1	30757	Assembly tigh-support left
31	1	30760	Axle for cylinder Ø32
32	1	30761	Axle for cylinder Ø40
33	2	30762	Spacer 19-12-24,8
34	2	30763	Spacer 19-12-29,7
35	1	30765	Plate for body holder rubber
36	1	30770	Rubber for body holder plate
37	12	82106000	Washer M6 FZB
38	16	82108000	Washer M8 FZB



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HEDENSTED GRUPPEN AS
 ID-Nr./Part No.:
 Filnavn/Filename: 30726 Assembly complete body holder.iam
 Beskrivelse/Description: Assembly complete body holder
 Status gemt til: Saved by: TV Size gemt/Last saved: 17-05-2004
 Papirstørrelse/Sheet size: A2 sheet 1 of 2

Hedensted Gruppen

Scale: 1:2

Overfl. beskaffenhed/ Surface properties:
 Ikke angivet tolerance iht./ Not specified tolerance according to: DS/ISO 2768-m

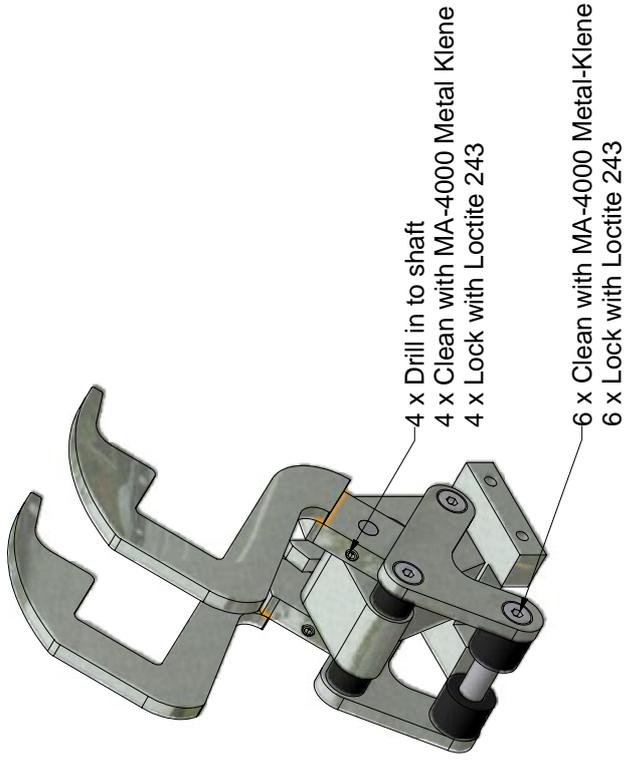
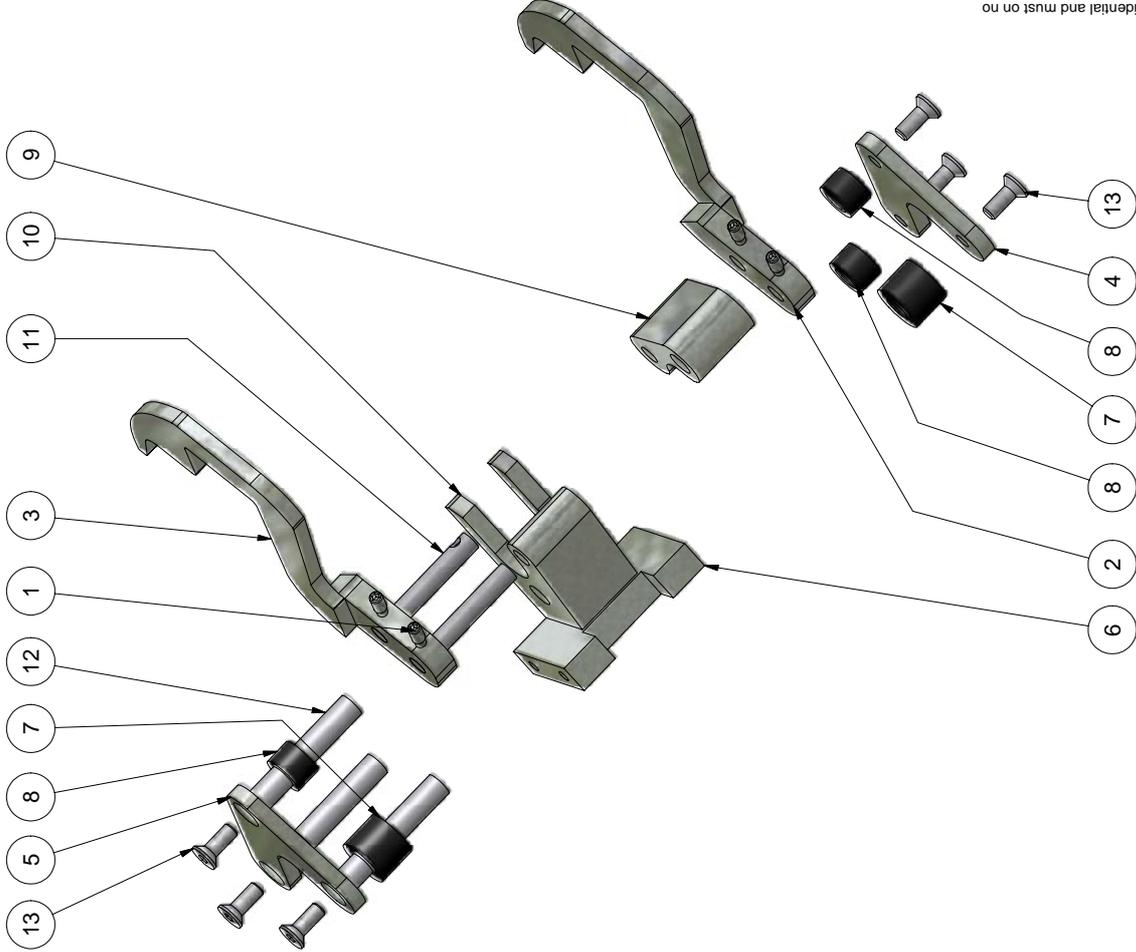
Tegningsdato: 14-06-2004
 Konst./Designed: Thomas Vittrup

REVISION HISTORY			
REV	DESCRIPTION	DATE	APPROVED
A	Made	17-05-2004	KL
B	Renamed	05-05-2010	KC

Skala/Scale: Material/Material: Vægt/Weight: kg

Parts List

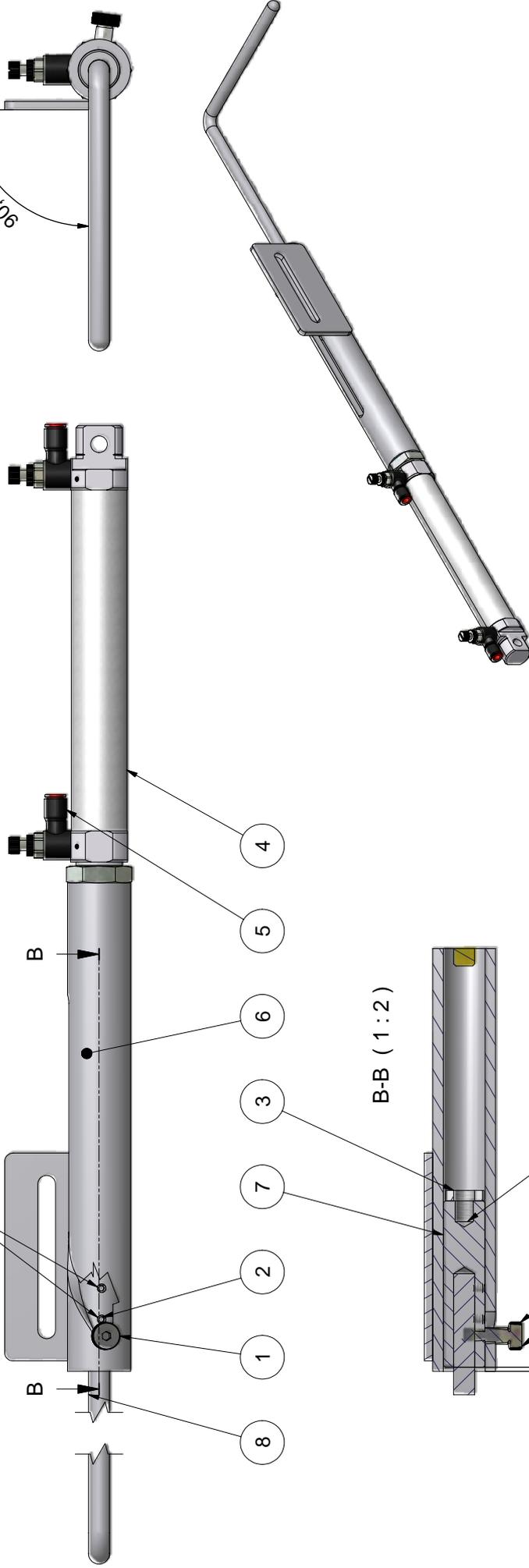
ITEM	QTY	PART NUMBER	DESCRIPTION
1	4	20905010	Stop screw M5-10 FZB
2	1	30665	Body holder hook left
3	1	30666	Body holder hook right
4	1	30670	Brace for cylinder body-holder left
5	1	30671	Brace for cylinder body-holder right
6	1	30675	Bottom part f bodyhook
7	2	30680	Bushing for body hook 20-10,2-15,8
8	4	30682	Bushing for body hook
9	1	30685	Eccentric for bodyholdsystm
10	1	30690	Bracket for bodyholdsystm
11	2	30731	Axel for body holder system
12	3	30732	Axel for body holder system
13	6	53406016	Hexagon countersunk head 6x16 Kval. 12.9



 Hedensted Gruppen	Skala/Scale: 1:1	Materiale/ Material: Overfl. beskaffenhed/ Surface properties.	Vægt/Weight: kg
	ID-Nr./Part No.: 30667	Udfolder iht./ Unfolding according to: DS/ISO 2768-m	Konst./Designed: Thomas Vittrup
Filnavn/File name: 30667 Ass. unit eccentric bodyholder.iam		Ikke angivet tolerancer iht./ Not specified tolerance according to:	Tegnet/Drafted: Thomas Vittrup
Beskrivelse: Ass. unit eccentric bodyholder		Dato/Date: 14-05-2004	
Description:			
Sidst gemt at/Last saved by: TV		Sidst gemt/Last saved: 17-05-2004	
		Papirstørrelse/Sheet size: A3	
		sheet 1 of 1	

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 HEDENSTED GRUPPEN AS

Drill in to shaft
Clean with MA-4000 Metal-Klene
Lock with Loctite 248



B-B (1 : 2)

2+1
-0

Lubricate with copper grease

Clean with MA-4000 Metal-Klene
Lock with Loctite 248

Cylinder adjusting:
The bolt must stop 2mm before the end of the groove.

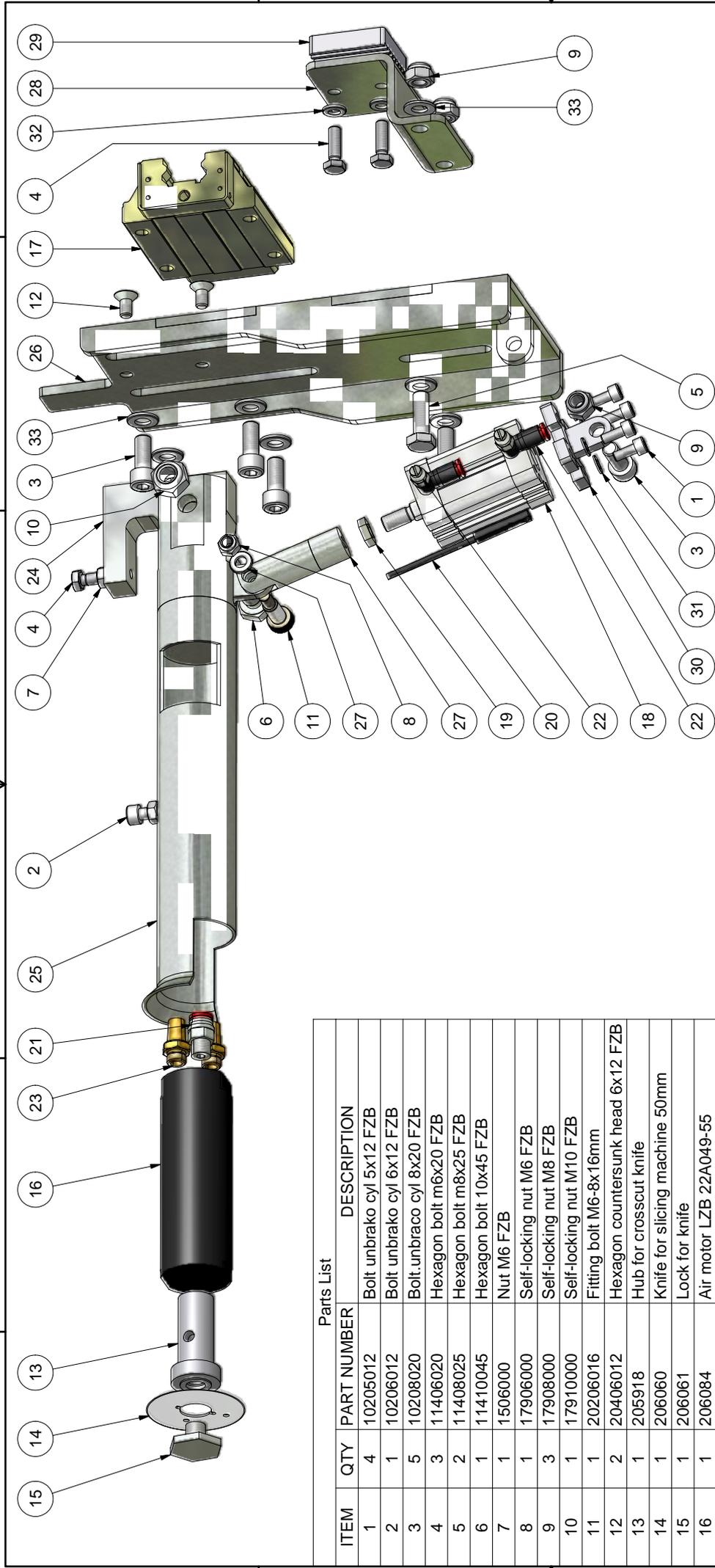
Parts List		
ITEM	QTY	PART NUMBER DESCRIPTION
1	1	20206012 Fitting bolt M6-8x12mm
2	2	20905005 Stop screw M5-5 FZB
3	1	210427 Lock nut MP150189_M10x1,25
4	1	211005 Cylinder RM/8026/M/125
5	2	215105 Banjo flow control Ø6 1/8"
6	1	30715 Col. pipeline for body holder
7	1	30725 Axle for pipe - bodyholder lock
8	1	30730 Roundsteel for bodylock

REVISION HISTORY

REV	DESCRIPTION	DATE	APPROVED
A	Made	17-05-2004	
B	Renamed, Loctite type changed	11-06-2010	KC

 Hedested Gruppen	Skala/Scale: 1:2	Material/ Material: Welded Steel Mild	Vægt/Weight: kg
	ID-Nr./Part No.: 30716	Overfl. beskaffenhed/ Surface properties:	Konst./Designed:
Finavn/Filename: 30716 Assembly bodyholder.iam	Udfoldet iht./ Unfolding according to: DS/ISO 2768-m	Tegnet/Drafted: Thomas Vittrup	Dato/Date: 14-05-2004
Beskrivelse: Assembly bodyholder	Description:		
Sidst gemt/Last saved by: TV		Papirstørrelse/Sheet size: A3 sheet 1 of 1	

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HEDESTED GRUPPEN AS



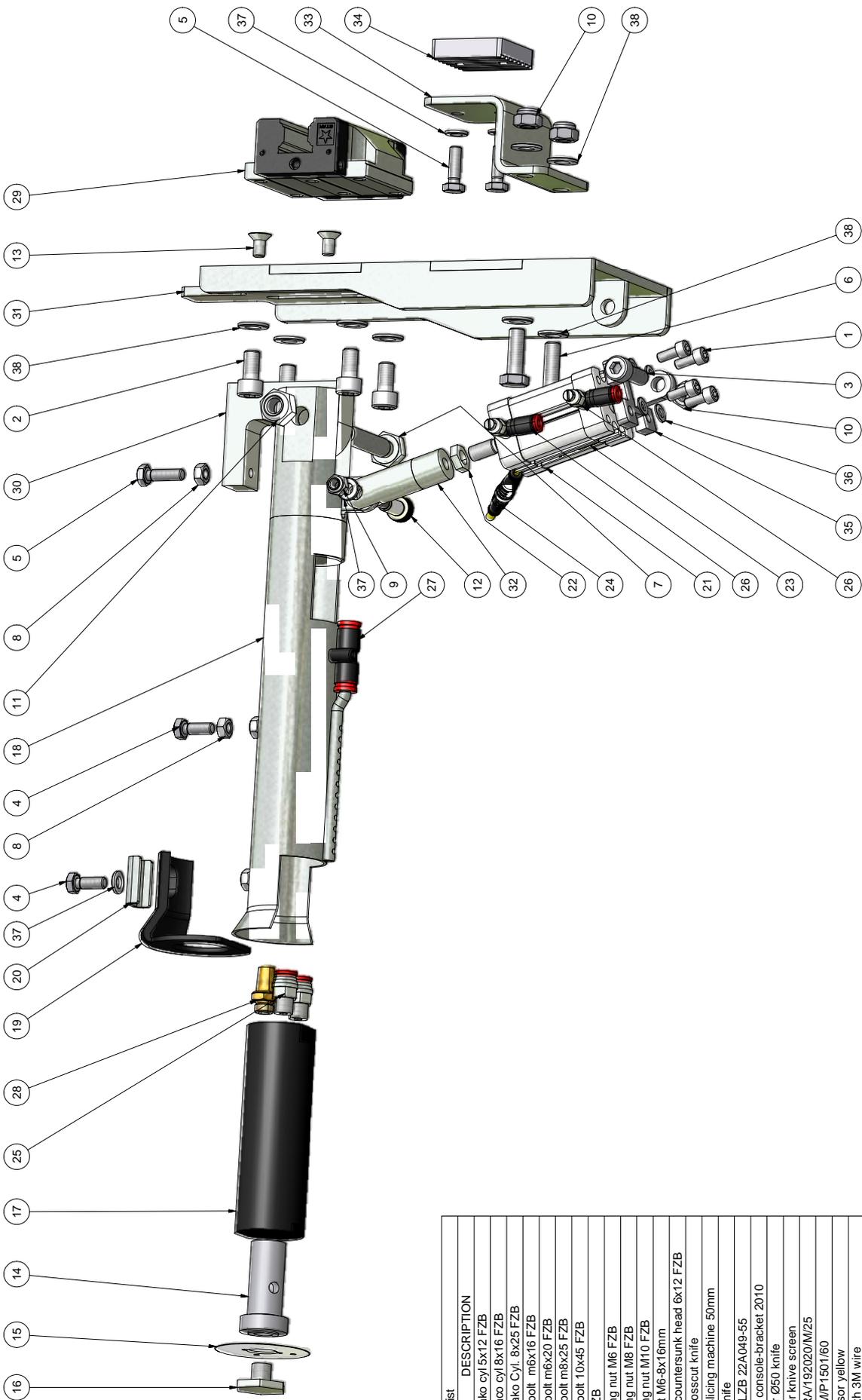
Parts List		
ITEM	QTY	PART NUMBER DESCRIPTION
1	4	10205012 Bolt unbrako cyl 5x12 FZB
2	1	10206012 Bolt unbrako cyl 6x12 FZB
3	5	10208020 Bolt.unbrako cyl 8x20 FZB
4	3	11406020 Hexagon bolt m6x20 FZB
5	2	11408025 Hexagon bolt m8x25 FZB
6	1	11410045 Hexagon bolt 10x45 FZB
7	1	1506000 Nut M6 FZB
8	1	17906000 Self-locking nut M6 FZB
9	3	17908000 Self-locking nut M8 FZB
10	1	17910000 Self-locking nut M10 FZB
11	1	20206016 Fitting bolt M6-8x16mm
12	2	20406012 Hexagon countersunk head 6x12 FZB
13	1	205918 Hub for crosscut knife
14	1	206060 Knife for slicing machine 50mm
15	1	206061 Lock for knife
16	1	206084 Air motor LZB 22A049-55
17	1	207912 Ball runner block / SHS25CSS
18	1	210300 Cylinder RA/192020/M/25
19	1	210421 Lock nut M/P1501/60
20	1	214310 Reed contact M/50/EAP/5V
21	1	215900 Straight connector Ø6 1/8"
22	2	215980 Banjo flow control Ø4 M5
23	2	216796 Silencer 1/8" T40C-1800
24	1	30390 Bracket for crosscut knife
25	1	30431 Assembly console-bracket
26	1	30442 Assembly mountingplate for
27	1	30467 Assembly spring system
28	1	30470 Bracket for pulling of
29	1	30598 Clamping plate for AT5
30	1	30644 Assembly mountingbracket
31	4	82105900 Washer M5 FZB
32	3	82106000 Washer M6 FZB
33	8	82108000 Washer M8 FZB

REVISION HISTORY

REV	DESCRPTIO	DATE	APPROVED
A	Made	17-05-2004	KL
B	Renamed	06-05-2010	KC

	Skala/Scale:	1:2		Vægt/Weight:	kg
	Material: Welded Steel Mild			Konst./Designed:	
ID-Nr./Part No.:		30391		Tegnet/Drafted:	
Udfoldet iht./ Unfolding according to:		Ikke angivet tolerancer iht./ Not specified tolerance according to:		Thomas Vittrup	
Finavn/Filename:		30391 Assembly crosscut knife.iam		Dato/Date:	
Beskrivelse:		Assembly crosscut knife		13-05-2004	
Description:					
Sidst gemt/Last saved by: TV		Sidst gemt/Last saved: 17-05-2004		Papirstørrelse/Sheet size: A3	
				sheet 1 of 1	

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 HEDESTED GRUPPEN AS



ITEM QTY PART NUMBER		DESCRIPTION
1	4	10205012 Bolt unbrako cyl 5x12 FZB
2	4	10208016 Bolt.unbrako cyl 8x16 FZB
3	1	10208025 Bolt Unbrako Cyl. 8x25 FZB
4	2	11406016 Hexagon bolt m6x16 FZB
5	3	11406020 Hexagon bolt m6x20 FZB
6	2	11408025 Hexagon bolt m8x25 FZB
7	1	11410045 Hexagon bolt 10x45 FZB
8	2	1506000 Nut M6 FZB
9	1	17906000 Self-locking nut M6 FZB
10	3	17908000 Self-locking nut M8 FZB
11	1	17910000 Self-locking nut M10 FZB
12	1	20206016 Fitting bolt M6-8x16mm
13	2	20406012 Hexagon countersunk head 6x12 FZB
14	1	205918 Hub for crosscut knife
15	1	206060 Knife for slicing machine 50mm
16	1	206061 Lock for knife
17	1	206084 Air motor LZB 22A049-55
18	1	207854 Assembly console-bracket 2010
19	1	207857 Screen for Ø50 knife
20	1	207863 Bracket for knife screen
21	1	210300 Cylinder RA/192020/M/25
22	1	210421 Lock nut MIP1501/60
23	1	214312 Read sensor yellow
24	1	214314 Socket with 3M wire
25	2	215900 Straight connector Ø6 1/8"
26	2	215980 Banjo flow control Ø4 M5
27	1	216615 Double straight connector Ø6mm
28	1	216796 Silencer 1/8" T40C-1800
29	1	222300 Ball runner block size 25
30	1	303900 Bracket for crosscut knife
31	1	30442 Assembly mountingplate for
32	1	30467 Assembly spring system
33	1	30470 Bracket for pulling of
34	1	30598 Clamping plate for AT5
35	1	30644 Assembly mountingbracket
36	4	82105900 Washer M5 FZB
37	4	82106000 Washer M6 FZB
38	8	82108000 Washer M8 FZB

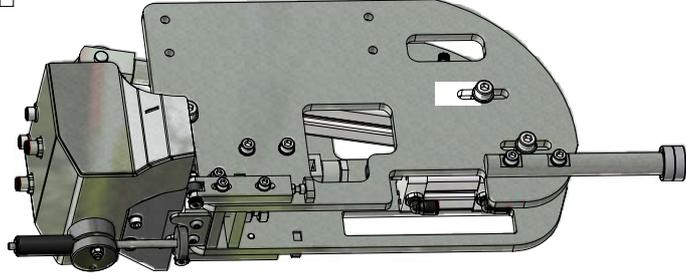
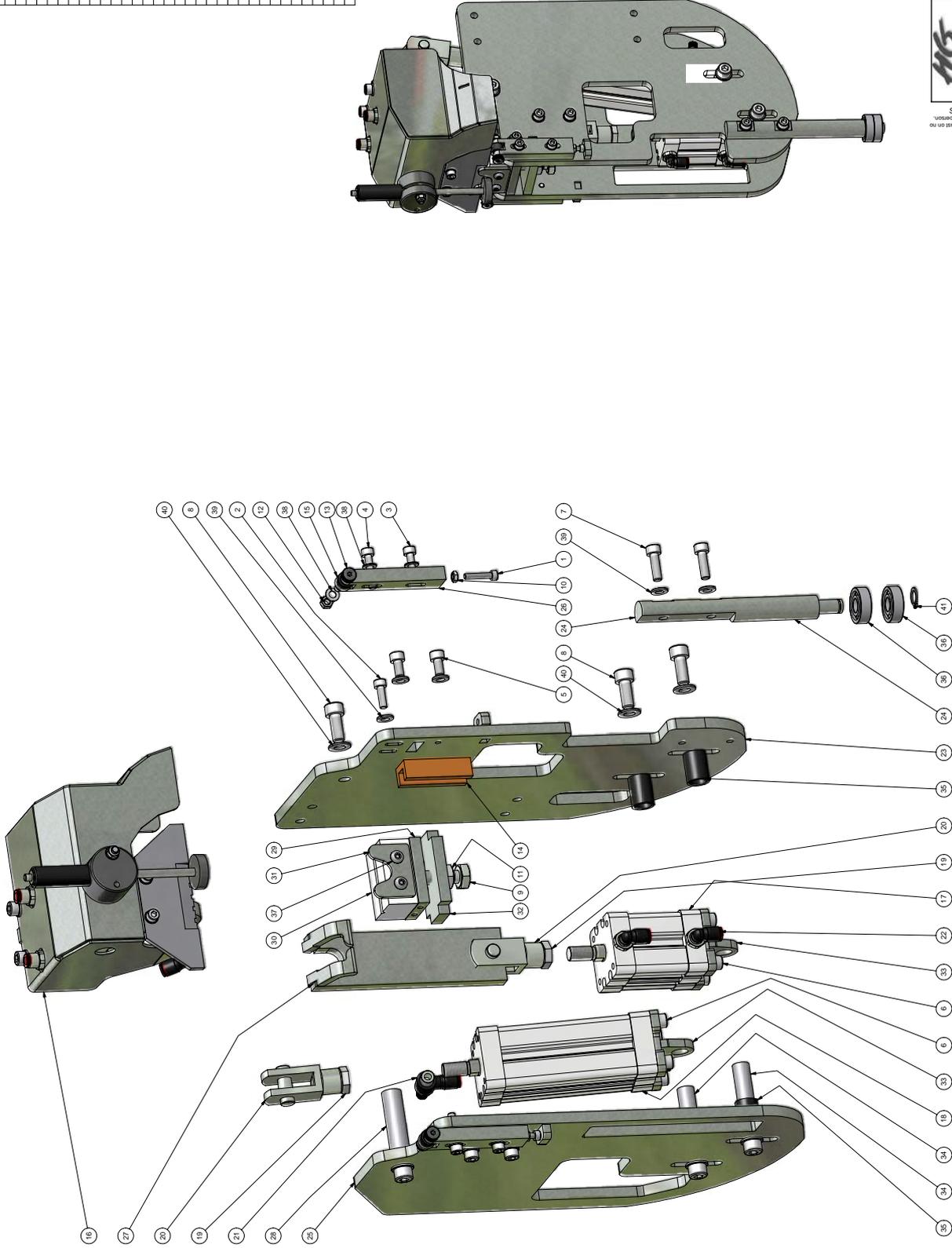
Parts List

	Scale: 1:2	Material: Welded Steel Mild Overl. beskaffning! Surface properties:	Weight: kg
	TD-Nr./Part No.: 207862 Filnavn/Name: 207862 Assembly crosscut knife 2010.lam Beskrivelse: Assembly crosscut knife 2010 Description:	Like angivet tolerancer iht./ Not specified tolerance according to: DS/ISO 2768-m TegneDated: Thomas Vittrup Dato/Date: 01-06-2010	
Status gemt/Last saved by: TV Status gemt/Last saved: 01-06-2010 Papirstørrelse/Sheet size: A2		sheet 1 of 2	

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REVISION HISTORY			
REV	DESCRIPTION	DATE	APPROVED
A	New drawing	01-06-2010	KL

ITEM	QTY	PART NUMBER	DESCRIPTION
1	2	10004020	Boil unbrake of 4x20 FZB
2	4	10005016	Boil unbrake of 6x16 FZB
3	2	10005020	Boil unbrake of 6x20 FZB
4	2	10005022	Boil unbrake of 8x16 FZB
5	2	10006012	Boil unbrake of 8x20 FZB
6	8	10006016	Boil unbrake of 6x16 FZB
7	2	10006020	Boil unbrake of 6x20 FZB
8	6	10006022	Boil unbrake of 8x20 FZB
9	1	11410030	Hexagon bolt 10x30 FZB
10	2	15040000	Nut M16 FZB
11	2	17000000	Self-lubricating nut M5 FZB
12	2	20005016	Filing tool M5 6x16mm
13	2	20079645	Bearing for pawlgr.
14	2	20079648	Roller for pawl cut with bushing
15	2	20079650	Pawlcut system 2010 - Left
16	1	21000000	Cylinder for pawlcut system
17	1	21000001	Cylinder for pawlcut system
18	1	21000002	Cylinder for pawlcut system
19	2	210427	Lock nut M16x100 M10x1,25
20	2	214115	F-Joint QM-80/22-25
21	2	215105	Barrel key control 08x 1/8"
22	2	215760	Shrivel elbow 60mm 1/8"
23	1	300585	Assembly back plate for pawl system, left
24	1	300586	Assembly back plate for pawl system, right
25	1	300588	Assembly front plate for pawl system, left
26	2	300455	Bracket for stop, pawltable
27	1	300481	Pawl clamp assembly
28	1	300666	Shaft for turning pawlcut
29	1	300570	Plate for mounting pawlgr. block
30	1	300575	Block for pawlgr. block
31	1	300576	Block for pawlgr. block
32	1	300660	Adjustment plate for pawlgr. block
33	2	300641	Assembly bracket for e32cyliner
34	2	300642	Shaft for cylinders
35	4	300643	Spacer 12,2 x 21,8
36	2	4720013	Bearing 0002 2161
37	2	4720014	Bearing 0002 2162
38	6	82100000	Washer M5 FZB
39	8	82100000	Washer M6 FZB
40	6	82100000	Washer M8 FZB
41	1	85710000	Spring ring for shaft Ø10 dm. 471



HGS Heddensted Gruppen

Scale: 1:2

Date: 2019/1

Drawn by: [Name]

Checked by: [Name]

Approved by: [Name]

Project: 20371 Pawlsystem_2010 left side.lam

Part name: [Name]

Weight: [Value] kg

Material: [Material]

Surface treatment: [Treatment]

Coating: [Coating]

Reference: [Reference]

Revision: [Revision]

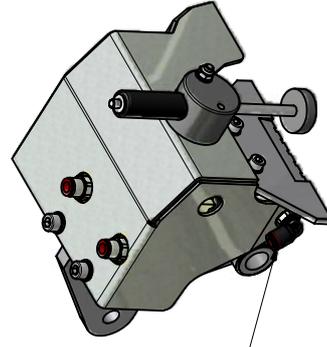
Scale: [Scale]

Sheet: 1 of 2

REV	DESCRIPTION	DATE	APPROVED
D	New drawing	28-05-2010	KL

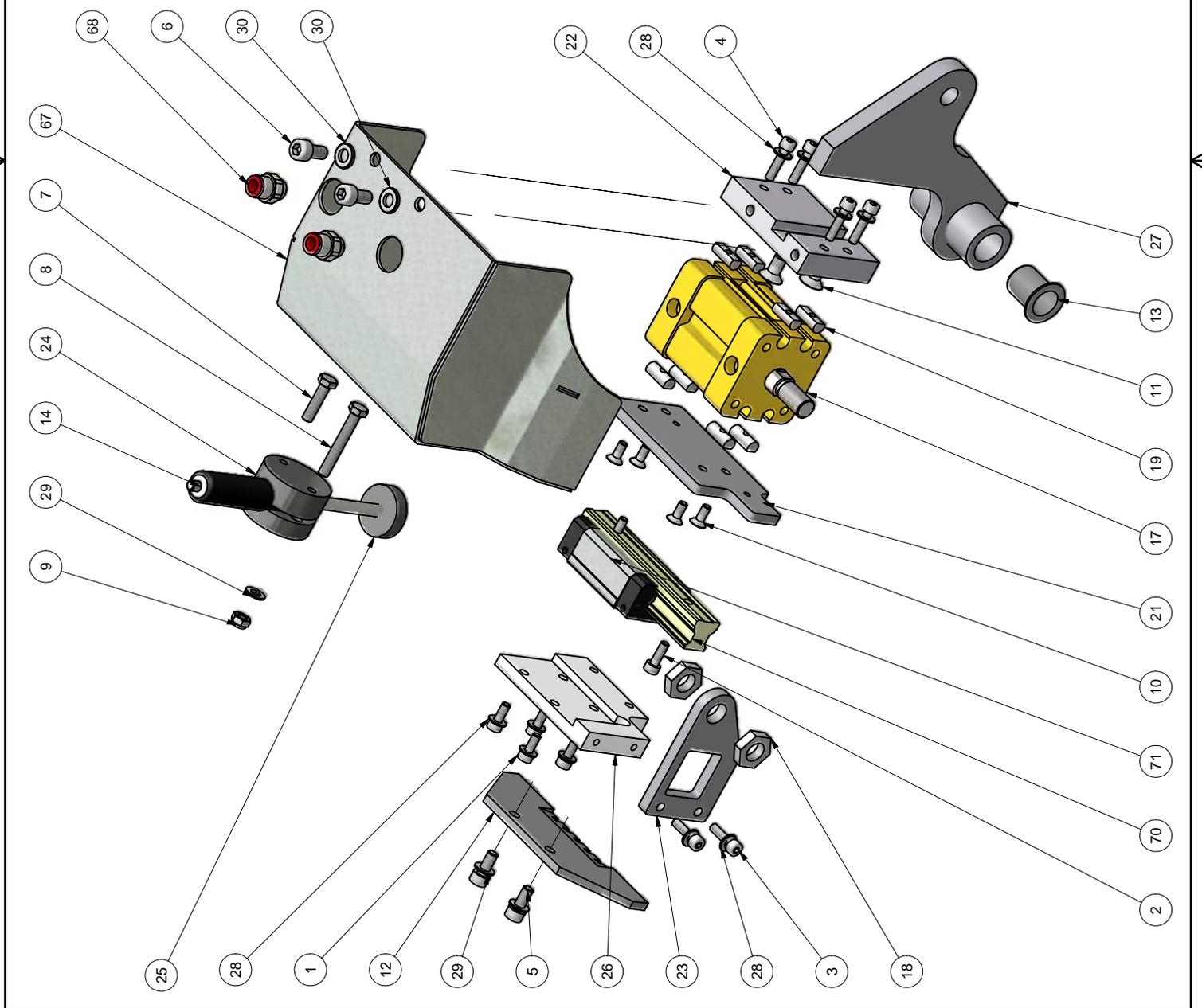
REV	DESCRIPTION	DATE	APPROVED
D	New drawing	28-05-2010	KL

Parts List			
ITEM	QTY	PART NUMBER	DESCRIPTION
1	4	10204010	Bolt.unbraco cyl 4x10 FZB
2	2	10204012	Bolt.unbraco cyl 4x12 FZB
3	2	10204016	Bolt.unbraco cyl 4x16 FZB
4	4	10204018	Bolt.unbraco cyl 4x18 FZB
5	2	10205012	Bolt.unbrako cyl 5x12 FZB
6	2	10206012	Bolt.unbrako cyl 6x12 FZB
7	1	11405020	Hexagon bolt m5x20 FZB
8	1	11405035	Hexagon bolt m5x35 FZB
9	1	17905000	Self-locking nut M5 FZB
10	4	20404010	Hexagon countersunk head 4x10 FZB
11	2	20406012	Hexagon countersunk head 6x12 FZB
12	1	207825	Paw knife CC HSS110-62-40-4mm
13	2	207840	Slide Bearing GFM-1416-21
14	1	207875	Gas spring Ø6x50 50N
17	1	210330	Cylinder RA/192032/M/20
18	2	210427	Lock nut MP150189_M10x1,25
19	8	214184	Groove nut MP72816
21	1	30237	Mountingplate for left pawknife rail
22	1	30238	Top for console, pawknife
23	1	30250	Bracket for pawknife
24	1	30253	Bracket for gasspring, paw cut
25	1	30254	Pellet for gaspring
26	1	30285	Mountingpiece for left pawknife
27	1	30323	Assembly, branch for turning
28	10	82104000	Washer M4 FZB
29	3	82105900	Washer M5 FZB
30	2	82106000	Washer M6 FZB
67	1	207976	Left Screen for paw blow
68	2	216520	Straight connector Ø6mm 1/8"
69	1	215760	Swirvel elbow Ø6mm 1/8"
70	1	207984	Ball guide rail size 15-95
71	1	207982	Ball runner block size 15

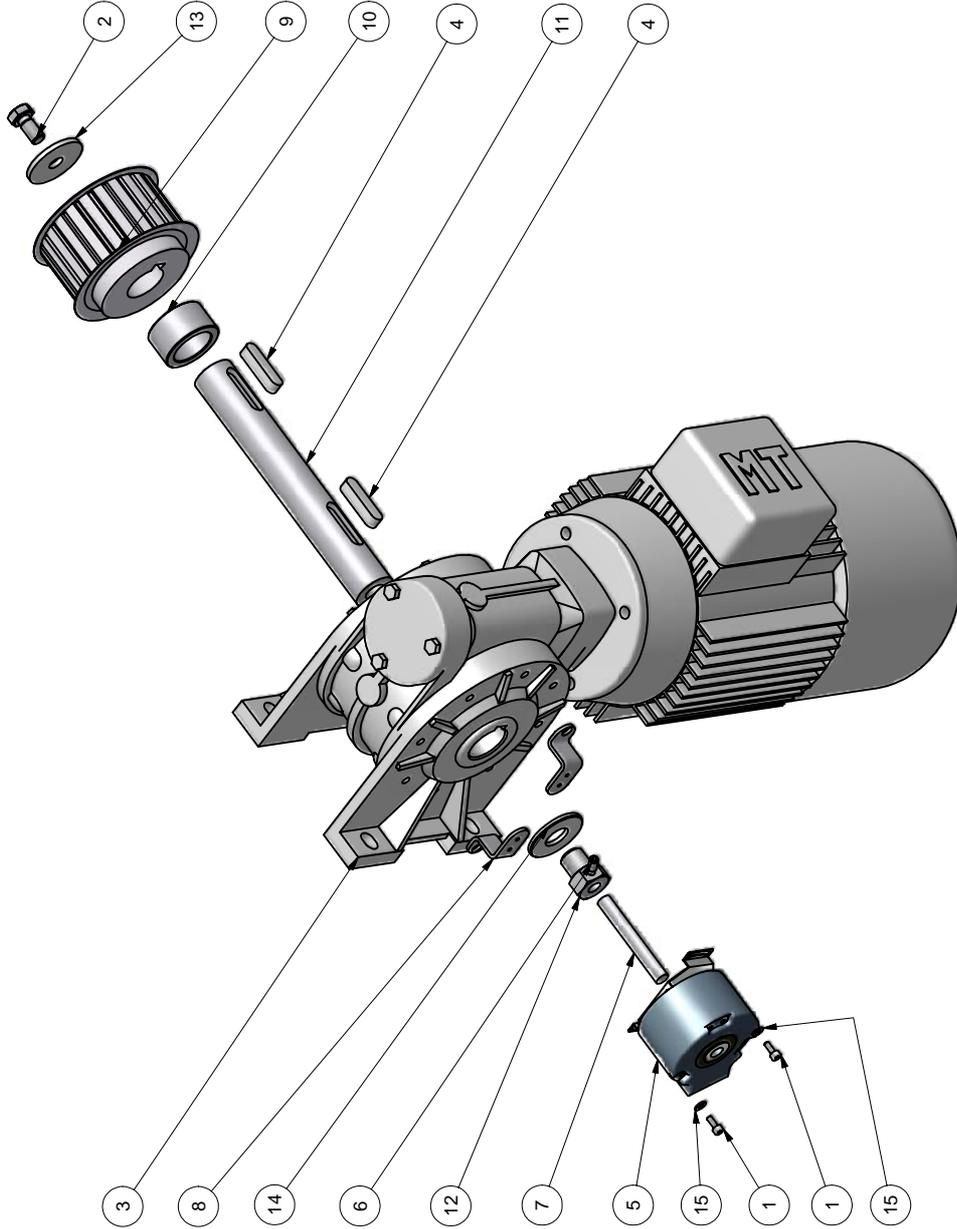


Break all edges
Alle kanter reifes

HEDENSTEDT GRUPPEN AS
 Scale: 1:2
 DS/ISO 2768-m
 Overfl. beskaffenhed/Surface properties:
 TegningsDraet: KL
 Part No.: 207969
 Material:
 Beskrivelse: Pawcut system_2010 - Left
 Description: Combi / Quick cut
 Udgave / Revision: KL
 Beskrivelse / Revision: 28-05-2010
 Sheet size: A3
 Side: 1 / 2



ITEM	QTY	PART NUMBER	DESCRIPTION
1	2	10203008	Bolt Unbraco cyl 3x8 FZB
2	1	11408016	Hexagon bolt m8x16 FZB
3	1	207902	Gearmotor high-effect with breake
4	2	207947	Key 8x7x32mm DIN-6885A
5	1	207956	Encoder Type 8.5020.C922.0500
6	1	20905010	Stop screw M5-10 FZB
7	1	30171	Shaft for encoder
8	2	30172	Bracket for encoder
9	1	30266	Pulley AT10 Z24 - gear side
10	1	30267	Spacer for large gear
11	1	30775	Shaft for large gearmotor
12	1	30776	Nut for large gearmotor
13	1	4809335	Washer type SRKB ø9x35x3
14	1	4814335	Washer Type SRKB ø14x35x3
15	2	82103000	Washer M3 FZB



Parts List

Alle kanter reifies

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HEDENSTED GRUPPEN A/S

Part No.: 207862

Beskrivelse: Gear for tower

Scale: Like angivet tolerance iht./ Not specified tolerance according to: DS/ISO 2768-m

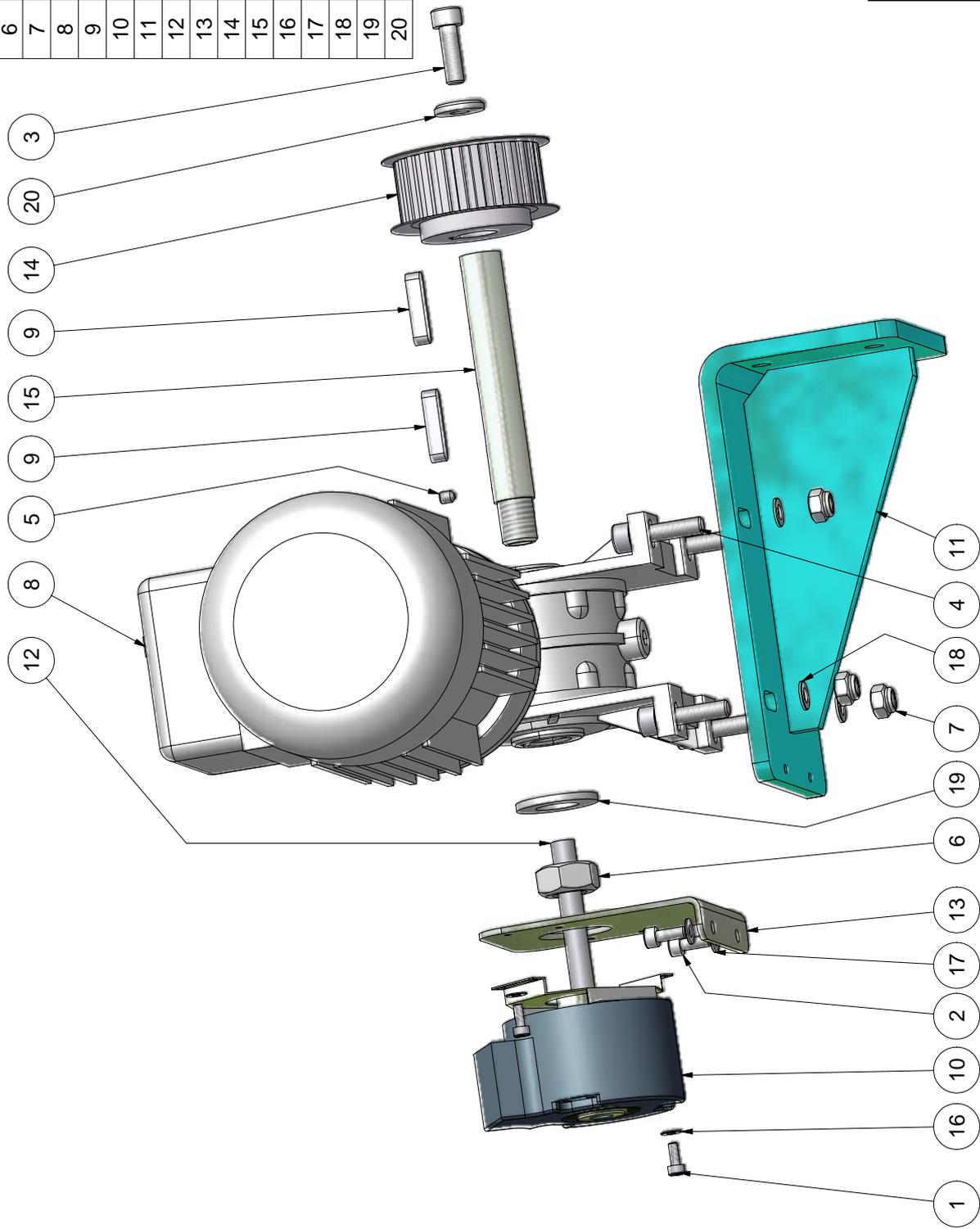
Overfl. beskaffenhed/Surface properties: Tegner/Draft: KL

Material: Date: 02-03-2007

Revision History: 1 / 1

Parts List

ITEM	QTY	PART NUMBER	DESCRIPTION
1	2	10203008	Bolt Unbraco cyl 3x8 FZB
2	2	10204010	Bolt.unbraco cyl 4x10 FZB
3	1	10206020	Bolt unbraco cyl 6x20 FZB
4	4	10206025	Bolt unbraco cyl 6x25 FZB
5	1	10504005	Stop screw 4x5 black
6	1	1512000	Nut M12 FZB
7	4	17906000	Self-locking nut M6 FZB
8	1	207903	Gearmotor RMI28 1:10 0.18kW
9	2	207946	Key 5x5x25mm DIN-6885A
10	1	207956	Encoder Type 8.5020.C922.0500
11	1	30144	Small engine bracket
12	1	30171	Shaft for encoder
13	1	30173	Bracket for encoder crosscut knife
14	1	30600	Pulley AT5 Z32 gear side
15	1	30780	Shaft for crosscut knife
16	2	82103000	Washer M3 FZB
17	2	82104000	Washer M4 FZB
18	8	82105900	Washer M5 FZB
19	1	82112000	Washer M12 FZB
20	1	87606000	Washer ø6,5x16,5x3 FZB



Alle kanter reifes
Breake all edges


Hedensted Gruppen
 Part No.: 207959
 Description: Gear for crosscut knife 2010

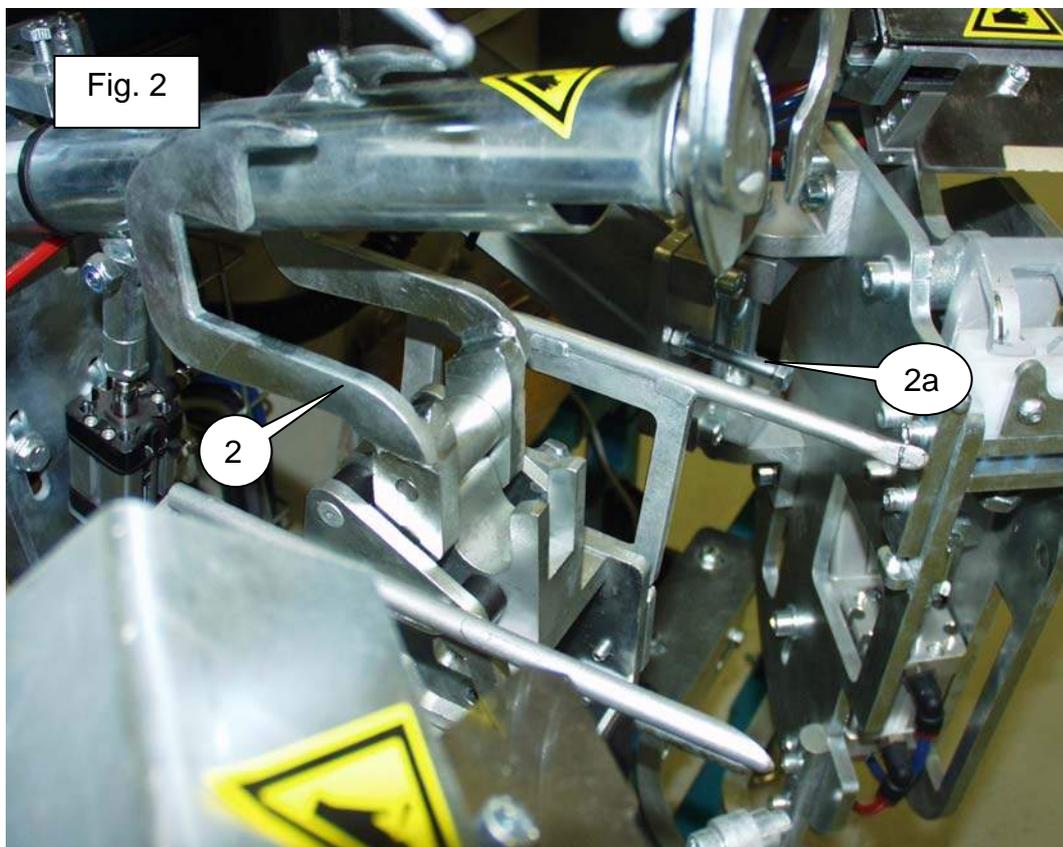
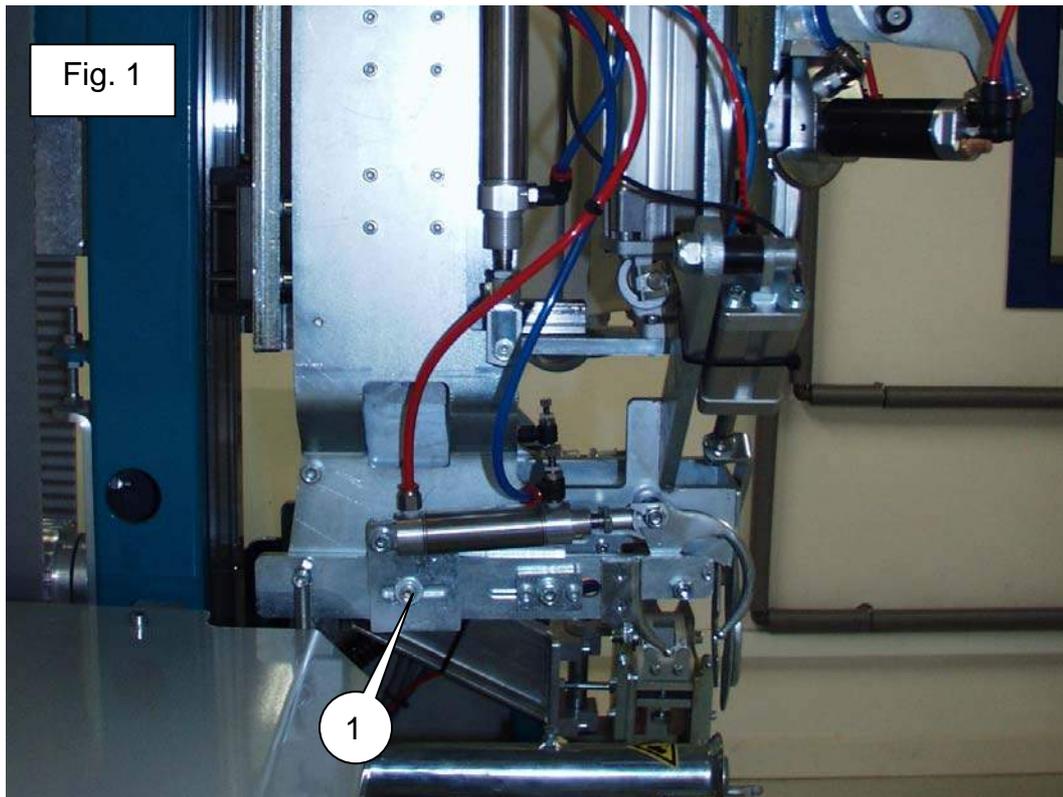
Scale:  DS/ISO 2768-m
 Overfit: 
 Material: KC
 Date: 05-03-2007

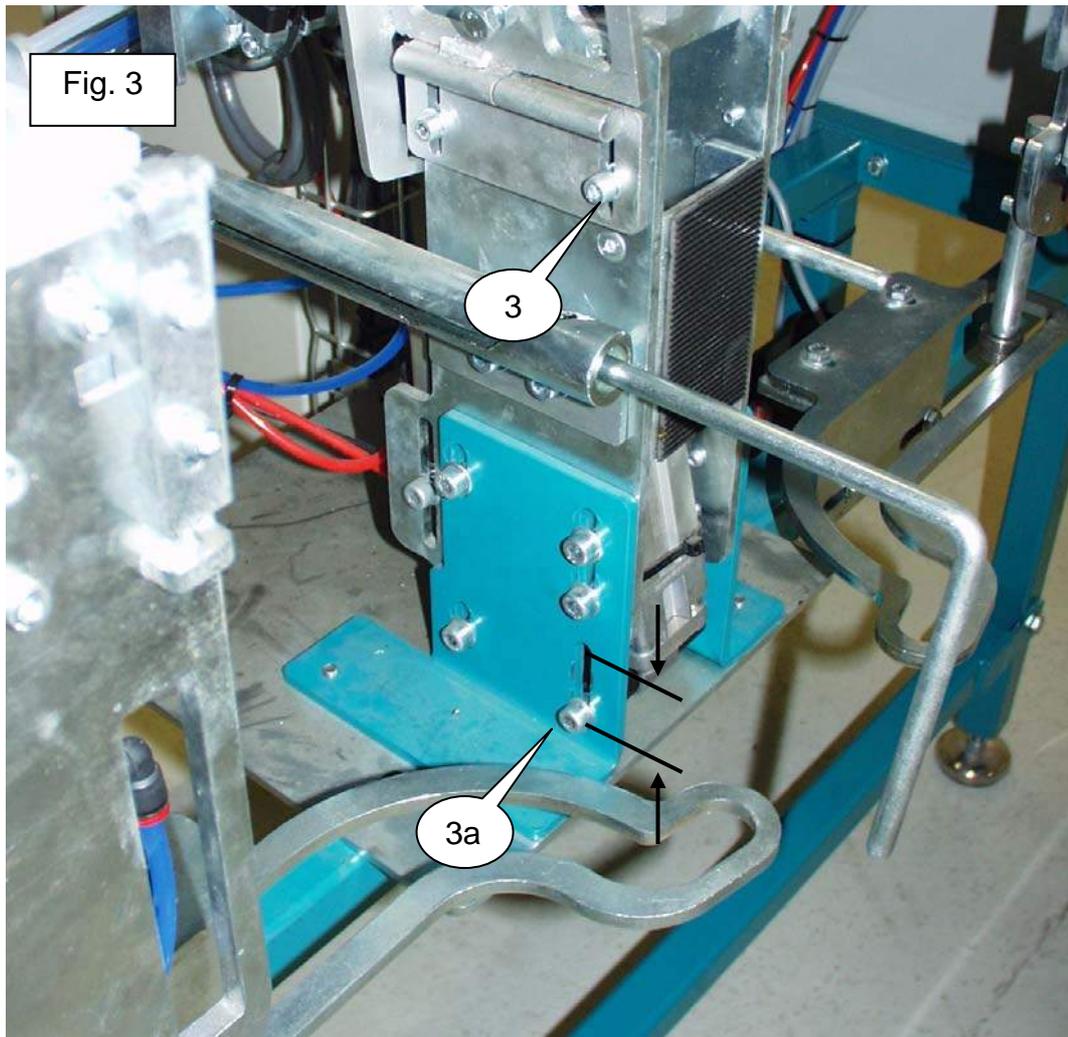
Revision History:
 REV: A
 DESCRIPTION: Made
 DATE: 28-05-2010
 APPROVED: KC

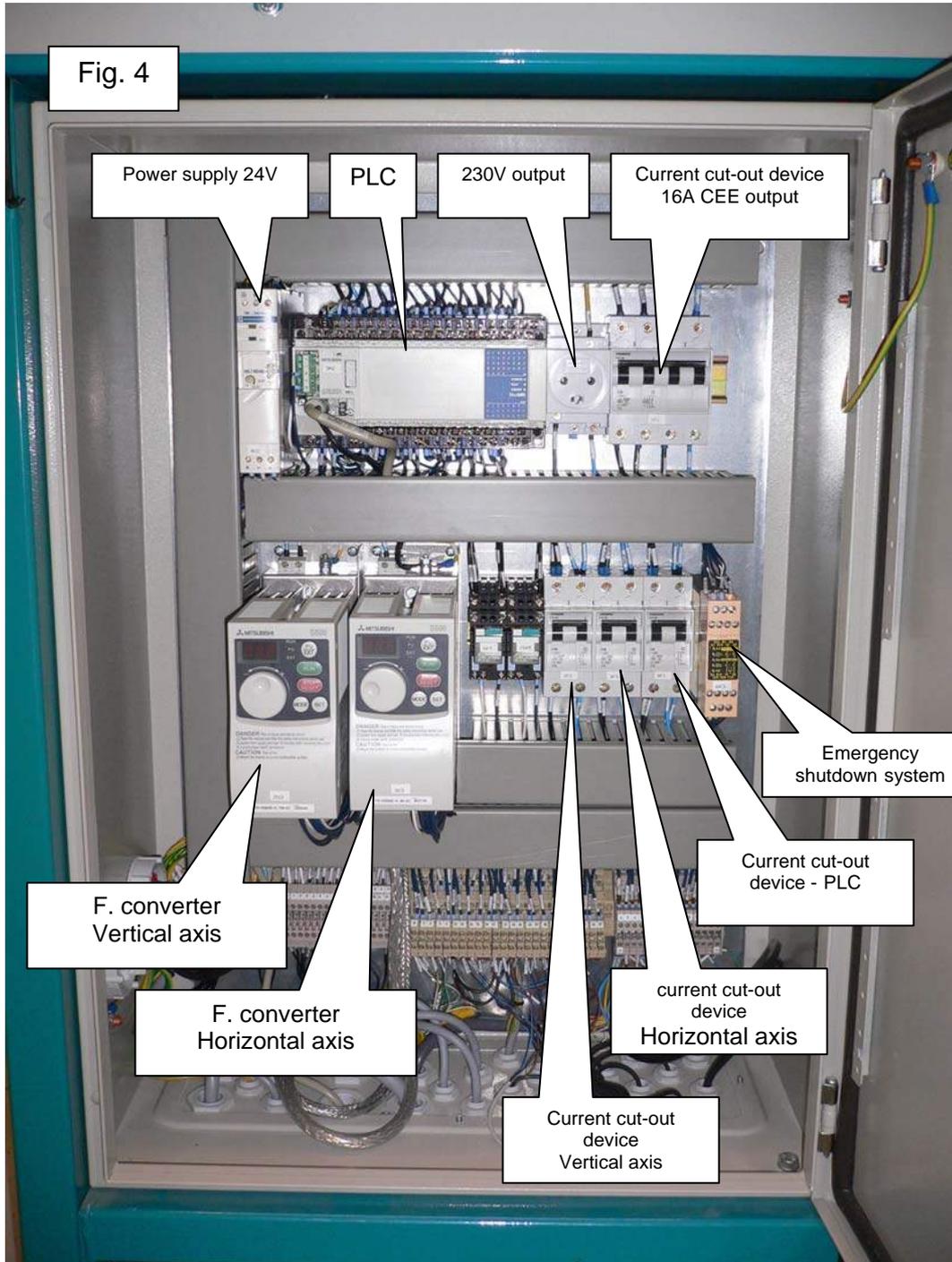
Sheet: 1 / 2

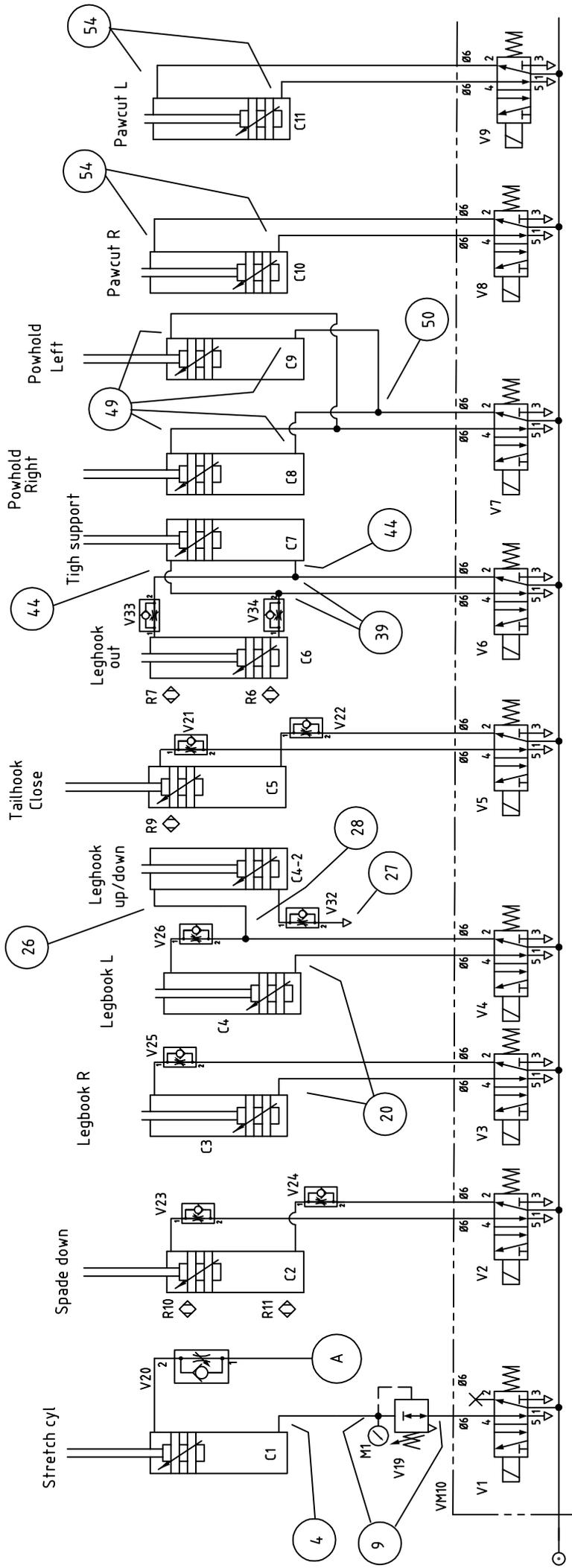
13. FAQ

Problem	Cause	Solution
When I put the mink in and step the pedal the paw is pulled out of the paw holder?	The stretch pressure is too high or there is dirt in the slide	Reduce the stretch pressure, and if it does not help, dismount the air of the machine, clean and massage the slide.
The cross-section is not quiet over the mink, even though I have just put it in?	The paw holders are mutual incorrectly adjusted.	Adjust the screws, which are marked with 2a on figure 2, so that the line between the two is quite right.
When I make a triangle cut, the cut is not deep enough?	The spade does not cut deep enough in the mink.	Adjust the depth in vertical data on the operating panel
When the legs are being loosened, the skin bursts on the thigh?	The cross cut is laid too far on the belly side of the legs, therefore it does not cross the paw blades.	
Too much meat is left on the thighs by loosening the legs?	The hooks do not close far enough round or it is bended.	Figure 1- open the hooks a little bit more with the adjustment screw
I have opened the hooks, but it does not help?		Adjust the depth on the hind leg loosener in the operating panel (vertical data), they have to be placed about 3-4 mm under the thigh holder.
Even though I close the hooks correctly round the thighs, it does not loosen well?	The hook does not close far enough round or it is bended	Try to increase the length and stroke, so that the balls just pass each other. If defect – then change the hook.
The tail spade makes a hole in the skin when it runs down?	The tail is stretched to hard out, or there can be a burr on the side of the spade.	
I have closed the tail hook and want to complete the skin, but the machine stops?	The signal for completing is missing, probably because some dirt is in the lock to the body holder.	Press reset on the panel, clean the lock and run the body again
I have cleaned the lock, but still it does not work?	When you run big minks, it can happen, that the body holder do not get far enough round to lock	Fig. 3 – At repeatable cases, try to increase the length of stroke by raising the cylinder 3-4mm (3a). At the same time lower the hind leg holder similar.
The tail is not cut up properly?	The tail roll is wrong adjusted, or it does not get close enough to the blade. The blade can be deaf.	Check that the tail roll attach can move unhindered in the length direction, clean for dirt. Sharpen the blades if necessary.
I have tried the various possibilities, but still it does not work?		Dismount the air of the machine and check that the tail roll can reach right to the blades. The tail roll has to be placed right beneath the centre of the blades.









VESTERLUNDEJ 18 2730 HERLEV
 ANELYSTPARKEN 43C 8381 TILST.
 HVIDKÆRVEJ 31 5250 ODENSE SV. 66139333

Måltørh.

Tegn.	1-6-10	PD
Reff.	29-6-10	PD
Reff.		
Reff.		

Erst. for: A3-935D

Tegn. nr.

ODS-0566-35714-A1

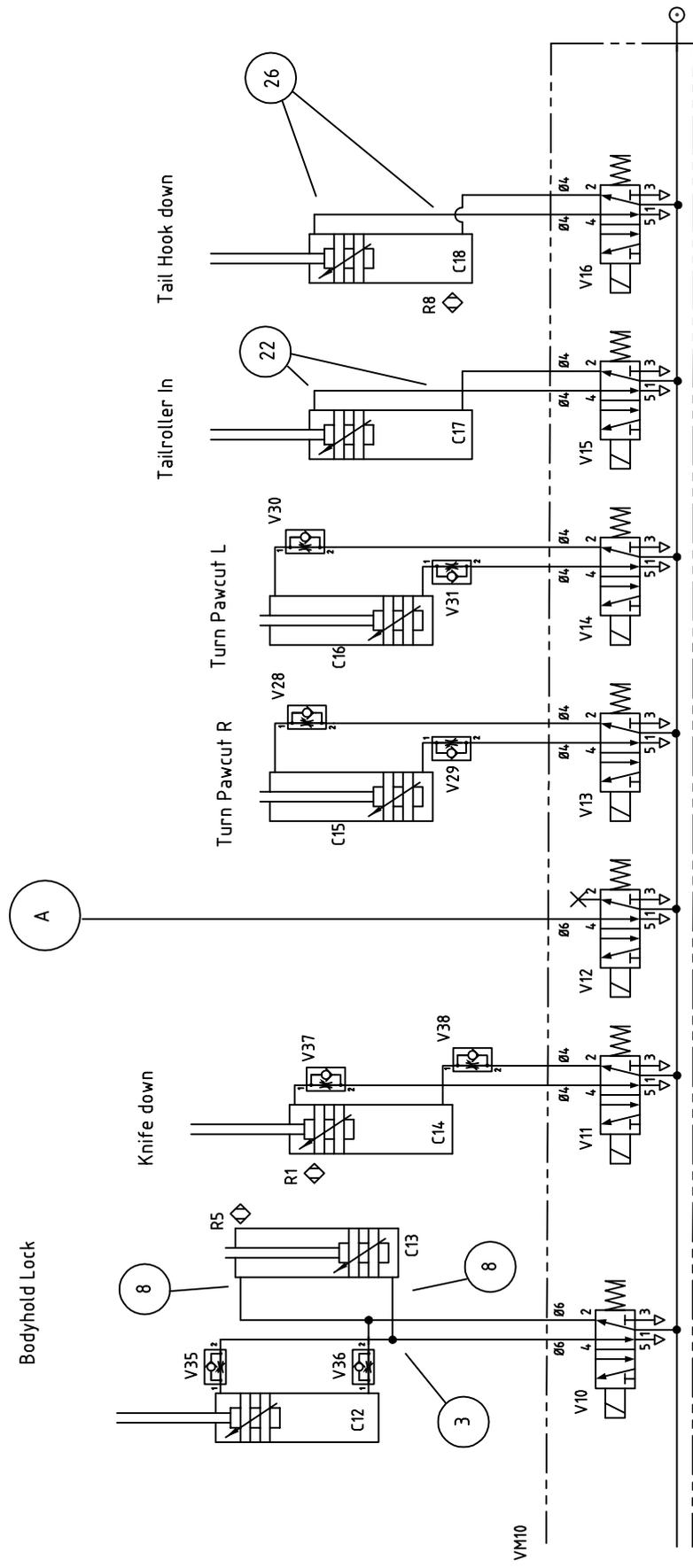
Erst. af

Combicut 2010
 Parts of lists ODS-0566-S1



		Hedensted Gruppen A/S	
Drawing no.		ODS-0566-35314-A1	Date: 29-6-2010
Parts of list		ODS-0566-S1	Design: Peter Damsgård
Drawing		Combicut 2010	A4-10774
Item	No.	Descreption	Norgren Ident. no.
1	1	Cyl C1	PRA/182032/M/320
2	1	F-Mounting	QM/8025/25
3	1	L-Mounting	QA/8032/24
4	1	Swivel	C02470618
5	1	Banjo flow control V20	C0L510618
6	1	Valve V19	R07-100-RNEG
7	1	Bracket	M/P71273/3
8	1	Gauge M1	18-013-011
9	2	Swivel	C02470618
10	1	Mounting nut	2962-04
11			
12	1	Cyl C2	PRA/182040/M/500
13	1	F-Mounting	QM/8040/25
14	1	L-Mounting	QA/8040/24
15	2	Banjo flow control V23-V24	C0K510628
16			
17	2	Cyl C3-C4	RT/57225/M/50
18	2	F Mounting	QM/57025/25
19	2	Nut	M/P1501/89
20	2	Straight adaptor	C01250618
21	2	Banjo flow control V25-V26	C0TA00618
22			
23	1	Cyl C4-2	RM/8026/M/80
24	1	F Mounting	QM/8025/25
25	1	Banjo flow control V32	C0K510618
26	1	Swivel	C02470618
27	1	Silencer	100110600
28	1	Swivel Y adaptor	C00820600
29			
30	1	Cyl C5	RA/192032/M/80
31	1	Nut	M/P1501/89
32	2	Banjo flow control V21-V22	C0K510618
33			
34	1	Cyl C6	RT/57225/M/50
35	1	Nut	M/P1501/89
36	1	UF-Mounting	QM/8025/32
37	1	L-Mounting	QM/57025/24
38	2	Banjo flow control V33-V34	C0TA00618

39	2	Swivel Y adaptor	C00820600
40			
41	1	Cyl C7	RA/192032/M/20
42	1	F Mounting	QM/8025/25
43	1	Nut	M/P1501/89
44	2	Swivel	C02470618
45			
46	2	Cyl C8-C9	RA/192032/M/25
47	2	F Mounting	QM/8025/25
48	2	Nut	M/P1501/89
49	4	Swivel	C02470618
50	2	Swivel Y adaptor	C00820600
51			
52	2	Cyl C10-C11	RA/192032/M/20
53	4	Nut	M/P1501/89
54	4	Straight adaptor	C02250618
55			

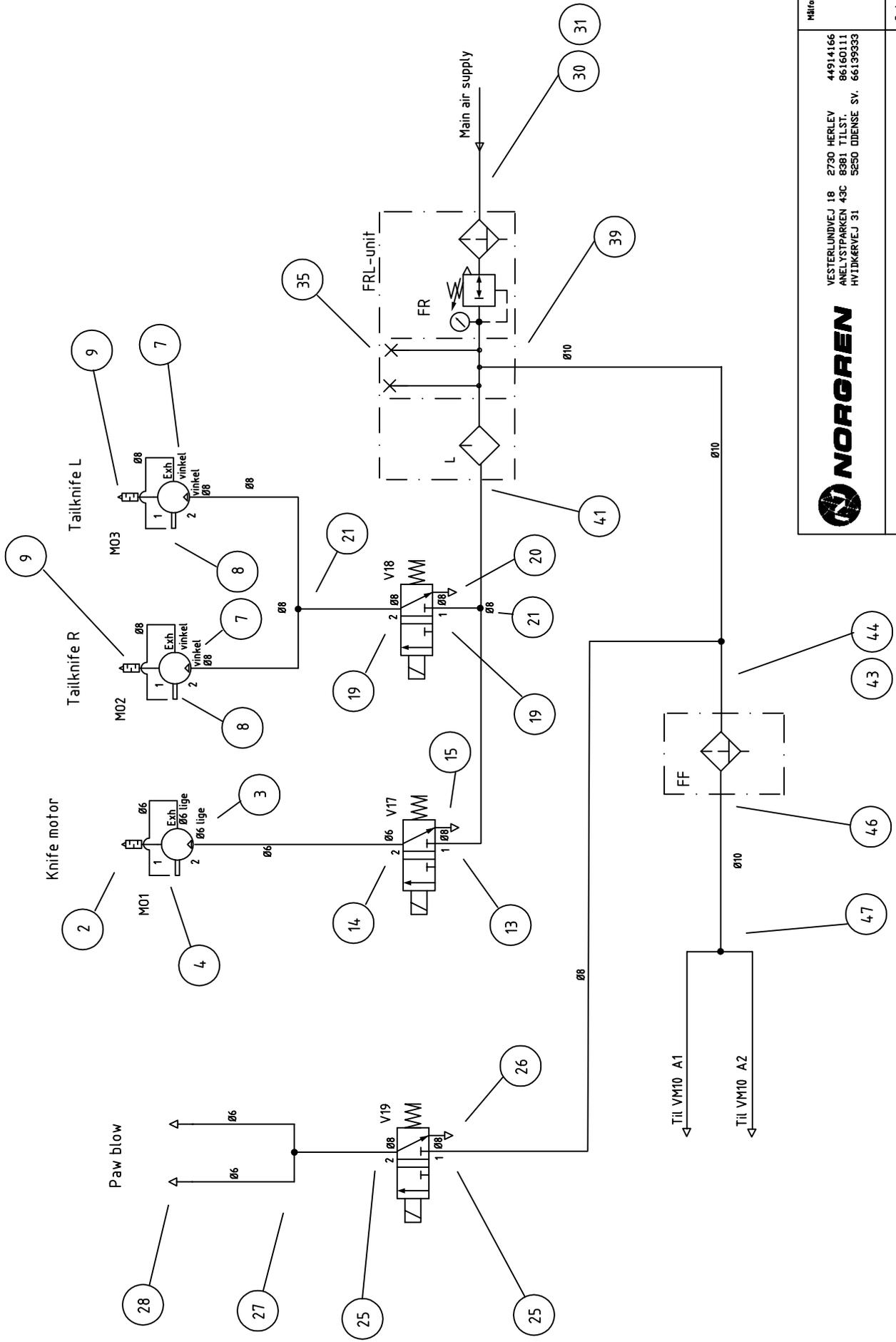


Måttorh.	Tegn.	1-4-10	PD
	Reff.	29-4-10	PD
	Reff.		
	Reff.		
Ersät. för: A3-995D			
Tegn. nr.		ODS-0566-35714-A2	

NORGREN	44914166	2730 HERLEV
	86160111	8381 TILST.
	66139533	5250 DDENSE SV.
<p>CombiCut 2010</p> <p>Parts of list ODS-0566-S2</p>		



		Hedensted Gruppen A/S	
Drawing no.		ODS-0566-35314-A2	Date: 29-6-2010
Parts of list		ODS-0566-S2	Design: Peter Damsgård
Drawing		Combicut 2010	A4-10774
Item	No.	Description	Norgren Ident. no.
1	1	Cyl C12	RM/8026/M/125
2	2	Banjo flow control V35-V36	C0K510618
3	2	Swivel Y adaptor	C00820600
4			
5	1	Cyl C13	PRA/182040/M/80
6	1	F-Mounting	QM/57040/25
7	1	R-Mounting	QA/8040/27
8	2	Straight adaptor	C02250628
9			
10	1	Cyl C14	RA/192020/M/25
11	1	Nut	M/P1501/60
12	2	Banjo flow control V37-V38	C0K510405
13			
14	2	Cyl C15-16	RA/192032/M/80
15	2	F-Mounting	QM/8025/25
16	2	Nut	M/P1501/89
17	4	Banjo flow control V28-V31	C0K510418
18			
19	1	Cyl C17	RA/192025/M/25
20	1	F-Mounting	QM/8020/25
21	1	Nut	M/P1501/60
22	2	Swivel	C02470405
23			
24	1	Cyl C18	RA/192032/M/50
25	2	Nut	M/P1501/89
26	2	Swivel	C02470618



VESTERLUNDEJ 18 2730 HERLEV 44914166
 ANELYSTPARKEN 43C 8381 TILST. 86160111
 HVIDKÆRVEJ 31 5250 ODENSE SV. 66139333

Måltørh.	Tegn.	1-6-10	PD
	Tegn.	29-6-10	PD

Erst. for:	
Tegn. nr.	ODS-0566-35714-A3
Erst. af:	

Combicut 2010
 Parts of list ODS-0566-S3



		Hedensted Gruppen A/S	
Drawing no.		ODS-0566-35314-A3	Date: 29-6-2010
Parts of list		ODS-0566-S3	Design: Peter Damsgård
Drawing		Combicut 2010	A4-10774
Item	No.	Description	Norgren Ident. no.
1	1	Air Motor M01	LZB22A049-55
2	1	Silencer	T40C1800
3	2	Straight adaptor	C02250618
4	1	Straight union	C00200600
5			
6	2	Air Motor M02-M03	LZB22A049-55
7	4	Swivel	C02470818
8	2	Swivel	C02470828
9	2	Silencer	T40C1800
10			
11	1	Valve V17	V60A413A-A313J
12	1	Connector	M/P43313/3
13	1	Swivel	C02470818
14	1	Swivel	C02470618
15	1	Silencer	T40C1800
16			
17	1	Valve V18	V61B413A-A313J
18	1	Connector	M/P43313/3
19	2	Swivel	C02470828
20	1	Silencer	T40C2800
21	2	Swivel Y adaptor	C00820800
22			
23	1	Valve V19	V60A413A-A313J
24	1	Connector	M/P43313/3
25	2	Swivel	C02470818
26	1	Silencer	T40C1800
27	1	Swivel Y adaptor	C00820806
28	2	Swivel	C02470618
29			
30	1	Plug Male	234110028
31	1	Adaptor	4215-08
32	1	Filterregulator FR	B72G-2GK-AL3-RMN
33	1	Tamper resistant	4255-51
34	1	Gauge	18-013-989
35	2	Plug Male	160050028
36	2	Quikclamp and Wall mount	4214-52
37	1	Quikclamp	4214-51
38	1	Porting blok	4216-52

39	1	Straight adaptor	C02251028
40	1	Lubricator	L72M-2GP-ETN
41	1	Swivel	C02470828
42			
43	1	Swivel Tee adaptor	C02671038
44	1	Stem reducer	C00231008
45	1	Oil removal filter FF	F73C-3GD-AT0
46	1	Swivel	C02471038
47	1	Union Tee	C00601000
48	1	wall mounting bracket	4424-50
49			
50	1	Valve V1-V16	VM101602172
51	2	Plug Ø6	110040600
52	1	Cabel 3 m D Sub 90gr.	V12088-E03

15. EC Declaration of Conformity

Hedensted Gruppen A/S

Vejlevej 15,

8722 Hedensted

- herewith declares that:

HG slicing machine Combi Cut

Typenumber 207800

- is in conformity with the provision of:

The Machinery Directive 98/37/EF

The low Voltage Directive 73/23/EØF

- and the following harmonised standards have been applied.

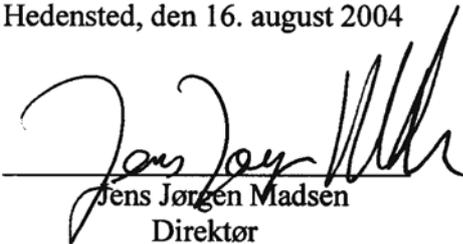
EN 292-1

EN 292-2

EN 60/439-3

EN 294

Hedensted, den 16. august 2004



Jens Jørgen Madsen
Direktør

16. Technical specifications.

Voltage	:	3x400V + N + PE
Connection	:	16A CEE
PLC-control	:	220 V/ 24 V DC
Pneumatic air	:	7 bar
Air volume	:	Min. 500 l/min.
Air connection	:	Cejn 320 quick coupling
Kapacity	:	180/350 mink pr. hour
Weight	:	300 kg
Dimensions	:	
Width	:	1400 mm
Transport hight	:	2400 mm
Operating hight	:	3000 mm
Length	:	900 mm