

## Machine Rebuild Generic Specifications

Haven Model: 871, 872, and 873 Dual-Blade Cutoff

### Overall Process Description:

Haven Manufacturing Corp. provides its customers with a reasonably priced alternative for re-furbishing their Dual-Blade cutoff head. This program enables our customer to receive original equipment material and experienced craftsmanship to bring used cutoff heads back to near new condition. If required, Haven will provide a loaner cutoff head that the customer can use while their machine is being serviced. The only production downtime experienced is the time it takes to swap the loaner head with the head to be rebuilt. The rebuilding process begins with a thorough evaluation of the cutoff head. Our technicians will examine the entire head for excessive wear or damage and make a recommendation for refurbishment. At a minimum, the Basic Rebuild Plan will be completed per the below listed guideline. If the evaluation shows a need for replacement of other components, the customer will be notified and given the opportunity to approve the additional work as described in the Extended Rebuild Plan. Upon completion, all rebuilt heads are subjected to an original equipment run-in period where the head is cycled to assure proper operation. Haven warrants our material and workmanship on all rebuilds for 90 days.

### Loaner Head Program:

Haven Manufacturing Corp. will loan the customer a replacement Model #871, #872 or #873 cutting head for use while their cutoff head is being refurbished. The replacement head will be shipped in a returnable container that the customer will use to send their unit back to Haven. The loaner head will be provided at NO CHARGE to the customer; shipping costs are customer's responsibility.

### Basic Rebuild Plan:

The following list describes the basic rebuild package.

1. Complete evaluation of all components as compared to original equipment standards.
2. Replacement of the following component groups:
  - a. Lamina
  - b. Pins
  - c. Integral
  - d. Lubrication injectors
  - e. Bearings
  - f. Misc. parts
3. Re-grind die nest (if necessary)
4. Cycle head for a minimum of 10,000 stokes
5. Clean and paint outside surfaces.

### Extended Rebuild Plan:

Depending on the age and condition of the cutoff head, additional parts may have to be replaced. Based on Haven's initial evaluation, the customer will be notified of what parts are recommended and the additional cost to complete the work. Haven will not proceed without customer approval. To better understand how the Extended Rebuild Plan goes beyond the Basic Rebuild Plan, listed below are most, but not necessarily all, of the parts that may need replacement:

1. Main cutting cylinder
2. Clamp drive weldment
3. Bell Crank
4. Clamp cylinder
5. Clevis for cut cylinder
6. Clevis for clamp cylinder
7. Drive link
8. Power link
9. Horizontal drive block

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