

User Manual

SLAG



HOG

SH2

67087 Slag Removal Tool for use on laser cutting machines with
minimum 1.25" between slats

 **SlatPro**



1. Description

The tool is moved along the slats on the bed of a laser machine to remove slag that accumulates while cutting. Rotary cutting tools ride on each side of the slat to lift and remove the slag. It may be used on steel, copper or hybrid steel/copper slats. When not in use it may be rolled along the floor and stored in the upright position.

2. Specifications

Voltage	120V 60 Hz single phase
Current	7 Amp max
Weight	44 pounds
Overall Length	92"
Slat Thickness	11 to 12 ga
Slat Length	49-80"
Min spacing between slats	1.25"

Replacement Cutters

- 66145 SET RH & LH Cutter

3. Initial Assembly

The Slag Hog ships in two pieces; power unit and the handle assembly. All fasteners are metric.

- Remove the acorn nuts and button head socket screw from the 1.36" diameter stub on the power unit
- Slide the handle on the stub with the power out cord of the handle on the same side as the plug in on the power unit.
- Plug the power cord from handle tube into the power unit
- Do not plug in to power outlet before verifying the switches on the handle and power unit are off; both rocker switches to 0.

4. Operation

Before plugging into power verify that the two switches are turned off

Wear work gloves and safety glasses when operating

Lift onto the cutting machine bed with care

Use extreme care near the cutters. Do not touch them unless the tool is unplugged

The tool has two on/off switches



Rocker switch on handle end, in off position, acts as circuit breaker reset in case of over-current



Rocker Switch on power unit in off position.

Both switches must be in on or “I” position to run. Turning either switch off stops motor operation.

The upper left picture shows the on/off switch that acts as the circuit breaker when the unit is overworked. If the slats are not straight it is possible for the cutters to grab onto two slats and stall the motor which will trip the breaker. If this occurs wait a minute, reset the breaker switch, and resume operation. When slats have excess slag build up it may cause the circuit breaker to overload. If this happens the operator will need to reduce force used for cleaning slats. If this occurs wait a minute, reset the breaker, and resume operation.

To begin use, place the tool on the slat bed of the laser machine, center the cutters over a slat, and turn on both switches. The slats can be cleaned by moving the tool in either direction along the slat across the bed.



With switches off plug tool into a 15 or 20 amp 120Volt outlet



Cutters shown centered on slat

To see the unit in operation, go to Youtube and search for Slaghog. The best video is:
<https://www.youtube.com/watch?v=PDvEFRREdgg>

The cutter geometry is ideal for most slat/pallet bed configurations. If the fit of the cutters on the slats does not seem correct contact the factory to find out options that are available.

When storing in upright position the unit is tippy and care must be taken to ensure that it does not fall over which may lead to damage of handle end components. Damage due to dropping, improper handling or falling over is not covered by warranty.

5. Maintenance

Disconnect power by unplugging from outlet before performing any work on the tool

5.1 Cutters

The cutters will dull over time and require replacement.

Tools required for replacement

- 6mm L Hex wrench
- 6mm male hex socket wrench
- Adjustable open wrench

Parts required are 66145 SET RH & LH Cutters with included capscrews.

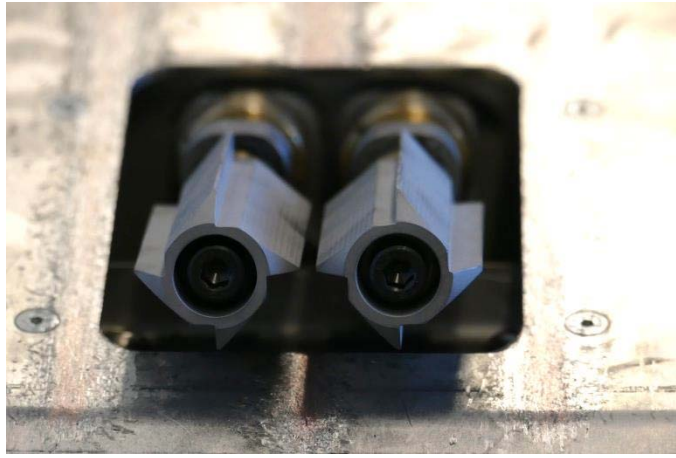
Place the tool on its back with the cutters up



Place the wrenches as shown and remove the right cutter cap screw with counter clock-wise rotation. Remove the right cutter.



Place adjustable wrench on flats of right shaft and remove left cutter with ccw rotation



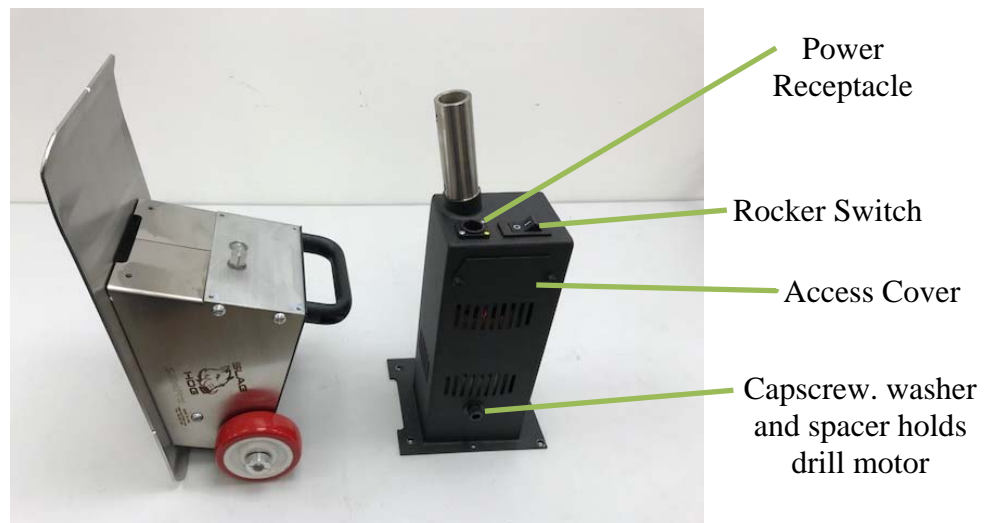
Slide the new right hand and left hand cutters so that the flats between the shaft are facing the base plate as shown. The cutters rotate so that the slag chips are pulled up toward the base plate. The cutters must be installed as shown.

Tighten new cutters with new capscrews and washers using the male hex socket wrench and L hex wrench approach.

5.2 Motor Brushes

If the motor doesn't rotate under power without load it is likely that the brushes need replacement. The following instructions show replacement of the **66125 Carbon Brush Kit**.

- Remove two 10mm bolts from handle
- Remove six 5mm hex bolts that attach motor enclosure to cutter mechanism

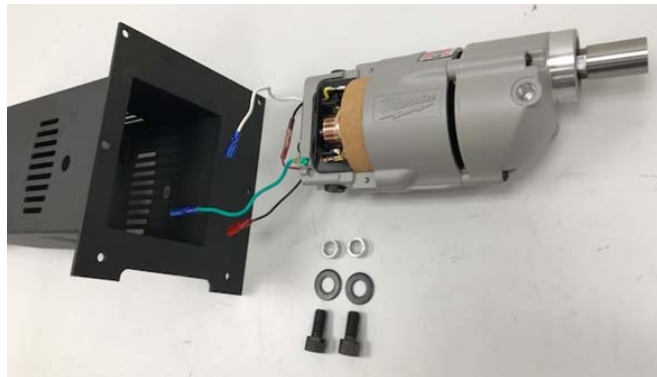


Cutter Mechanism Left and Motor Enclosure shown Right

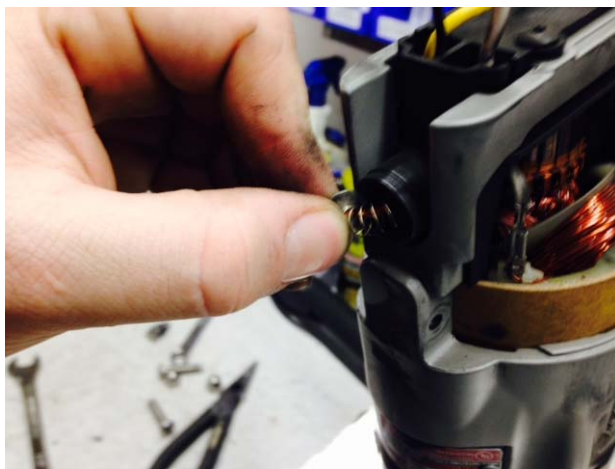
- Remove access cover
- Disconnect black wire from Rocker Switch, and green and white wire from Power Receptacle. Refer to Section A-A of the following assembly drawing for wire connections if necessary.
- Use needle nose pliers to pull on terminal ends. Do not pull on wire.



Remove two each of capscrew, washer and spacer that hold drill motor in enclosure. Remove motor from enclosure.



Unscrew plastic cap for the brush. Remove old brush and replace with new brush. Thread in cap and repeat for other side.



Apply light Loctite 242 to fastener threads. Reinstall drill motor in enclosure, reconnect three terminals, replace cover plate and mount motor enclosure on cutter mechanism. Replace handle and put back in service.

5.3 Other maintenance

All other repairs require qualified personnel to perform. In this case the factory or distributor should be contacted for further instructions.



SLAGHOG WARRANTY

Subject to the exclusions described below, all Slaghog products ("Products") as manufactured by Slatpro LLC are warranted to be free from defects in materials and workmanship under normal use and service for 12 months after the ship date to the purchaser. Unless otherwise set forth in a quotation or agreed to by Slatpro in writing, Product warranty only applies to the first using purchaser. Warranty is not transferable beyond the first using purchaser and is limited to new Products sold by Slatpro or through authorized representatives and channel partners.

EXCLUSIVE REMEDY. In the event that Slatpro determines that a Product contains a defect in materials or workmanship, then Slatpro, in its sole discretion, will (a) repair the Product, (b) replace the Product with new or rebuilt (c) refund the purchase price of the Product. THIS LIMITED WARRANTY IS EXCLUSIVE AND IS IN LIEU OF ALL OTHER EXPRESS AND IMPLIED WARRANTIES, INCLUDING BUT NOT LIMITED TO THE IMPLIED WARRANTIES OF MERCHANTABILITY AND FITNESS FOR A PARTICULAR PURPOSE. THE REMEDY OF REPAIR, REPLACEMENT OR REFUND IS BUYER'S SOLE AND EXCLUSIVE REMEDY UNDER THIS WARRANTY. IN NO EVENT SHALL SLATPRO'S LIABILITY UNDER THIS WARRANTY EXCEED THE PURCHASE PRICE OF THE PRODUCT GIVING RISE TO THE WARRANTY CLAIM. All Products which are repaired or replaced shall be warranted only for the unexpired portion of the original warranty period.

EXCLUSIONS. This warranty does not cover (a) any failures which are not attributable to defects in materials or workmanship, including without limitation, failures caused by accidents, inadequate maintenance, misuse, unauthorized modifications or repairs, improper storage, and normal wear and tear, (b) any consumable parts or accessories, such as cutter blades, are designed to wear over time or through use of the product, (c) Excessive use which is contributed from overuse, recommended use is for 1 cleaner to service 1-3 machines under normal use conditions. Recommended cleaning interval of once per week if production levels equal 2 shifts.

WARRANTY RETURNS. No Products shall be returned without prior authorization from Slatpro. Buyer shall prepay all shipping charges for the return of Products to Slatpro designated service location.

LIMITATION OF LIABILITY. IN NO EVENT SHALL SLATPRO BE LIABLE FOR ANY INCIDENTAL DAMAGES, CONSEQUENTIAL DAMAGES, SPECIAL DAMAGES, INDIRECT DAMAGES, LOSS OF PROFITS, LOSS OF REVENUES, OR LOSS OF USE, EVEN IF INFORMED OF THE POSSIBILITY OF SUCH DAMAGES. SLAPRO'S LIABILITY FOR DAMAGES ARISING OUT OF OR RELATED TO ANY ORDER IS LIMITED TO THE ORDER PRICE FOR THE SPECIFIC PRODUCT THAT GIVES RISE TO THE CLAIM. TO THE EXTENT PERMITTED BY APPLICABLE LAW, THESE LIMITATIONS AND EXCLUSIONS SHALL APPLY REGARDLESS OF WHETHER LIABILITY ARISES FROM BREACH OF CONTRACT, WARRANTY, TORT (INCLUDING BUT NOT LIMITED TO NEGLIGENCE), BY OPERATION OR LAW, OR OTHERWISE.

Effective Date: January 1, 2017



Slag Hog Assy

1" Cutters SH2

P/N: 67087

Item	Qty	Part No.	Description	sheet 1 of 2
The following items are for the drive portion of the assembly				
1	1	67055	Drive Shaft	
2	2	66143	Cutter Shaft	
3	2	66135	Idler Shaft	
4	1	67077	Driven Idler Shaft	
5	2	66140	Gear Support Plate Cutter Side	
6	2	66141	Gear Support Plate Motor Side	
7	2	66139	Cutter Support Plate	
8	1	66042	Pivot End Plate Cutter Side	
9	1	67052	Pivot End Plate Motor Side	
10	1	66044-RH	Top Gear Support RH	
11	1	66044-LH	Top Gear Support LH	
12	2	66025	Spring Guide Male	
13	2	66051	Spring Guide Female	
14	4	67058	Input Shaft Spacer	
15	1	66039	Chip Deflector	
16	4	66081	Idler Shaft Washer	
17	2	66137	Shaft Washer (.5 ID)	
18	2	66138	Shaft Washer (.38 ID)	
19	4	66054	Pivot Washer	
20	1	66142	Gear Box	
21	2	NI	Clamp Collar 9520T8	
22	2	66136	Spacer, Cutter	
23	2	66048	Spur Gear 14T	
24	2	66049	Spur Gear 16T	
25	2	66144	Spur Gear 11T	
26	10	66115	Needle Bearing .62 ID	
27	4	67005	Needle Bearing .5 ID	
28	2	67006	Needle Bearing .38 ID	
29	4	67007	Needle Bearing .62 ID Closed End	
30	2	66126	Die Spring	
31	6	NI	Thrust Washer .62ID 5906K516	
32	4	NI	Needle Brg Thrust Washer .38 ID 5909K251	
33	2	NI	Needle Bearing .38 ID 5909K25	
34	4	NI	Machine Key 98870A140	
35	2	NI	Dowel Pin, Pull-out 97175A390	
37	2		Clamp Collar 8mm ID 3369K14	
38	1	66145 SET	Cutter Set	



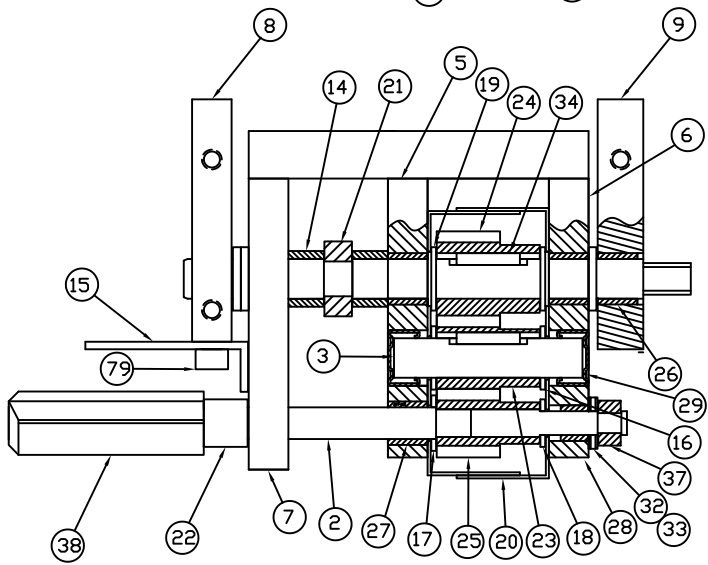
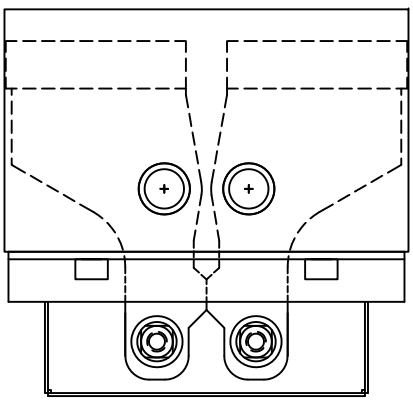
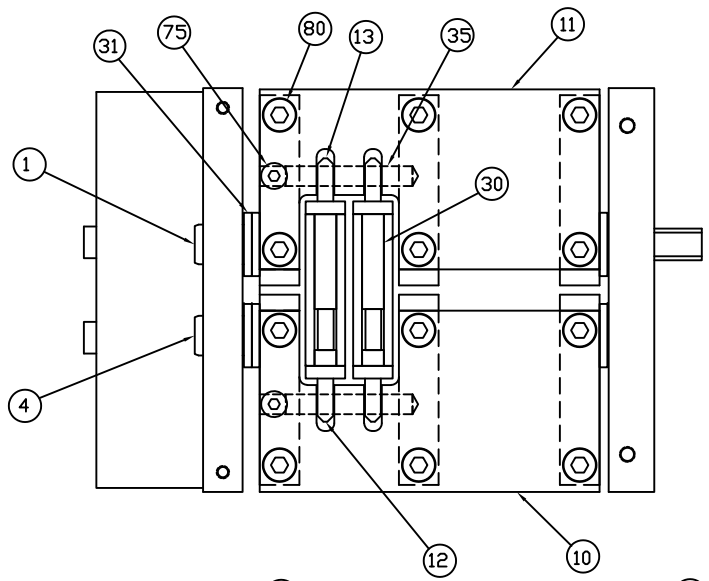
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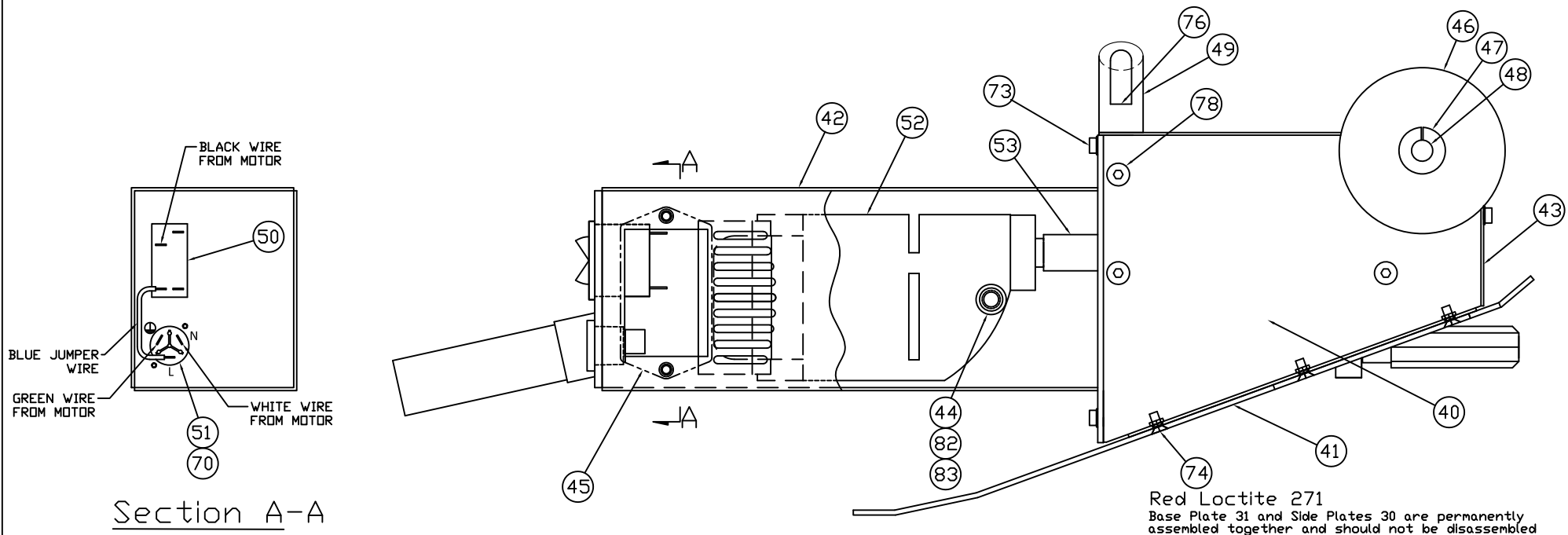
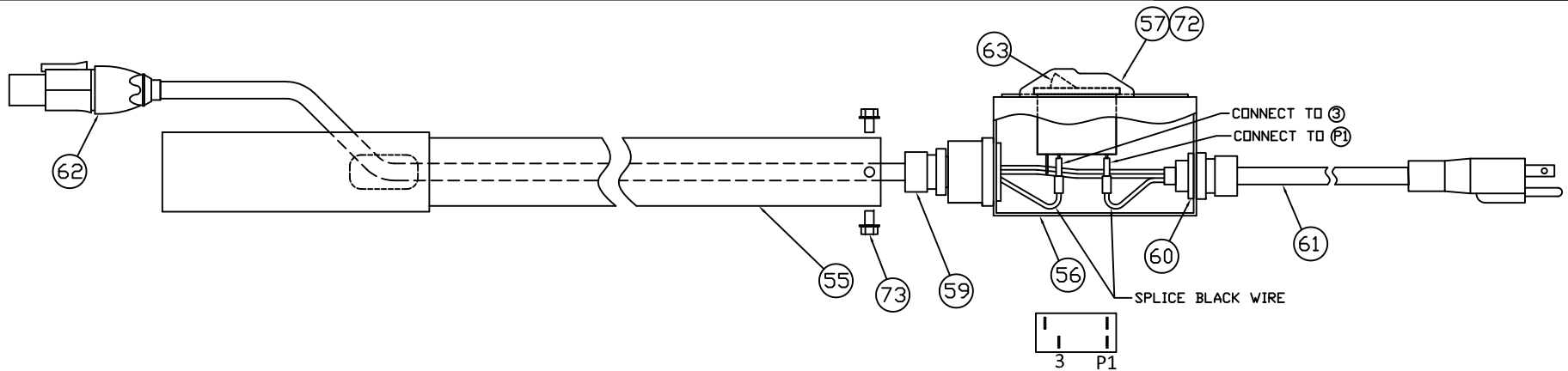
Item	Qty	Part No.	Description	sheet 2 of 2
The following items are for the housing portion of the assembly				
40	1	66030-RH&LH	Side Plate Set	
41	1	66035	Base Plate	
42	1	67062	Motor Enclosure	
43	1	66037	Top Cover	
44	2	67061	Spacer Drill Mount	
45	1	66062	Wire Access Cover	
46	2	66117	Wheel	
47	2	NI	Clamp Collar 6157K14	
48	1	NI	Shaft .5 dia x 10.25 1255T17	
49	1	66116	Handle	
50	1	67063	On/Off Switch 15A	
51	1	67065	Receptacle	
52	1	66122	Motor	
53	1	67056	Square Drive	
The following items are for the handle portion of the assembly				
55	1	66060	Handle Tube	
56	1	67059	Handle End Box	
57	1	67060	Cover, Handle End	
59	2	NI	Cord Grip 7529K2	
60	1	NI	3/8 Fixture Nut	
61	1	66121	Cord	
62	1	67066	Plug End	
63	1	67064	On/Off Breaker Switch 7.5A	
The following items are for the fasteners				
70	2	NI	Pan Hd Phillips Mach Scr M3x8 90116A153	
72	2	NI	Button Hd SCS M5x8 SST 94500A230	
73	16	NI	Vib Resist Hex Hd Flange CS M5x12 92820A215	
74	6	NI	Flat Head SCS M5x12 91263A833	
75	2	NI	Button Hd SCS M6x16 91306A672	
76	2	NI	Socket Head Cap Screw M6x25 90128A265	
78	8	NI	Button-Head SCS M8x16 91306A677	
79	14	NI	SHCS M8x25 90128A275	
80	2	NI	Button Hd SCS M10x55 SST 92095A426	
81	2	NI	Acorn Nut SST M10x1.5 SST	
82	2	NI	SHCS 7/16-14 x .88 91251A668	
83	2	NI	Washer 7/16 96765A21	

NI means non-inventory item



Drive Assembly
 Unless noted Blue Loctite 242 on all fasteners

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Section A-A

Drive Installed in Housing Assembly

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