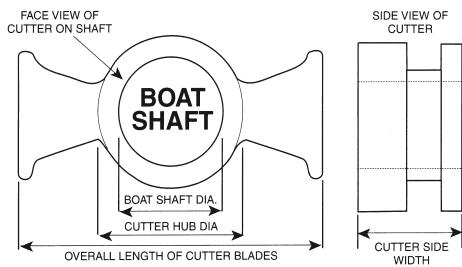


## SIZING CHART • CUTTER DIMENSIONS • DECIMALS/METRIC

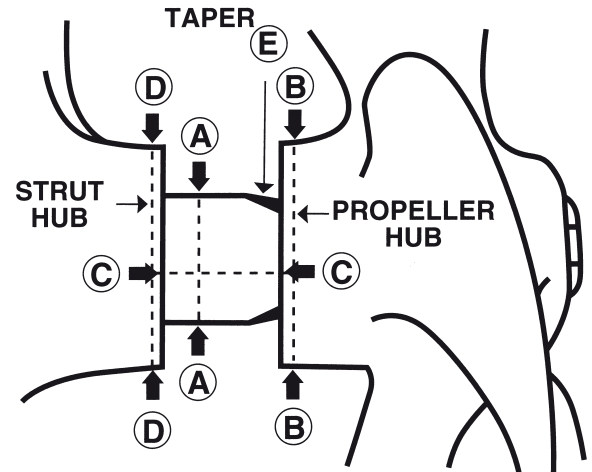
MODEL TYPE	SHAFT DIAMETER	CUTTER HUB DIA.	CUTTER OVERALL LENGTH	CUTTER WIDTH	MIN. SPACE TO INSTALL
A	3/4", 7/8", 1", 1-1/8", 1-1/4" 20, 25, 30 mm	2" 51 mm	4" 102 mm	15/16" (.938") 24 mm	1-1/8" 30 mm
B	1", 1-1/8", 1-1/4", 1-3/8", 1-1/2" 20, 25, 30, 35, 40 mm	2-5/8" (2.625) 67 mm	5" 123 mm	1-1/16" 27 mm	1-1/4" 32 mm
C	1-1/2", 1-5/8", 1-3/4", 1-7/8", 2" 40, 45, 50 mm	3-3/8" (3.375) 86 mm	6" 152 mm	1-3/8" 35 mm	1-9/16" 39 mm
D	1-1/2", 1-3/4", 2", 2-1/4", 2-1/2" 40, 45, 50, 55 mm	3-7/8" 98 mm	6-3/4" 171 mm	1-7/16" (1.437") 36 mm	1-5/8" 41 mm
E	2", 2-1/4", 2-1/2", 2-3/4", 3" 50, 55, 60, 65, 70, 75 mm	4-3/8" 110 mm	7-5/8" 194 mm	1-1/2" 37 mm	1-11/16" (1.687") 43 mm
F	2-1/4", 2-1/2", 2-3/4", 3", 3-1/2" 60 to 90 mm	5-1/2" 140 mm	10" 254 mm	1-9/16" (1.562") 40 mm	1-3/4" 45 mm
F1	3", 3-1/2", 4", 4-1/2" 75 to 115 mm	6-1/2" 165 mm	11" 280 mm	1-3/4" 40 mm	2-0" 50 mm
F2	3", 3-1/2", 4", 4-1/2", 5", 5-1/2" 75 to 140 mm	7-7/8" 200 mm	13-1/2" 343 mm	1-11/16" (1.687") 43 mm	2.0" 50 mm
F3	4", 4-1/2", 5", 5-1/2", 6", 6-1/2" 115 to 175 mm	9-1/2" 241 mm	15-3/4" 400 mm	1-7/8" (1.875") 48 mm	2-1/8" 54 mm

\* CUSTOM SIZES AVAILABLE UPON REQUEST.

### CUTTER SIZING DIAGRAM



## MEASUREMENTS NEEDED FOR ORDERING AND INSTALLATION:



(MEASURE WITH CALIPER OR MICROMETER).

- A** Shaft Diameter \_\_\_\_\_
- B** Propeller Hub Diameter \_\_\_\_\_
- C** Space between Prop & Stern Bearing (Port) \_\_\_\_\_  
(Stb.) \_\_\_\_\_
- D** Stern tube or strut hub diameter \_\_\_\_\_
- E** Length of Exposed Taper (Port) \_\_\_\_\_  
Forward of Prop Face (Stb.) \_\_\_\_\_  
(MEASURE LENGTH OF EXPOSED TAPER FROM PROP FACE).

## INSTALLATION PROCEDURE

### STEP 1

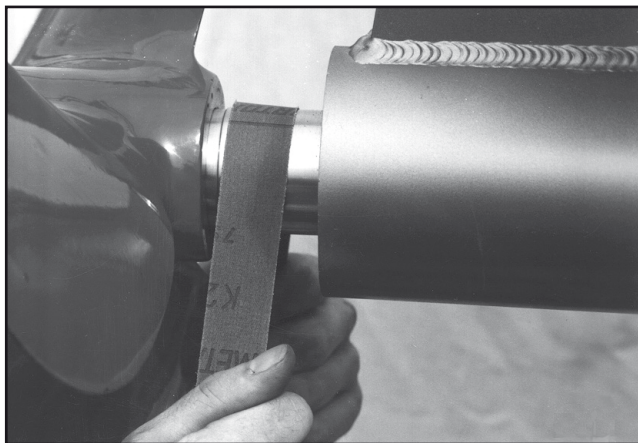


PHOTO #1

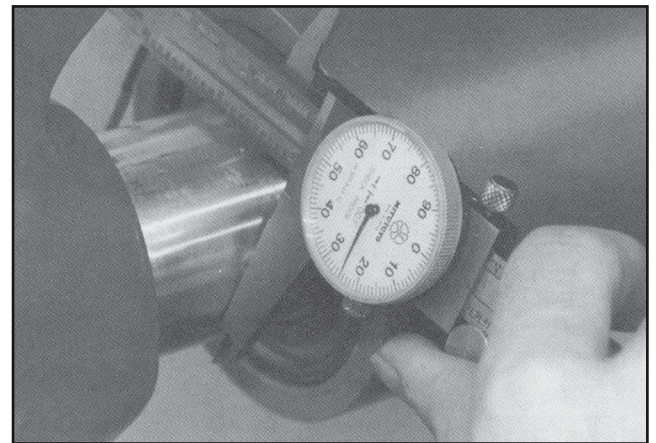


PHOTO #2

- A. Scrape and clean shaft thoroughly (use emery tape). (PHOTO #1).
- B. Use a dial caliper to determine where taper (if any) ends from propeller hub. (Cutter cannot be mounted over taper.) **MUST BE CLAMPED ON STRAIGHT SHAFT.** (PHOTO #2) For acceptable installation refer to Diagrams A, B & C on page 3.
- C. Also check shaft size. Shaft should measure .002 over nominal (PHOTO #2).
- D. In preparation for installation - disassemble cutter: (1) Loosen stationary blade screws only 1/2 way out (screws #4 on page 10). (2) Remove screws on rotating cutters.

# STEP 2

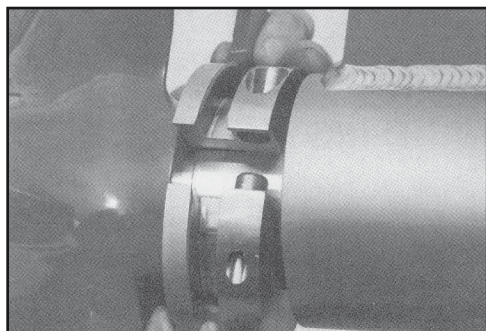


PHOTO #3

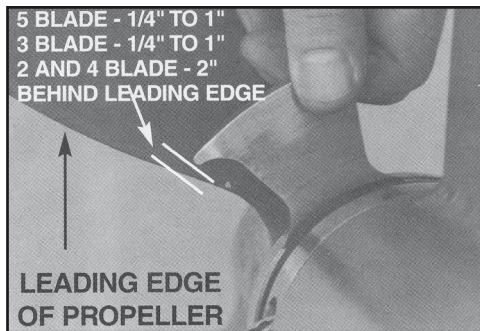


PHOTO #4

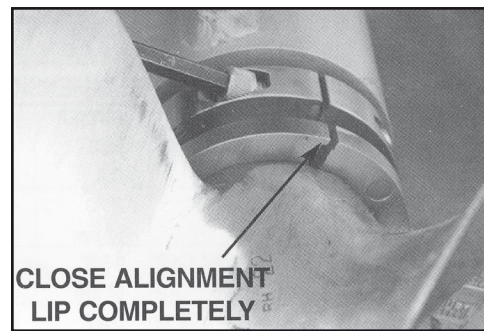


PHOTO #5

- A. Place the two shaft-mounted Rotary Cutter castings **AS CLOSE TO THE PROPELLER** as possible (cutter blade next to propeller hub) **considering exposed shaft taper**. (Photo #3). (**CANNOT CLAMP ON TAPER!!**)
- B. **3 AND 5 BLADE PROPELLER:** Position one cutter blade 1/4"-1" behind the leading edge of propeller blade; the other cutter blade will automatically be in position (Photo #4). **2 AND 4 BLADE PROPELLERS:** Position cutter blade approximately 2" behind leading edge (Photo #4).
- C. **FIRST**, tighten screw on lip side (closing alignment lip completely!) (Photo #5). This automatically aligns groove perpendicular to bore.
- D. **SECOND**, tighten opposite screw (without alignment lip). This clamps rotary cutter to shaft.

**NOTE: Only one side of Rotary Cutter has an alignment lip.** When tightened, this automatically aligns the stationary cutter groove perpendicular to the shaft bore, allowing the stationary cutter assembly to spin freely in groove without binding. (**Rotary cutter castings are paired (DO NOT INTERCHANGE) must remain as a set.**)

# STEP 3

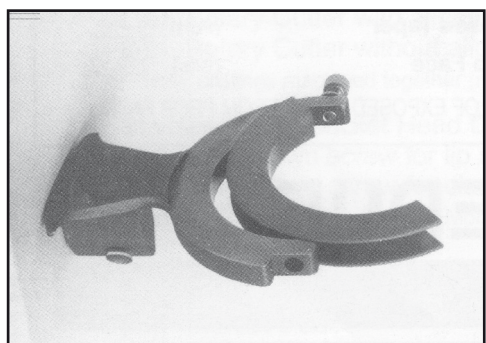


PHOTO #6

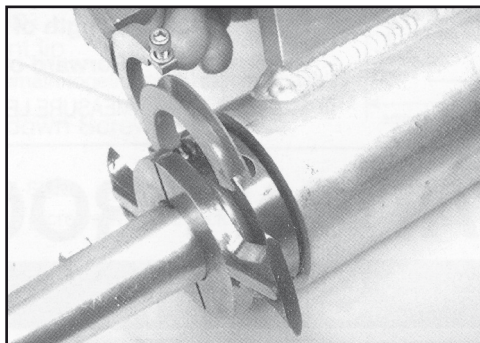


PHOTO #7

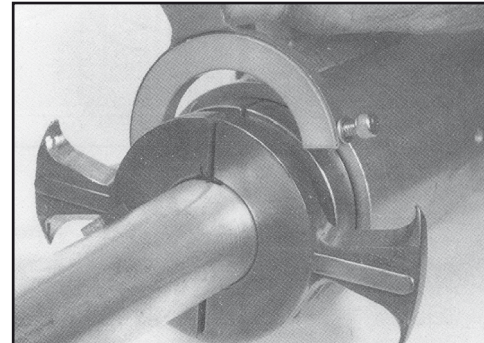


PHOTO #8

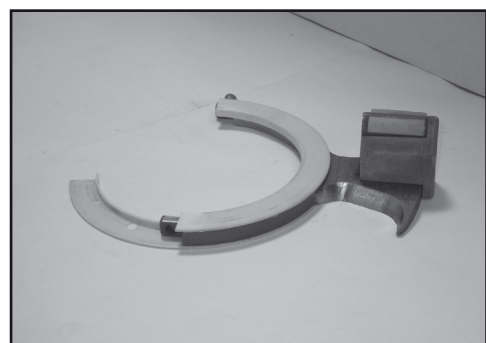


PHOTO #9 - F1, F2, F3 ONLY.

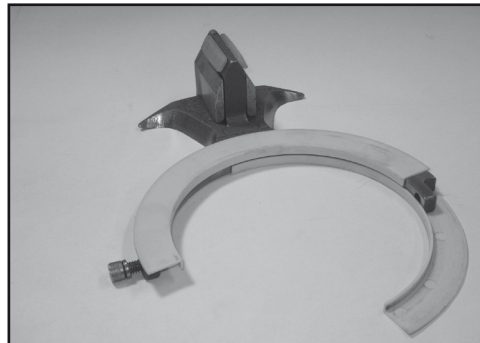


PHOTO #10 - F1, F2, F3 ONLY.



PHOTO #11

- A. 1) **Mold size cutters A, B, C, D, E, F**, insert stationary cutter into U shape bearings. (Photos #6, #7 and #8).  
2) Insert stationary cutter with bearing into groove of mounted rotating cutters.
- A1. 1) **Mold size cutters F1, F2, F3**, insert each L-shaped bearing into cutter groove. (Photos #9 and #10).  
2) Insert stationary cutter (with 4 side bearings in place) into cutter groove. (No longer a bottom bearing with new L-shape bearing design.)
- B. Tighten socket head cap screw with spacer/lock washer in place (Photo #11). Spacer/lock washer is **necessary** to keep screw from hitting bottom of bearing.

# STEP 4

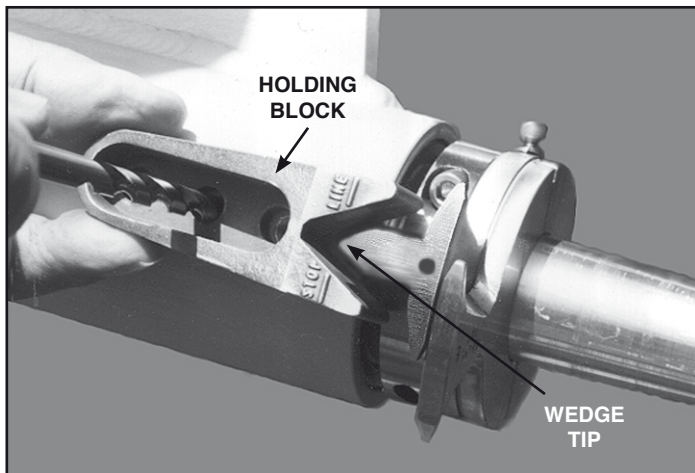


PHOTO #12

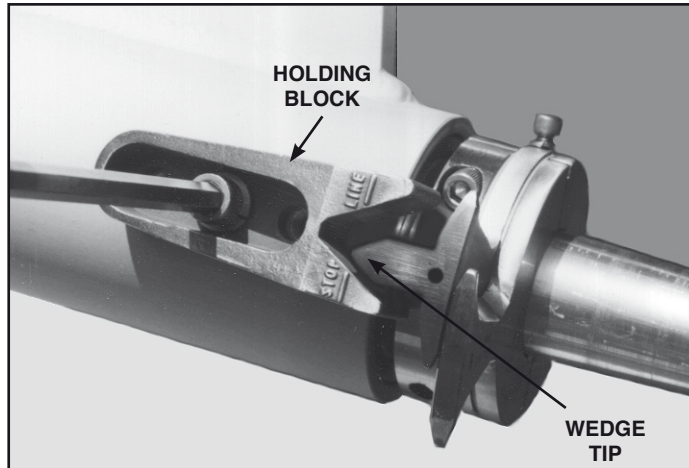
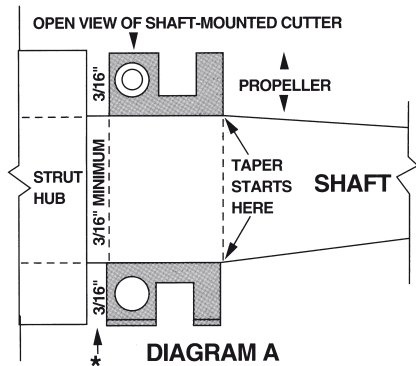


PHOTO #13

**NOTE:** Mount holding block on portside of strut with left-hand propeller and on starboard side of strut with right-hand propeller.

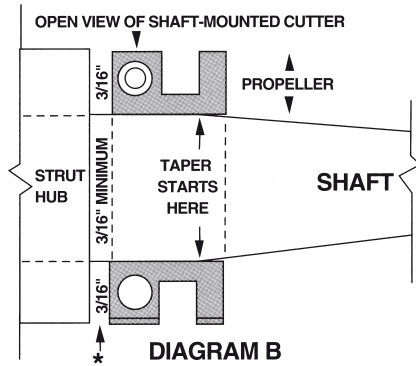
- A) Move holding block into position until wedge tip of stationary cutter is 1/2 way into V of holding block. (**Stop lines are marked on holding block**). This positioning is necessary to take up **forward and aft** shaft **end play** allowing stationary cutter to move forward and aft. (Shafts move slightly forward when vessel goes forward and slightly aft when in reverse). We refer to this as end play. (**Refer to pages 8 and 9 to confirm proper holding block size.**)
- B) **Drill and tap center hole first!** (Photos #12 and #13). Mount holding block with **one screw**. Then drill and tap other 2 holes with holding block in place.
- C) **Holding block #4, #5, #5A**  
**FIRST** - Drill and tap upper hole. **SECOND** - Drill and tap lower hole. **THIRD** - Drill and tap forward hole.

## CONSIDERATIONS WHEN SHAFT TAPER EXTENDS INTO CUTTER MOUNTING AREA



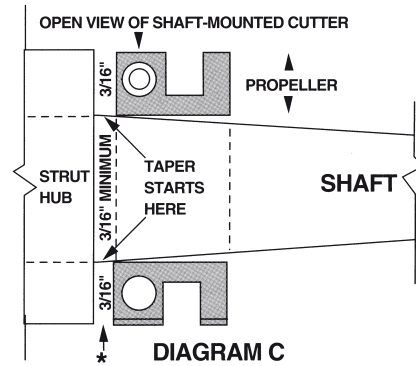
**IDEAL INSTALLATION POSITION**

Diagram "A" shows a straight shaft under an area where cutter is to be mounted. This will assure full clamping of cutter onto shaft.



**ACCEPTABLE INSTALLATION POSITION**

Diagram "B" shows part of the shaft taper under the cutter. As you can see, this allows approx. 3/4 of cutter width clamped on straight shaft; however, it gives adequate holding power for cutter.



**IMPOSSIBLE INSTALLATION \*\***

Diagram "C" - Do not attempt this installation. Cutter cannot clamp on a full taper. The cutter follows the taper and causes loosening and spinning on the shaft.

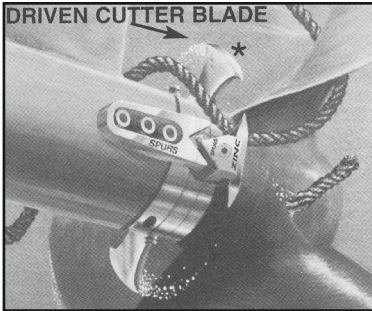
**It is impossible to clamp a cylinder onto a cone and expect it to hold.**

**\*\*NOTE: WHEN A FULL TAPER IS IN THE SPACE WHERE THE CUTTER IS TO BE INSTALLED, THERE ARE OTHER OPTIONS: (1) CUT A RING FROM STRUT BOSS OR (2) INSTALL A "SPURS" SPACER BETWEEN TRANSMISSION AND SHAFT FLANGES. (REFER TO SPECIAL CONDITIONS ON PAGE 5).**

**\* ALLOW MINIMUM OF 3/16" BETWEEN STRUT AND LINE CUTTER FOR END PLAY AND WATER FLOW. (WHEN THERE IS EXCESSIVE END PLAY OR LOOSE MOTOR MOUNTS, ALLOW MORE SPACE ACCORDINGLY.)**

**"F" SERIES CUTTERS - When possible mount block on top of strut.**

# POSITIONING DIAGRAMS OF SPURS CUTTER BLADE IN RELATION TO PROPELLER BLADES



**CUTTER OPERATION**  
The leading edge of the propeller blade draws the line into the cutting blades making positioning of driven cutter blade (\*) important.

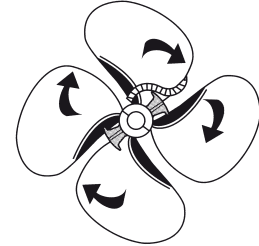
## DIRECTIONS:

- 1) Looking aft, position edge of cutter blade slightly behind leading edge of propeller.
- 2) Cutter will cut in any position; however, it becomes more efficient when positioned correctly.
- 3) Positioned correctly, cutter will also be more efficient when reverse cut is made.



Arrows on propeller blades below point to leading edge of propeller. **VIEWED LOOKING AFT.**

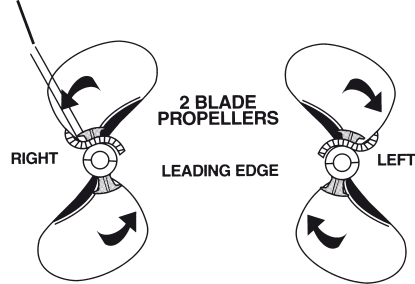
## EXAMPLE OF WRONG CUTTER BLADE LOCATION



**WRONG**

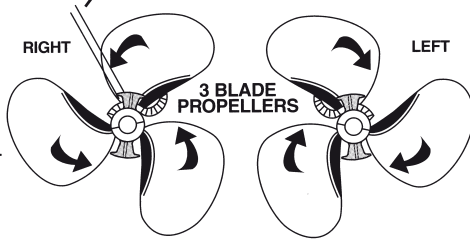
When the cutter blade is forward of propeller blade, the line will lay on top of cutter blade during this revolution of propeller. It will not be cut until next revolution

Position 2"+ behind leading edge



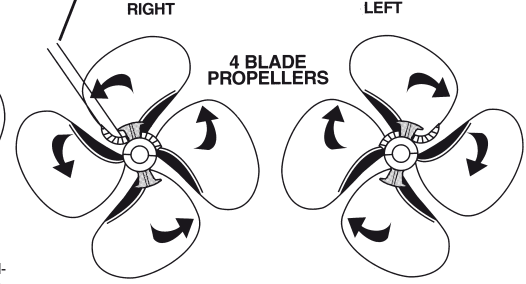
Position cutters as shown.

Position 1/4"-1/2" behind leading edge



Position (1) cutter blade approximately 1/4" to 1/2" behind leading edge of propeller blade; the other cutter blade then falls approximately midway between other (2) propeller blades.

Position 2" behind leading edge



Position cutter blades midway between propeller blades.

## 5 BLADE PROPELLERS:

Position (1) cutter blade 1/4" to 1" behind the leading edge of propeller blade; the second cutter blade will fall on the leading edge; however, cutting will not be affected.

## DRILL AND TAP SIZING CHART

Table of drill and tap selections necessary to drill and tap holes for mounting holding block to strut or stern tube.

SCREW SIZE	TAP DRILL SIZE	TAP SIZE
8 x 1.25	6.5	8 x 1.25
10 x 1.5	8.5	10 x 1.5

STEP 1: Use regular starter tap.

STEP 2: For shallow holes, use a bottoming tap to complete threads to bottom of drill hole.

## ELECTROLYSIS PREVENTION AND SOUND DEADENING FOR STATIONARY CUTTER ASSEMBLY.

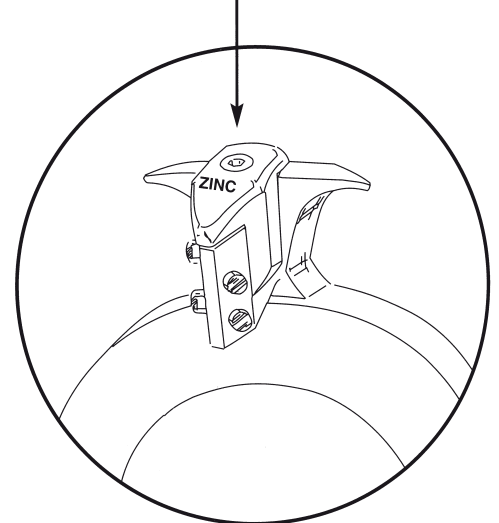
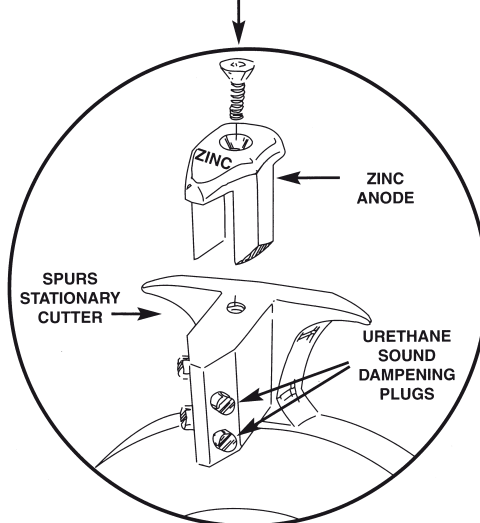
*To prevent electrolysis, a zinc has been installed on the stationary cutter assembly and must be replaced as necessary.*

**(Stationary cutter is isolated)**  
**THE DRIVEN CUTTER PORTION OF THE CUTTER ASSEMBLY IS CLAMPED TO THE SHAFT AND GETS ITS ELECTROLYSIS PROTECTION FROM SHAFT ZINC OR PROP NUT ZINC.**

## ZINC ANODE INSTALLATION

10 X 32 X 5/8 FLAT HEAD SOCKET SCREW

CAP ZINC ANODE IN PLACE



**REINSTALL:** Lower zinc anode over stationary cutter blade and screw down tightly. Use hammer; tap to set zinc, then re-tighten screw.

# INSTALLATION FOR SPECIAL CONDITIONS

PHOTO #14

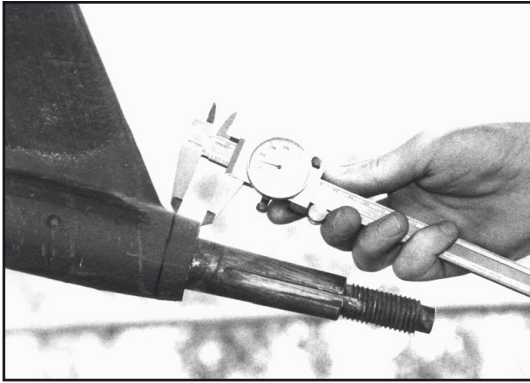


PHOTO #15

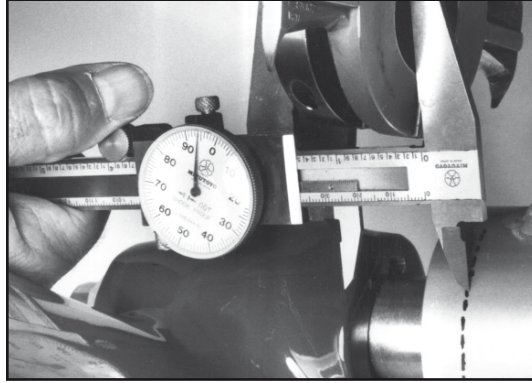


PHOTO #16

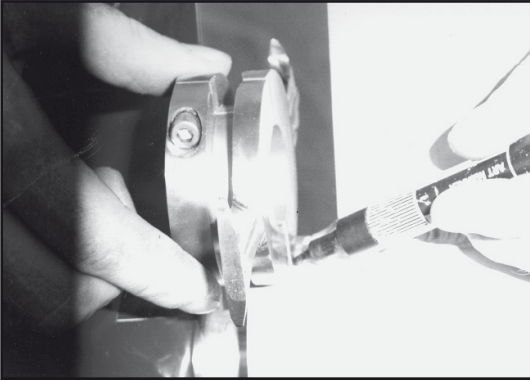
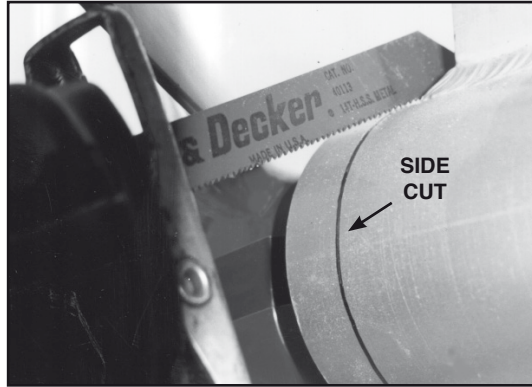


PHOTO #17



## CONDITION 1

### **When space between propeller and strut is too narrow to mount cutter:**

**OPTION 1:** Removal of a ring from strut boss the width necessary to allow enough space for mounting cutter, including any end play. Procedure is as follows:

- a) Scribe a ring around strut allowing space for cutter and end play (Photos #14, #15 and #16).
- b) Cut strut through bearings stopping at rubber; using a knife, cut through rubber and remove ring. Make a side cut before a complete cut when propeller is not removed (Photo #17).
- c) Remove ring and follow installation instructions.

**OPTION 2:** Install SPURS® Spacer between transmission and shaft flange. A 1" spacer will lengthen shaft allowing an additional 1" for cutter to be installed. (Photo #18).

**SPURS® Spacers are available through Spurs Marine:**

**Contact us for sizing. We will need the Make and Model # of your transmission.**

**SPURS® Spacers are solid steel, machined parallel within .001 and are electroless nickel plated.**

PHOTO #18

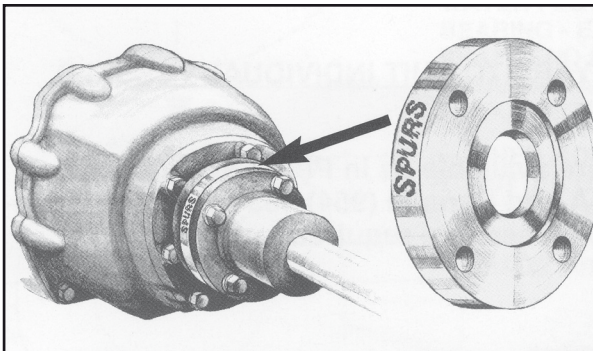
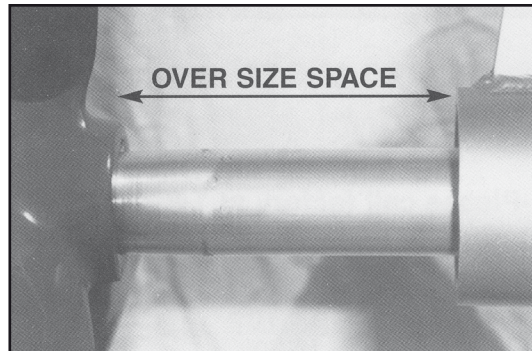


PHOTO #19



## CONDITION 2

### **Too much space between propeller and strut or stern tube:**

(Photo #19). Contact manufacturer for special instructions. When a vessel with an unusual arrangement is encountered, send drawings for factory installation assistance. A zinc collar between propeller and cutter will act as a filler.

# INSTALLATION REQUIREMENTS FOR FIBERGLAS STRUT!

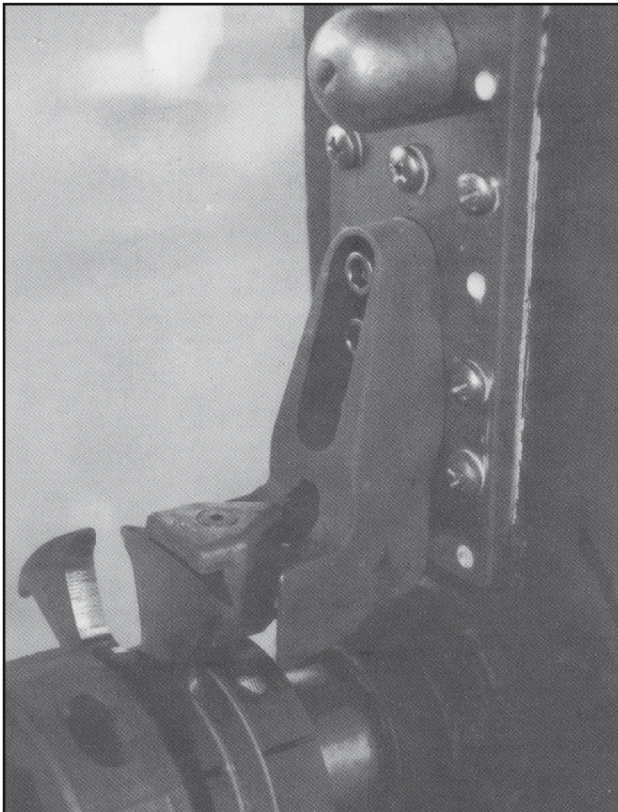
Fiberglas will not support screws drilled and tapped into it. The shearing force of a line cut is too great; therefore, the screws that hold the holding block will pull out.

We recommend when installing the holding block onto fiberglas that a metal plate, approximately 1/4" thick, be embedded into the fiberglas. The plate can be stainless steel or aluminum.

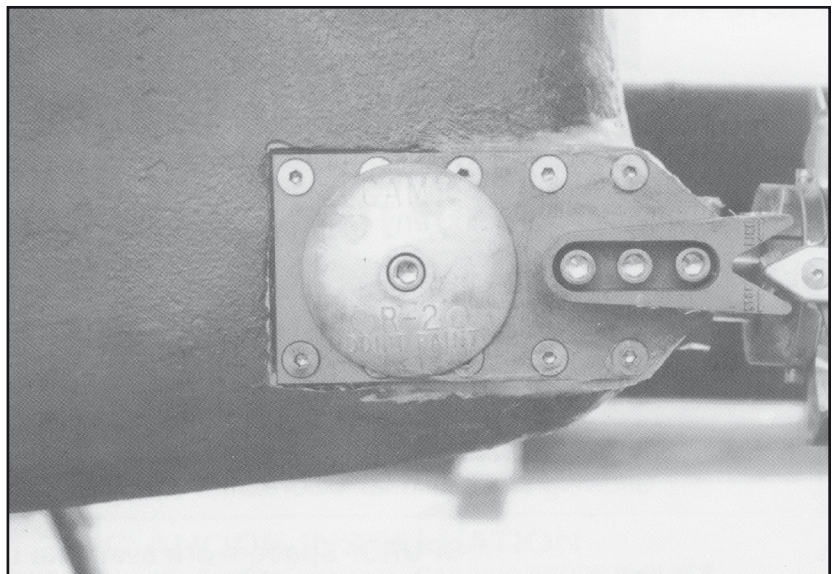
- 1) The installation is achieved by first measuring to determine the depth required, then routing away the glass to receive the plate. Using stainless steel flat head screws and epoxy, mount the plate into the routed area.
- 2) Drill and tap into the plate and mount the holding block.
- 3) Bond the plate and holding block by screwing a small zinc anode onto the plate.

**• PHOTOS BELOW ARE EXAMPLES OF A COMPLETED PLATE MOUNTED INTO FIBERGLAS.**

**PHOTO #1**



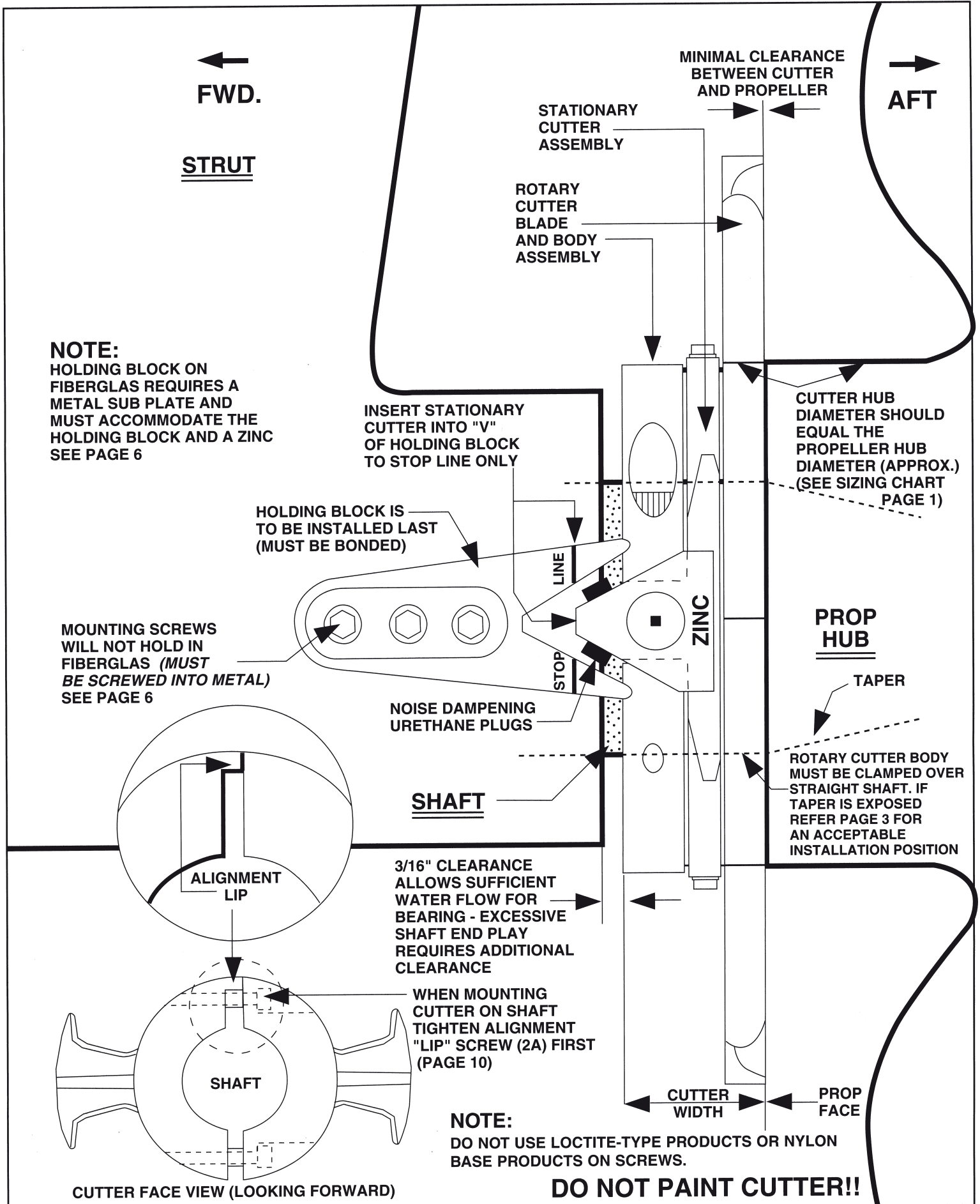
**PHOTO #2**



**PLATES ARE FABRICATED AT BOAT YARD TO SUIT INDIVIDUAL VESSELS**

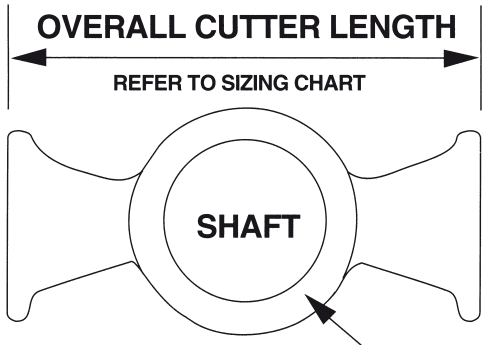
Custom fabricated holding blocks are available as in Photo #1 (above).

# COMPLETED INSTALLATION



# HOW TO SELECT THE WEDGE HOLDING BLOCK TO FIT YOUR CUTTER:

1. The Holding Block (mounted on strut or stern tube) relates to cutter mold type (selected from page 1).
2. Using the cutter mold type, refer to (Fig. 1) for overall cutter length.
3. Subtract the vessel's strut outside diameter from overall cutter length. Then  $\div 2 =$  Holding Block Height.

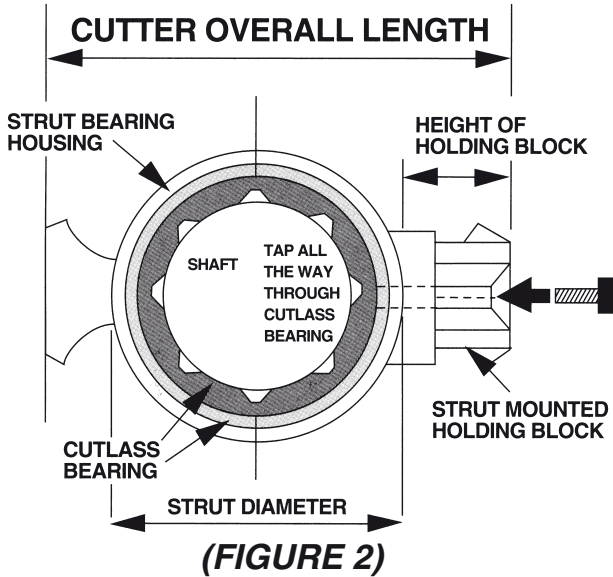


**(FIGURE 1)**

FACE VIEW OF CUTTER ON SHAFT

MOLD TYPE	OVERALL LENGTH	MOLD TYPE	OVERALL LENGTH
A	4"	F	10"
B	5"	F1	11"
C	6"	F2	13 1/2"
D	6 3/4"	F3	15 3/4"
E	7 5/8"		

4. Using height figure, select Holding Block from chart (Fig. 3).



**(FIGURE 2)**

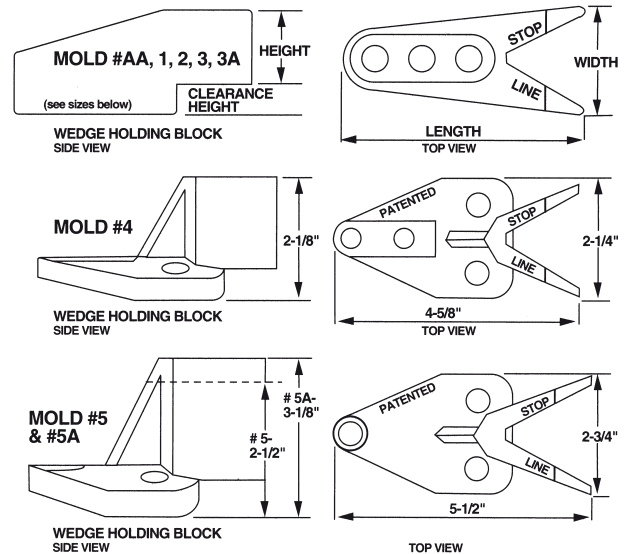
## 5. FORMULA TO DETERMINE HOLDING BLOCK: (as seen in Fig. 2)

Cutter overall length \_\_\_\_\_  
 Subtract strut diameter — \_\_\_\_\_  
 Divide by 2  $\div$  \_\_\_\_\_  
 Holding block height = \_\_\_\_\_

After the holding block height has been determined, it is an easy matter to choose the holding block mold type from chart (Fig. 3). Match the height needed to the closest height of holding block available. Use shims if needed!

WEDGE HOLDING BLOCK SIZES AVAILABLE				
MOLD TYPE	HEIGHT	CLEARANCE HEIGHT	WIDTH	LENGTH
#AA	.900"	1/8"	1 1/4"	3"
#1	1 1/8"	5/16"	1 3/8"	3 1/4"
#2	1 1/4"	1/2"	1 5/8"	3 1/2"
#3	1 1/2"	1/2"	1 3/4"	3 5/8"
#3A	2"	7/8"	1 3/4"	3 11/16"
#4	2 1/8"	9/16"	2 1/4"	4 5/8"
#5	2 1/2"	3/4"	2 3/4"	5 1/2"
#5A	3 1/8"	3/4"	2 3/4"	5 1/2"

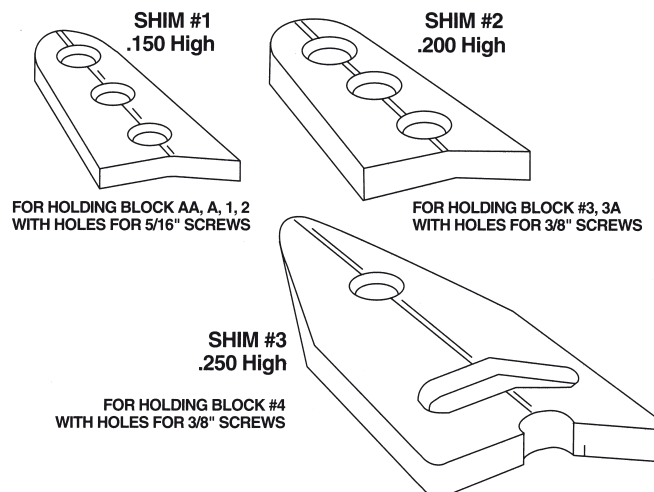
**(FIGURE 3)**



The above are actual diagrams of the wedge holding blocks that are available. In most cases, they are interchangeable with cutter of different mold types. They are selected for the best height match to secure the wedge portion of the stationary cutter.

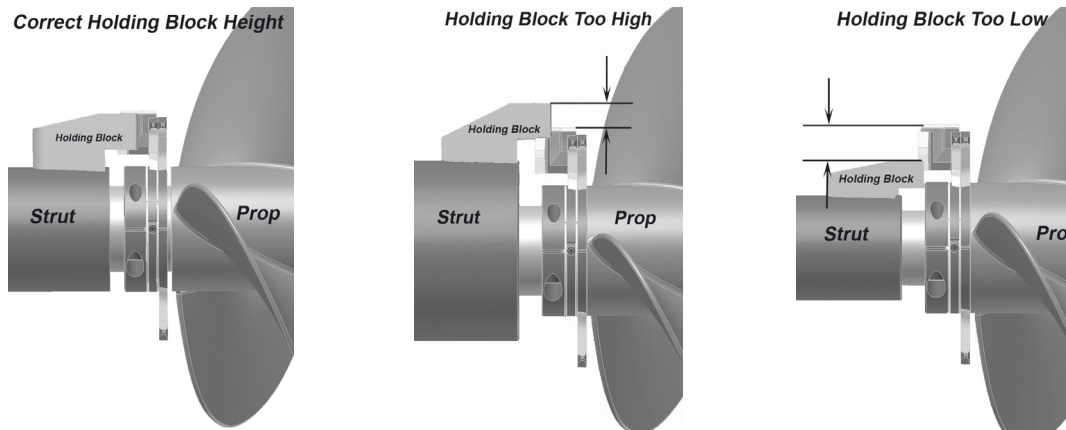
## SHIMS

Shims are available to raise the holding block to attain a height fit (when needed). Position shim under holding block then drill and tap into place.





# EXAMPLES OF HOLDING BLOCK INSTALLATIONS:

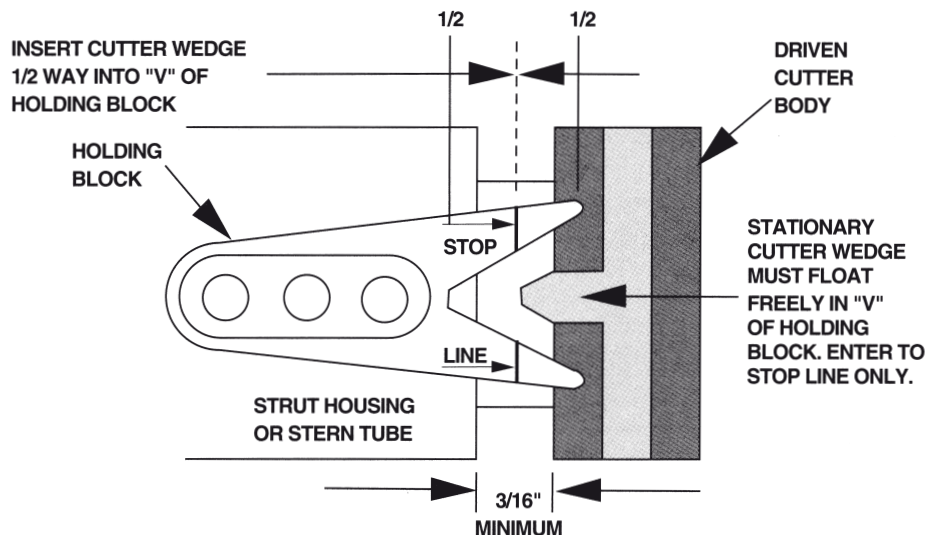


HEIGHT OF HOLDING BLOCK APPROXIMATELY EQUAL TO WEDGE HEIGHT OF STATIONARY CUTTER AFTER MOUNTED ON SHAFT.

## PURPOSE OF WEDGE HOLDING BLOCK

1. The wedge holding block, being firmly attached to the strut, provides the means for holding the corresponding wedge that makes up the forward part of the stationary cutter.
2. When a line is caught between the stationary cutting blade and the rotating cutting blade (attached to shaft), the wedge forces the two blades tightly together, overcoming the resistance of the bearing and instantly cuts the line. Normally the stationary and rotating blades never touch; they are held apart by the teflon bearing which purposely isolates the metals from wear.
3. At the instant of cut, the blades come closer together.

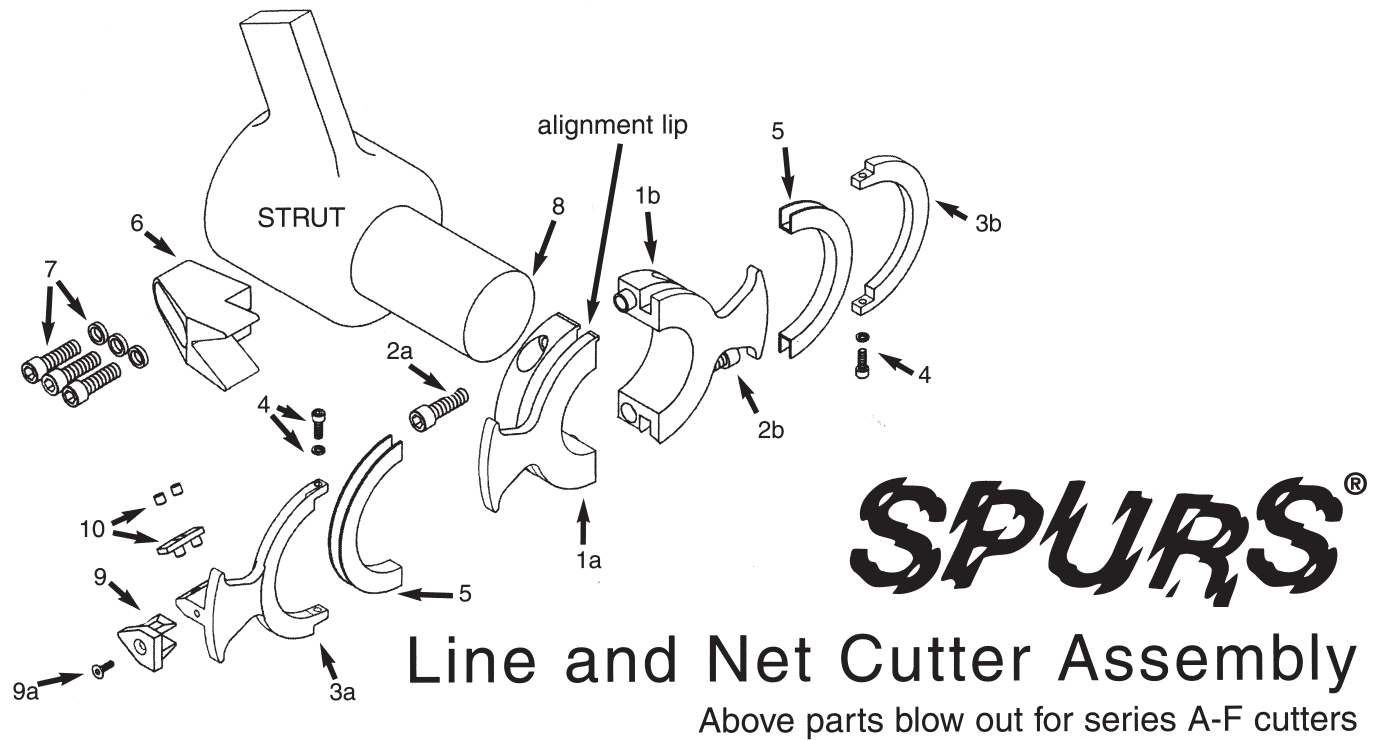
## MOUNTING THE WEDGE HOLDING BLOCK



1. The wedge holding block is mounted onto the stern bearing tube or strut and held by stainless steel screws (*provided with cutter*). Holes are to be drilled and tapped to receive these screws. Holding block is to be used as a template in place when all but first screw is drilled and tapped.
2. The wedge holding block is to be mounted on the same side of the strut as the rotation of the propeller.  
**EXAMPLE:** If there is a righthand prop, the holding block would be mounted on the starboard side of the strut; on a lefthand prop, it would be mounted on the portside of the strut.
3. Holding block must be positioned to accommodate the stationary cutter wedge, with the stationary cutter wedge entering only one-half way into the V of the holding block. This is important to assure enough clearance to move with shaft and avoid bottoming in holding block V. If the male wedge of the stationary cutter touches the bottom of the female wedge holding block during forward end play, this will force the cutter blades together grinding metal on metal, causing the blades to be destroyed through excessive friction.

**\* See more information regarding holding blocks on addendum sheet (included).**

# ENGINEERING MAKES THE DIFFERENCE



1. Shaft-Mounted Rotary Cutter  
(1a) Rotary Cutter with alignment lip  
(1b) Rotary Cutter without alignment lip  
note: castings machined together (must remain together/not interchangeable)
2. Stainless Steel Socket Head Draw down Screws  
(2a) Draw down screw for lip side  
(2b) Draw down screw for clamping side  
note: Model A-E (screws only) Model F-F3 (screws with 3/8 lock nuts)
3. Stationary Cutter Ring  
(3a) with blade  
(3b) without blade
4. Stationary Cutter Screw and Hi-collar Lock Washers
5. Long-life Anti-Friction Bearings (water lubricated)
6. Holding Wedge Block (9 sizes available) see page 8
7. Three (3) holding wedge mounting screws and high collar lock washers for holding block
8. Propeller Shaft (3/4" - 6-1/2" or 20mm-165mm)
9. Zinc Anode (stationary cutter is isolated and requires independent zinc)  
(9a) 10 x 32 x 5/8 ss flat head socket screw
10. Sound Dampening Plugs (pressed into stationary cutter blade wedge) model A thru D have separate plugs for each hole, model E thru F3 have one piece for each side pressed into stationary wedge

***DANGER! Sharp blades produce vise cutting action.***