

# SAFETY MAINTENANCE

## CHIPPER KNIFE BABBITTING

To maintain the desired chip size, it is important that you babbitt your knives after each grinding.

**IMPORTANT** - Never babbitt a knife that measures less than 2 1/2 inches in width.

To babbitt your knives, follow these steps:

1. Warm knives and all babbitting hardware with a torch until all moisture is eliminated from the surface of the parts.



**CAUTION: All parts must be moisture free or blowback may occur, causing personal injury.**

2. Place knives into the babbitting fixture and bring spacers up to the back of the knife.

3. Place the babbitting funnel over the cavity and slowly pour the babbitt from the ladle until the cavity is filled.

4. Let babbitt cool.

5. After babbitt is cool, remove the knife from the babbitting fixture.

6. Place the knife on a table and file off the excess babbitt until babbitt does not project beyond the sides of the knife.

