

IDENTIFICATION OF NO. 104 CUTTERS

THE BLADE POINT WIDTH AND CUTTER DESIGNATION OF NO. 104 CUTTERS MAY BE DETERMINED FROM THE CUTTER NUMBER WHICH IS MARKED ON THE CUTTERS.

A representative number for .550" whole depth cutter would be: G104E-60T-C. G104E refers to the No. 104 Generator. 60 is equal to Blade pint width x 1000. Thus, 60 denotes a blade point width of .060" T indicates a .550" whole depth cutter.

C is the cutter designation which may be A, B, C, D, or E. This is a letter system for designation the pressure angle of the blades. Blade pressure angles are selected to produce a desired length of tooth bearing. The utter number of the .750" whole depth cutters carries the letter U instead of T as follows: G104-130U-B. As explained above, this number refers to a No. 104 cutter with a blade point width of 130" and a "B" cutter designator. These cutters are

manufactured so that each cutter of a pair is of the same diameter. Each member of a pair is marked with the same series number to identify the pair.

For example, a pair marked RRM-37, would identify the cutters as the 37th pair of 24 bladed cutters. A pair marked serial RRL-14 would identify the cutters as the 14th pair of 16 bladed cutters. Cutters of the same serial number must be kept together and their diamters maintained alike through the life of the cutters.

Other markings on the cutter indicate whether it is upper left hand or lower right hand Upper L.H. meaning that it is a left-hand cutter and is used on the upper cutter spindle of the 104 Generator.

| Blade Point Width | Edge Radius | Cutter Designation | Apr. Diam Pitch 20° Pressure Angle of Gear |
|-------------------|--------------|--------------------|---|
| .020" | Break Corner | E | 14 - 20 DP |
| .025" | Break Corner | D E | |
| .031" | Break Corner | D E | |
| .038" | .010" | C D E | 6 - 16 DP |
| .048" | .010" | C D | |
| .060" | .010" | B C D | |
| .075" | .010" | B C | 4 - 8 DP |
| .090" | .015" | A B C D | |
| .110" | .020" | A B C | |



| Stock #104 Cutters | | |
|--------------------|-------------|--------------|
| G104E-20T-E | G104E-48T-D | G104E-75T-B |
| G104E-25T-F | G104E-48T-E | G104E-75T-C |
| G104E-31T-E | G104E-48T-F | G104E-75T-D |
| G104E-31T-F | G104E-60T-A | G104E-75T-E |
| G104E-38T-C | G104E-60T-B | G104E-90T-B |
| G104E-38T-D | G104E-60T-C | G104E-90T-C |
| G104E-38T-E | G104E-60T-D | G104E-90T-D |
| G104E-38T-F | G104E-60T-E | G104E-110T-B |
| G104E-48T-C | G104E-60T-F | G104E-110T-C |