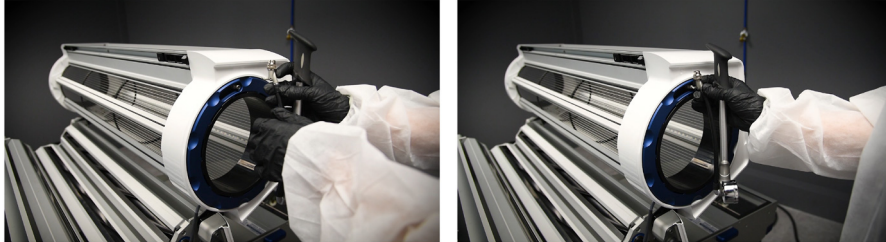


HOT SWAP

A Hot Swap is a process where you change out the AirThread Tension Tumbler, bedknives, and helical blades mid-trim session. The concept is to restore optimum performance and keep trimming without stopping for a complete cleaning of the machine.

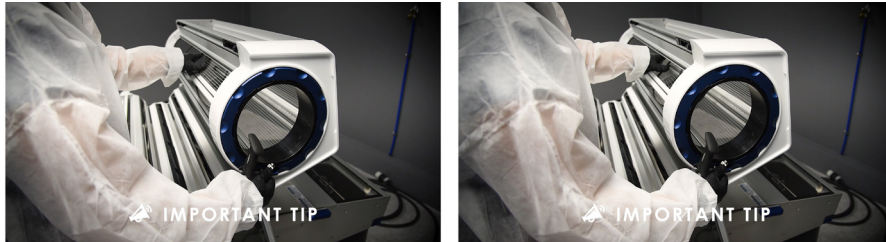
PART 1: AIRTHREAD TENSION TUMBLER - REMOVAL

STEP 01.



First, depress the centre of the shroud valve to release the air from the piston.

STEP 02.



Next, while you're depressing the centre of the shroud valve, press down on the centre of the tumbler. This will force out any remaining air from the piston. This is an important tip, and will make this process much easier.

STEP 03.



Now you'll remove the tumbler retaining ring on the infeed side. Try our favorite technique. With your fingers inside the tumbler, pull the tumbler towards you slightly and rotate the tumbler retaining ring with your thumbs. The ring should spin easily.

STEP 04.



Repeat this step for the tumbler retaining ring on the outfeed side.

STEP 05.



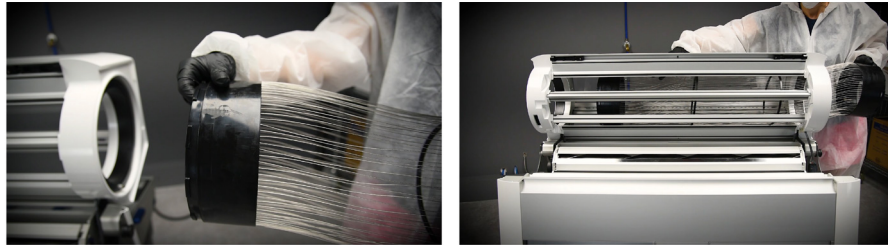
Then, you'll slide the tumbler out the infeed side. Removal is easiest if you pull it straight out towards you, rather than at an angle.

Now, you'll hand off your dirty tumbler to the sanitation team and grab a clean one for installation.

HOT SWAP

PART 1: AIRTHREAD TENSION TUMBLER - INSTALLATION

STEP 01.



You'll slide in the side WITHOUT the fin first, and Pull it through as much as you can.

STEP 02.



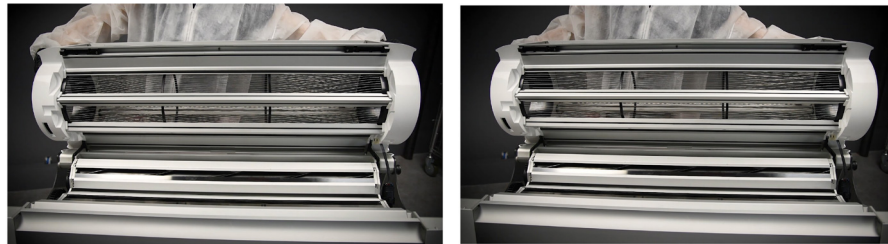
Then, you'll line up the fin on the tumbler end cap with a gap just under the shroud valve, and push it in as far as possible.

STEP 03.



Next, you'll install the tumbler retaining rings. Start with the outfeed side. Put the ring in place, and spin it. This one should go on easily.

STEP 04.



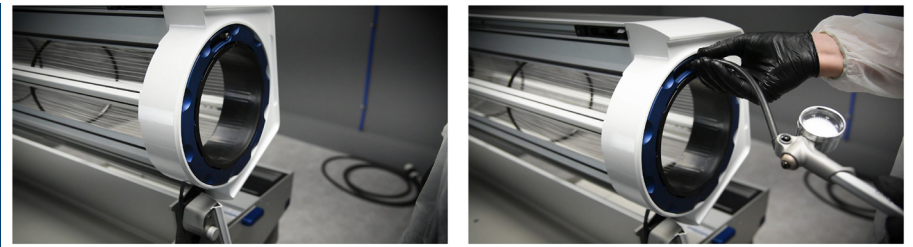
Before installing the second tumbler retaining ring, try to straighten the tumbler cable as much as possible.

STEP 05.



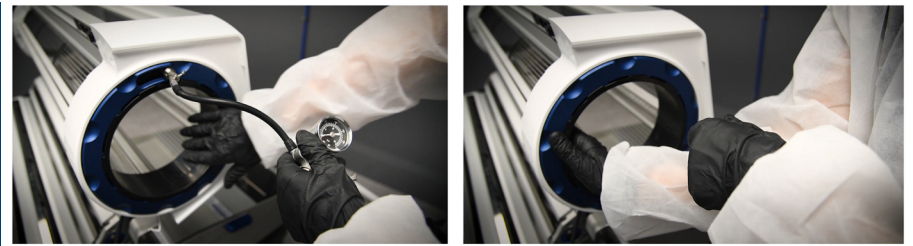
Now you'll install the infeed side tumbler retaining ring. Place your fingers inside the tumbler, and while pulling it towards you, rotate the ring with your thumbs.

STEP 06.



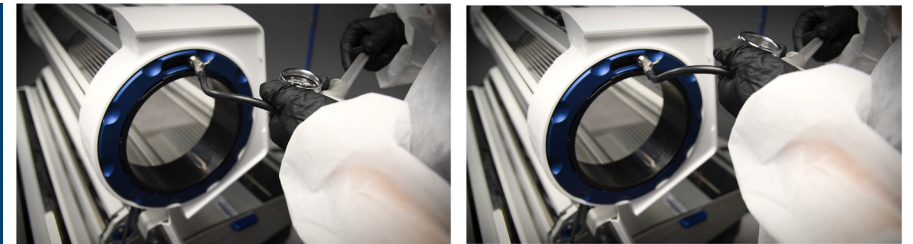
Last step: you'll add air pressure to the AirThread Tension Tumbler. Attach the pump to the shroud valve.

STEP 07.



Give it a few pumps, and then roll the tumbler back and forth several times. This will help the bearings roll smoothly when it's fully pressurized.

STEP 08.



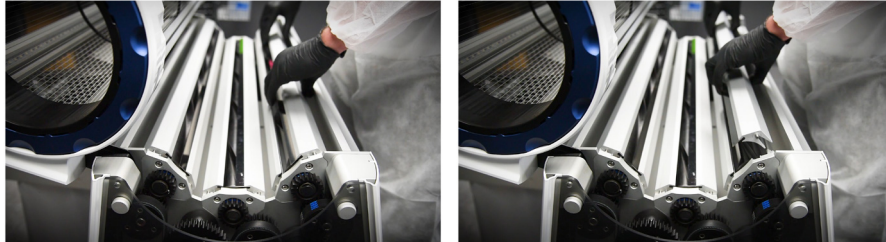
Now, pump the AirThread Tension Tumbler up to between 130psi and 140psi. And that's it! You've got a fresh tumbler, locked and loaded, ready to trim.

HOT SWAP

Next, you'll change out the bedknives and helical blades. The spacer bars don't need to be changed, but they'll need to be removed anyways to access the helical blades.

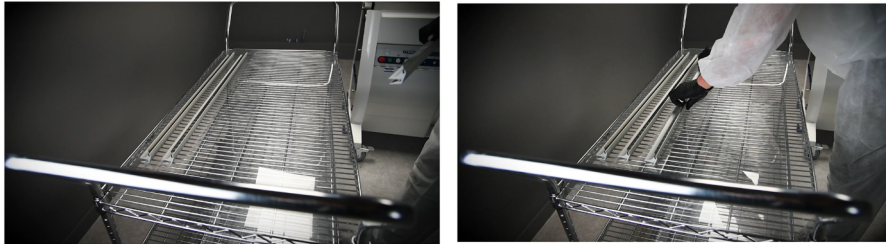
PART 2: HELICAL BLADES & BEDKNIVES - REMOVAL

STEP 01.



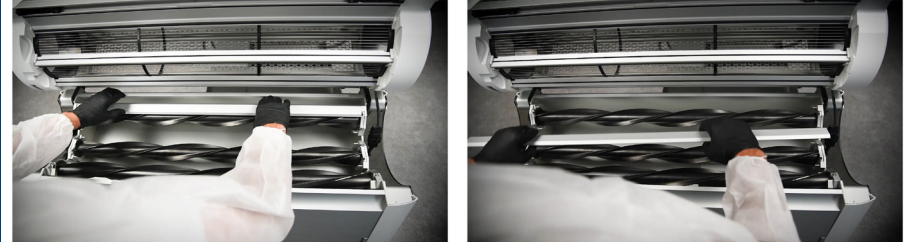
Start by removing the three bedknives. Simply lift them out and set them aside.

STEP 02.



We always recommend using rolling racks or shelving for removal and storage of your blade cartridges.

STEP 03.



Next you'll remove the spacer bars. Like the bedknives, you just lift them out, and set them aside.

STEP 04.

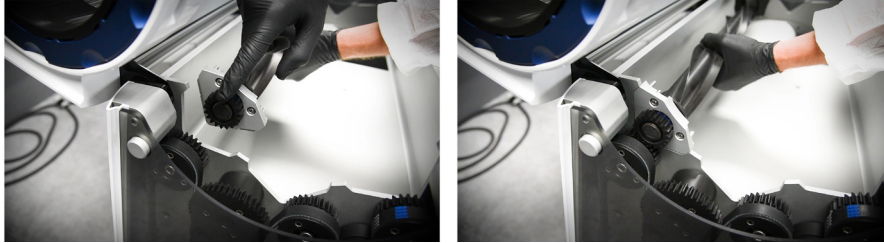


Now you'll remove the helical blades. They are the heaviest of the three components, so make sure you get a good grip and use both hands. You may want to wear padded gloves to protect your palms and fingers.

Now that you've got everything out, we'll reverse the process with a fresh set of helical blades and bedknives.

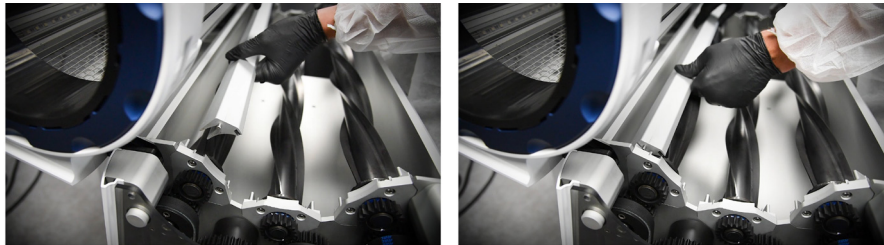
PART 2: HELICAL BLADES & BEDKNIVES - INSTALLATION

STEP 01.



Start with the helical blades. One end has a gear, which fits to the gears on the side of the M108. Make sure the helical blades are seated properly at both sides.

STEP 02A.



Next you'll install the spacer bars. Each spacer bar has a pin on one side, which goes on the GEAR SIDE of the M108. If you're facing the machine with the lid open, that would be the outfeed, or LEFT side.

STEP 02B.



The spacer bars have a tongue and groove design, with the groove being on the spacer bar and the tongue being on the M108 body.

STEP 03.



Finally, you'll replace the bedknives. Like the spacer bars, they have a tongue and groove design and a pin on one side, so that they can only be installed one way.

STEP 04.



Close the lid and you're done, fresh set of blades, ready to trim.

That's it!
With a little practice and a couple extra sets of hands you should be able to complete a hot swap in less than five minutes.
Our team has it down to 90 seconds, [click the link to check it out](#).

If you have any questions about this process, don't hesitate to get in touch with us,
or view some of the other guides and videos we've made available in our [Mobius Academy](#) training site.