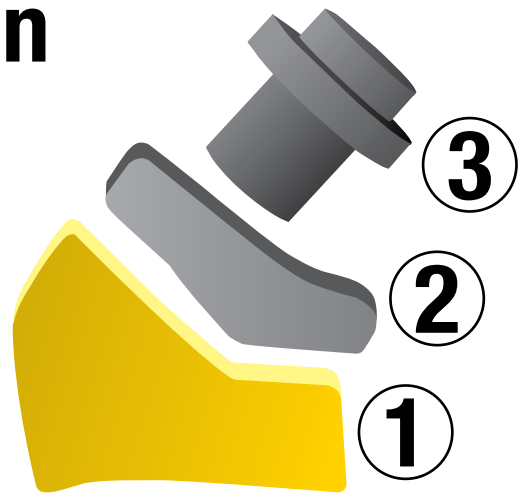




CB11 Stack-On Toolholder Conversion

Easy as 1, 2, 3

Convert your OEM drum to a quick-change taper sleeve system and leave the torque wrench behind!



Advantages

- | | | |
|--|---|---|
| Single piece replacement part for either 20mm or 22mm conicals | ➤ | Quick field repairs/maintenance to return drum to original pattern |
| Hardfacing on block and sleeve | ➤ | Longer wear life in deep cutting conditions |
| Short sleeve bore with relief cone | ➤ | Easy bit access and cleaning |
| Corrosion-resistant compression retainer | ➤ | Does not require anti-seize; Consistent extraction force over time |
| No bolts requiring tapping, torquing, and re-torquing | ➤ | Save time and money |



Step-by-step instructions to convert WIRTGEN® HT11 cutting system:

➤ **1** Start with **OEM Base Blocks** as pedestals for the stack-on.

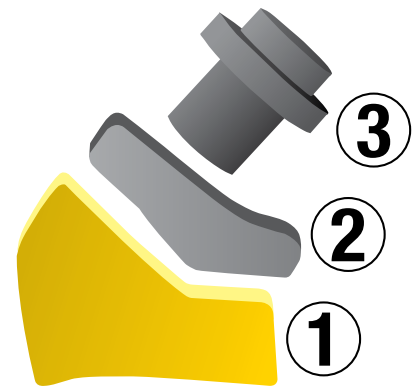
- Remove bolt-retained toolholders.
Clean top surface and bit access notch.

➤ **2** **CB11 Adapter Block** — Weld-on block converts drum to a no-bolt, quick-change system.

- Use alignment tool to center adapter block with the base block. Clamp or tack weld adapter block into place. Remove alignment tool. Root and cover weld according to accepted welding procedures (reference Kennametal 'Recommended Welding' guidelines if unsure). Repeat process for each base to be converted.

➤ **3** **CB11-RK or CB11-SK Sleeve** — OEM block is now ready to accept CB11 sleeves.

- Check to make sure the adapter block bore is clean. Drive sleeve into bore until tapers contact (sleeve collar will not contact block face). Most roadside repairs can be handled by removing the old sleeve and repeating step 3.



Description	Order Number
CB11 Adapter Block	6615882
CB11-RK Sleeve (for 20mm bit)	6615883
CB11-SK Sleeve (for 22mm bit)	6615884
CB11 Alignment Tool	6615885

IMPORTANT:

- Pre-heat is recommended; never exceed 450°F (230°C).
- Allow blocks to cool before installing sleeves.
- Do not use anti-seize; sleeves use compression retainer instead of an interference fit.
- Use installation tool to avoid hammering the bit seating face, KPF-Install Bit (1968708).

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