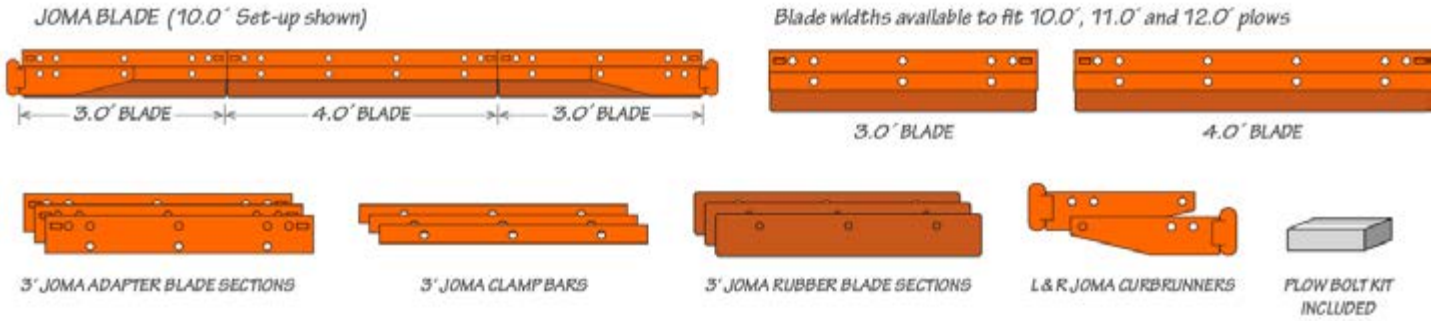
INSTALLATION INSTRUCTIONS

Joma® 6000 Cutting Edge System

PARTS INCLUDED



IMPORTANT!

The moldboard mounting surface must be clean of all foreign material prior to installing new blades and hardware to avoid issues with bolt loosening while in service.

- For torque recommendation, please refer to SAE J1701
- Re-torque hardware after the first 10 plow hours

IMPORTANT NOTES ABOUT JOMA 6000

Bolt Hole Spacing

The JOMA® 6000 blade is manufactured in 12" increments, with each segment held in place with one bolt, centered. Therefore, the JOMA blade must be bolted to the plow at intervals of 12" (end holes positioned six inches in from the outboard edge).

If the moldboard of the plow has mounting holes positioned other than 12" on center, an adapter blade is used to accommodate the JOMA (Figure 1). This simple adapter has two horizontal rows of mounting holes, the top row to fit the plow and the lower row to fit the JOMA® blade.

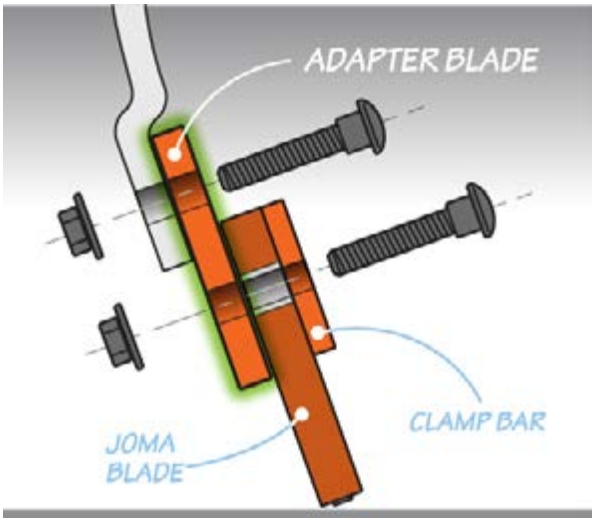


FIGURE 1

Stepped or Short Moldboard

The JOMA® Blade should be mounted with a minimum 2" of back support below the mounting holes to support the segment. If the distance from the center of the mounting holes to the bottom of the moldboard is less than 2", a backing blade should be used (Figure 2).

The JOMA® Blade segments require a clear area 2.5" above the mounting holes to be able to move and seat properly. If there is a step in the moldboard (as shown in Figure 2), a backing blade will position the blade allowing the Joma blade free movement in order to 'seat' itself.

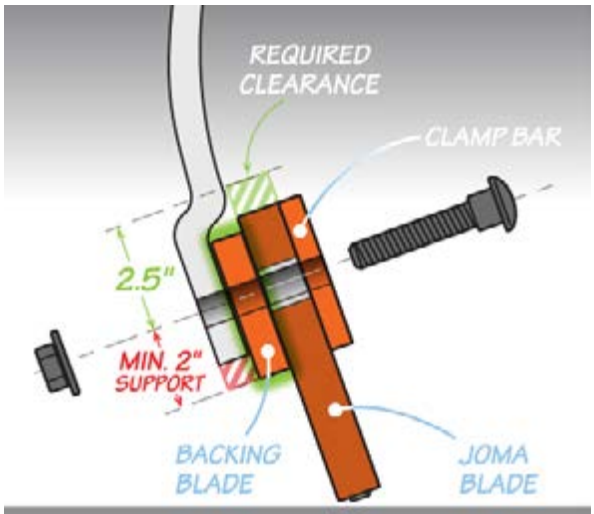


FIGURE 2

Hardware

The JOMA® blade is supplied with a specially heat-treated clamping bar, which is placed over the JOMA® blade to clamp the blade to the plow. ***Only Grade 8 or better carriage bolts*** are recommended for installing the JOMA® blade (Part #KT-JMR-12*;* Figure 3).



FIGURE 3

Operating Angles

REVERSIBLE FRONT PLOWS

The recommended moldboard angle for installation is 65–75° to the road surface for best performance (Figure 4). Steeper angles (approaching 90°) result in bounce and chatter.

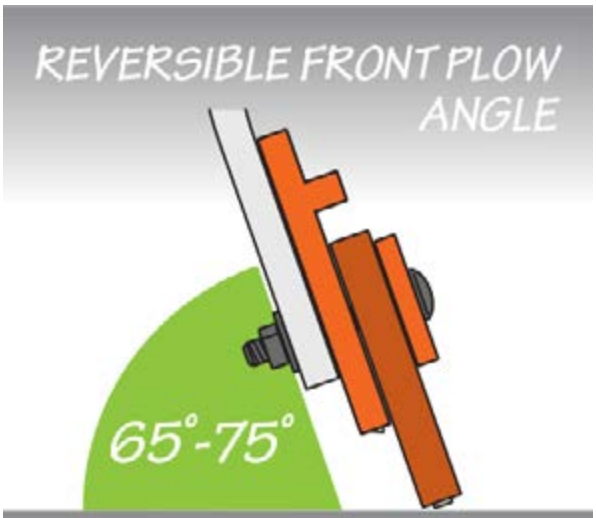


FIGURE 4

ONE-WAY PLOWS

The recommended moldboard angle for one-way plows is 55–60° to the road surface for best performance. Shallower angles allow the moldboard to bottom out before the JOMA® blade is worn, leading to moldboard damage or premature wear. (Figure 5).

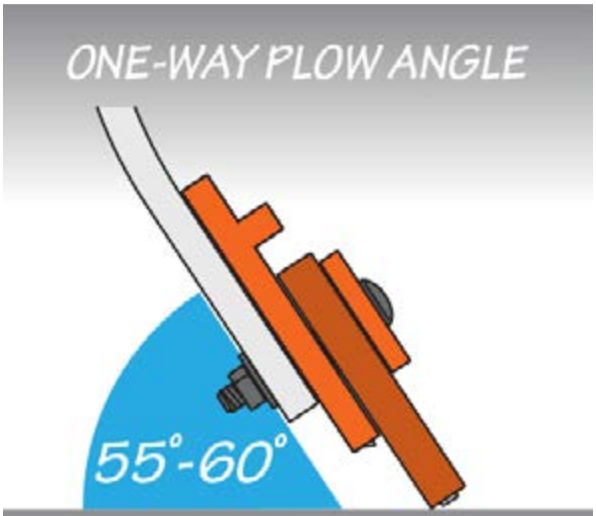


FIGURE 5

Joma 6000 Operation Notes

1. THE JOMA® SYSTEM PERFORMS BEST ON HARD SURFACES such as asphalt, concrete, tar and chip seal roads.

2. IF YOUR RUBBER BLADE IS CHANGING SHAPE, IT'S NORMAL**.** During operation, the JOMA® blade 'seats' itself up into the rubber holder. Don't be alarmed by the rubber being pushed up above the clamping bar, this is normal. As a result of this seating process, the JOMA® blade actually becomes narrower in its first few hours of operation – this is not premature wear, but compression of the rubber due to the seating process.

   Actual wear can be determined two ways: 1) by carefully examining the carbide insert at the end of the blade for possible damage, or 2) by inspecting the front wear indicator for the amount of carbide left behind the line (Figure 6).

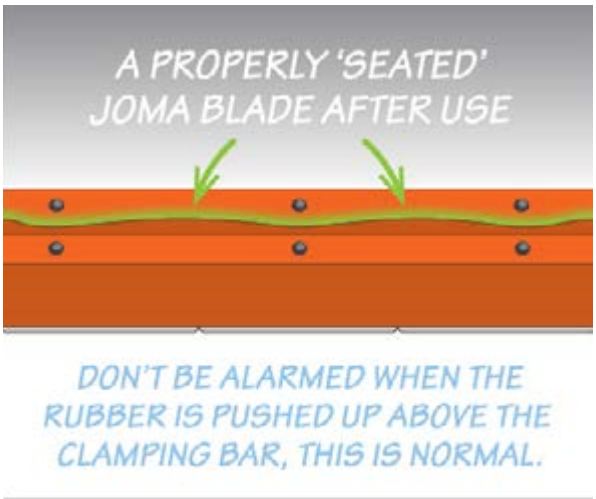


FIGURE 6

3. PROPER ADJUSTMENT DURING INSTALLATION
   When installing new JOMA® blades with runner shoes or castors, the blade should be adjusted while lifted approximately 3/4" off the road surface. This adjustment places enough weight on the JOMA® to force the required seating process in the first few hours of operation. Once the JOMA® blade has seated, the runners will be in contact with the road surface and properly supporting the weight of the plow, extending blade life. (Figure 7)

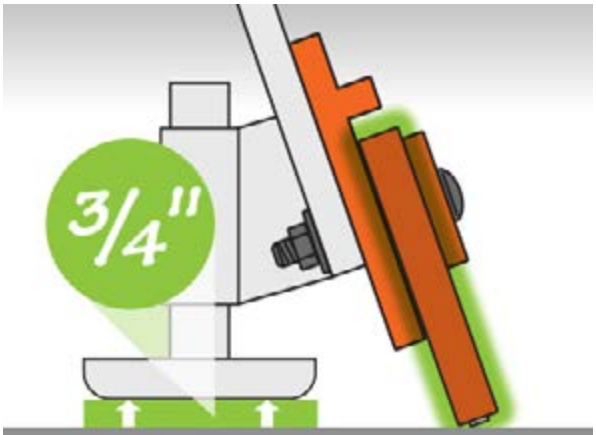


FIGURE 7

4. EXCESSIVE CHATTERING OR BOUNCING
   Operating a plow in a straight-on (dozer) position can result in the blades chattering, so increasing the angle of the plow should eliminate this. Other causes of excessive chatter or bouncing are: weak trip mechanisms or insufficient down pressure. (Figure 8)

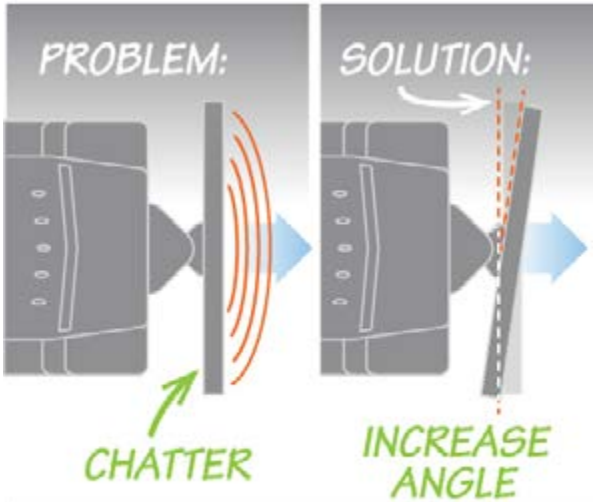


FIGURE 8

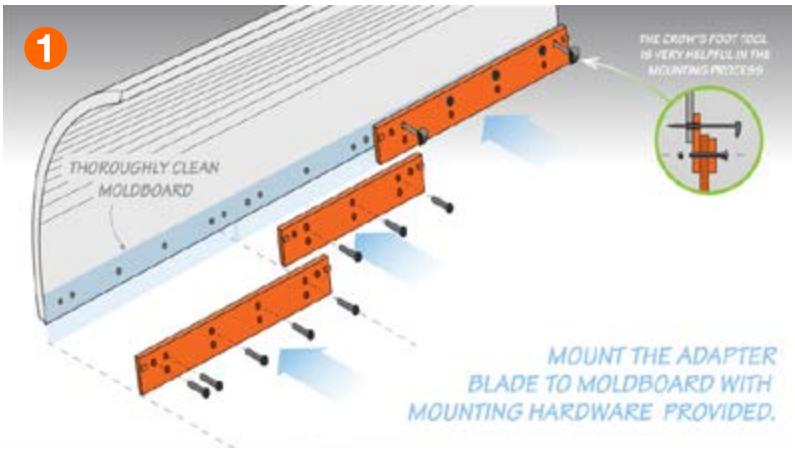
5. WHAT IF I SEE A THIN FLAP OF RUBBER ON THE JOMA EDGE?
   If excessive heat is built up on the bottom edge, the rubber may delaminate from the bottom edge of the segments (usually experienced only during dry plowing operations). The thin layer of rubber on the front edge generally does not affect the performance of the blade, and can be removed with a utility knife if desired. However, if you are experiencing excessive snow deflection over the plow, this thin flap of rubber could be the cause and should be removed.

6. INDIVIDUAL SECTIONS OF THE JOMA SYSTEM CAN BE REPLACED without replacing the entire set, provided the remaining sections are less than 50% worn. If wear exceeds 50%, replace the entire set. The seating of the new JOMA® blade section into the rubber will compensate for the difference, allowing for a level cutting edge.

JOMA 6000 INSTALLATION

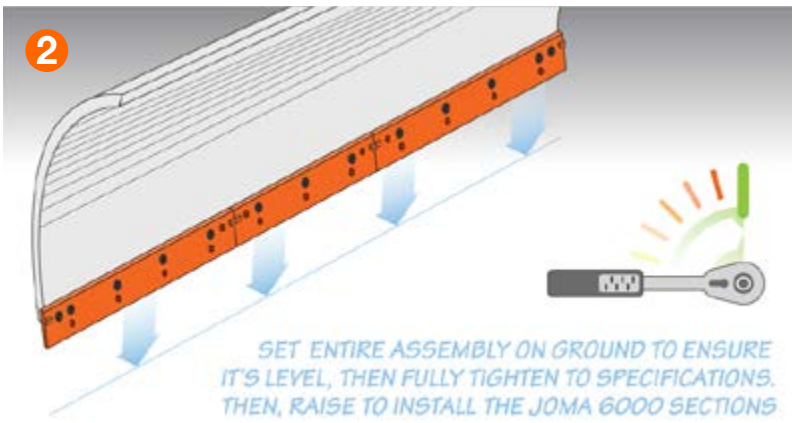
Step 1

Install driver's-side main cutting edge with included shorter 3" plow bolts. Hand tighten. Do not install bolts in the three bolt holes on the end. These three holes will be used for plow guard installation.



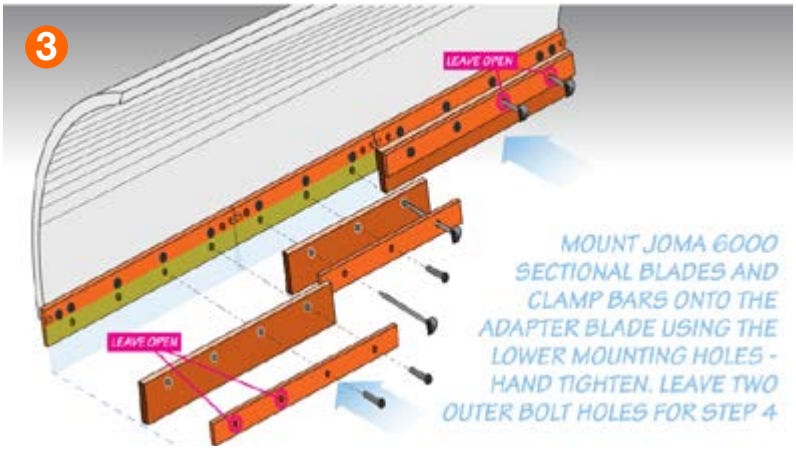
Step 2

Install center and passengers-side sections with included shorter 3" plow bolts by first pressing blade firmly against moldboard, then slide blade behind the adjacent blade so they interlock.



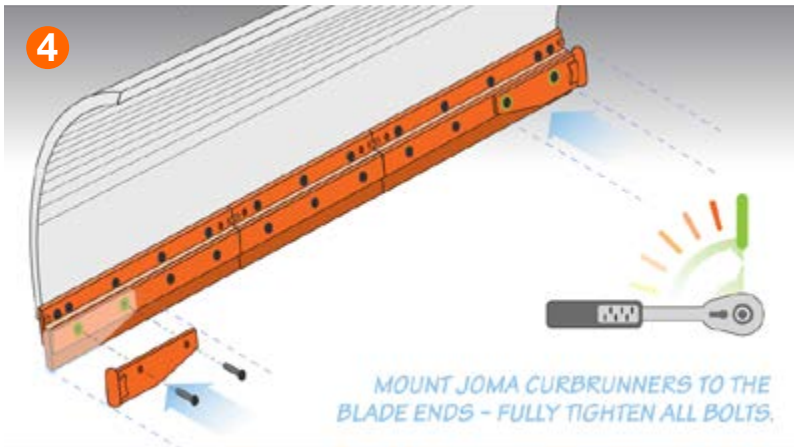
Step 3

Install center and passengers-side sections with included 3" plow bolts. Hand tighten. Do not install bolts in the three bolt holes on the end. These three holes will be used for plow guard installation in Step 4.



Step 4

Install a JOMA® CurbRunner on each end with included longer Super Bolts. Fully tighten all bolts.



Re-torque hardware after the first 10 plow hours

WARNING!

Enclosed hardware package must be utilized or the WARRANTY is invalid