

## Cutter Blade Installation:

1. Insert the pivot pin into the cutter body and thru the blade. Rotate the pivot pin until it engages the tang of the activating rod.
2. With the blade in the open position, rotate the clutch of the tool until the alignment mark on the pivot pin is parallel to the hex wrench and set screw in the cutter blade. This will ensure the set screw is aligned with the flat on the pivot pin.
3. Apply a small amount of serviceable Loctite (provided) to threads of screw. Tighten set screw to 6-10 in/lbs., being careful not to overtighten and ensuring set screw is on flat of pivot pin. If second follow up screw is provided, install and tighten to 6 in/lbs.

**TIP:** To verify the set screw is located on the flat of the pivot pin, loosen set screw slightly and attempt to pull pivot pin out of tool. The pin should only be able to slide until the set screw stops on the end of the pivot pin flat.

## Operating Sequence:

1. With through coolant **OFF** and flood coolant **ON** enter work hole in **clockwise** rotation at **500-800 rpm**.
2. Feed to open area so blade can be opened completely before cutting.
3. Reverse spindle rotation to **counterclockwise** at **500-800 rpm**. Do not stop spindle between changing rotation. Blade will open. After a 1-3 revolution dwell, increase rpm to proper cutting speed. Turn through coolant **ON**.
4. Back feed to counterbore depth. Dwell for 1-3 revolutions to clean up cut.
5. Feed back to open area to clear part. Turn **OFF** through coolant. Leave flood coolant **ON**.
6. Set spindle to **500-800 rpm** and reverse to **clockwise**. Do not stop spindle between changing rotation. Blade will close. Fast feed out to complete machining cycle.

