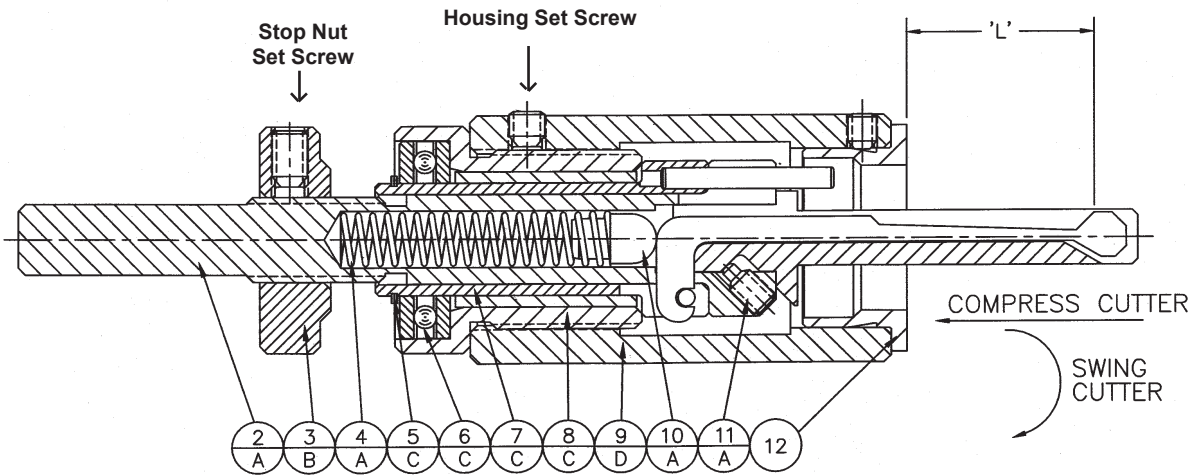


Back Chamfering Unit Setting and Operating Instructions



To assemble or remove the cutters and pilots:

1. Loosen the housing set screw and unscrew the housing completely off of the assembly.
2. Loosen the pilot locking screw (det. 11) and remove the pilot.
3. To remove the cutter, push the cutter down, compressing the spring plunger (det. 10), and then swing it out in a circular motion, freeing it from the pin.
4. To reassemble the tool, reverse the above procedures.

To set chamfer position and diameter:

1. To set chamfer position length ("L"), loosen the set screw in the housing (det. 9) and thread the housing until approximate length is achieved. Visually set the BCU in the part if possible, or use a scale.
2. Tighten set screw.
3. To set the desired diameter or depth of chamfer on a manual machine, release the diameter stop nut (det. 3) and thread to position that allows the cutter to feed out to cut desired chamfer diameter. The tool can be inserted in a part and actuated by hand to verify the setting. Lock the set screw in the stop nut.
4. Test cut a part.
5. To adjust the diameter/axial position of the chamfer, thread the housing as required to reposition the chamfer. Note: You must set the chamfer position before adjusting the diameter stop nut (det. 3) because the axial position will affect the chamfer diameter. The graduations on the housing relate to the radial movement of the cutter.