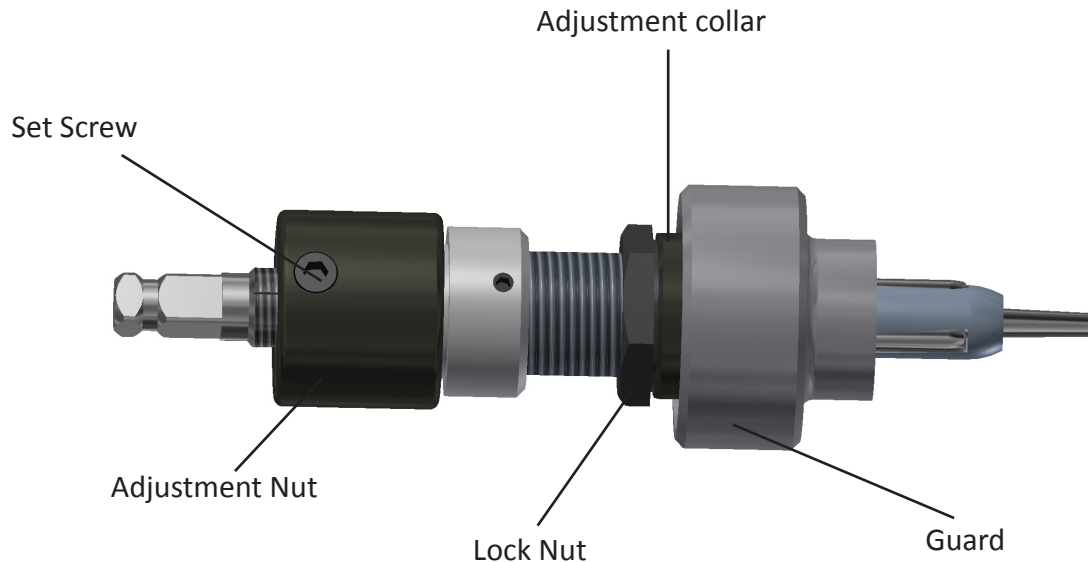


Mechanical Joining Tool Setup



Guard Position:

1. Loosen the lock nut
2. Rotate the adjustment collar to adjust the depth the rolls will go into the part.
3. Re-tighten the lock nut

Diameter adjustment:

1. Loosen the set screw in the adjustment nut
2. Rotate the adjustment nut to adjust the stroke of the mandrel (this will determine the size).
3. Re-tighten the set screw.
4. Expand a part and check the size. Adjust as required.

Diameter	RPM	Torque
1/4" to 5/8"	2000	15 in. lbs.
1/2" to 1.5"	700 to 1200	8 to 12 ft. lbs.
1" to 3"	75 to 250	30 to 102 ft. lbs.



Your hole finishing experts.