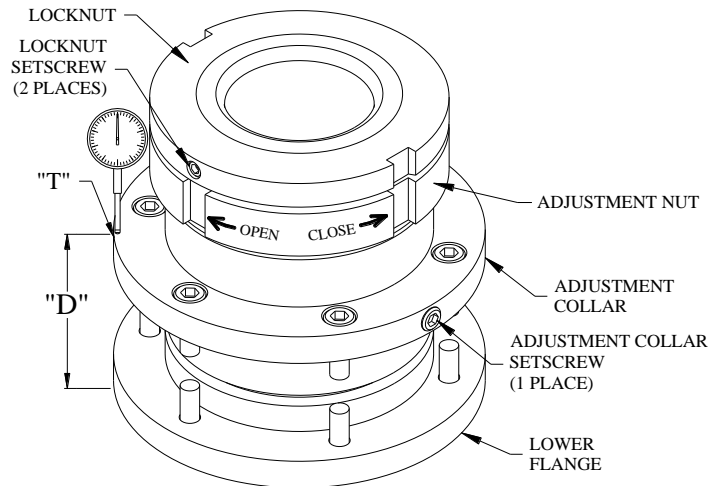
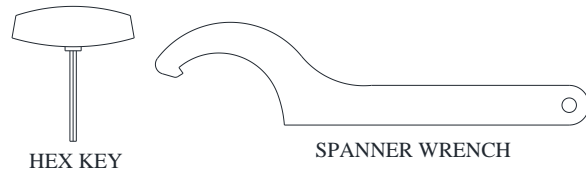


Adjustable Sleeve Assembly – Straight Bore Adjustment Instructions

1. Great Lakes Custom Tool recommends the use of safety glasses **at all times**.
2. When cutter is mounted on the machine, be sure to follow **LockOut/TagOut** procedures and use all appropriate personal protection equipment.

The adjustable sleeve assembly is adjusted to widen or narrow the cut for the profile as required to maintain the proper part dimensions.

1. Determine the amount that the sleeve assembly must be adjusted by measuring the profile of several samples just machined.
2. Measure the distance “D” between the top surface of the flange of the adjustment collar and the bottom surface of the lower flange or place a dial indicator on the top surface “T” of the adjustment collar to measure the movement (up or down) of the adjustment collar.
3. The adjustment nut will only need to be rotated a few degrees to make the desired adjustment. **Use the chart below as a guide.**
4. Using a hex key, loosen the locknut setscrews.
5. Loosen the locknut using a spanner wrench (GLCT Part No. 6975A22). Turn the locknut counterclockwise (ccw) to loosen. **Loosen locknut just enough to allow for adjusting the adjustment nut. (Loosen locknut no more than ¼ turn!)**
6. Using a hex key loosen the adjustment collar setscrew. Turn the adjustment nut using a spanner wrench in the desired direction.



SLEEVE ASSEMBLY SHOWN WITHOUT CUTTER

Rotation of Adjustment Nut (Degrees)	Change in Dimension “D” (Inches)
5°	.0008
10°	.0017
15°	.0026
20°	.0034
25°	.0043

Close to narrow the cut. (ccw)
Open to widen the cut. (cw)

7. After adjustment, tighten adjustment collar setscrew, locknut, and locknut set screws.