

Adjustable Sleeve Assembly – Hydro Bore Mounting & 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.

MOUNTING INSTRUCTIONS

1. Position adjustable sleeve assembly with cutter on spindle and pressurize to a working pressure of 400-450 bar (5800-6500 psi). Do not exceed the maximum pressure of 500 bar (7450 psi). Use Grease gun (GLCT Part No. M06) with pressure gauge to pressurize the hydro sleeve assembly. It is recommended to check the pressure once a day before start up.
2. Place a safety collar with pins above the adjustable sleeve assembly. Position the collar so the pins engage the holes of the hydro sleeve. Tighten the clamping screw in the collar using a hex key.

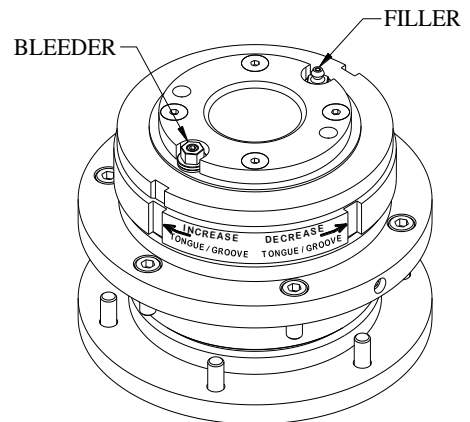
Safety Collar No.	Spindle Dia.
WNW-101719	1 13/16"
WNW-101720	2 1/8"

3. When it becomes necessary to remove the adjustable sleeve assembly with cutter from the spindle, loosen the clamping screw in the safety collar and remove the collar. Using a hex key loosen the screw in the bleeder to release the pressure in the expansion sleeve. Remove the adjustable sleeve assembly from the spindle.

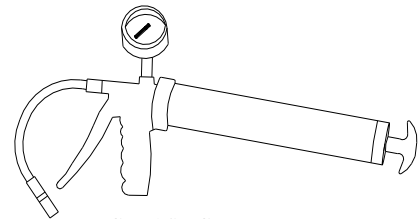
ADJUSTMENT INSTRUCTIONS

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

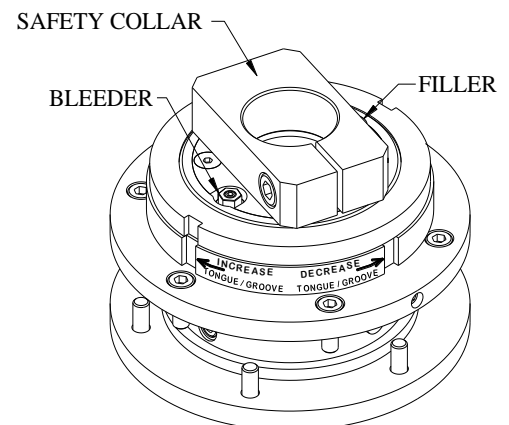
1. Determine the amount that the adjustable sleeve assembly must be adjusted by measuring the profile (tongue or groove) of several flooring boards just cut. If cutters need to be sharpened, send the flooring assembly to Great Lakes for sharpening and cutting width adjustment.



Hydro Bore-Adjustable Sleeve Assembly
Shown without cutter (Ref. 942-08796-0000)

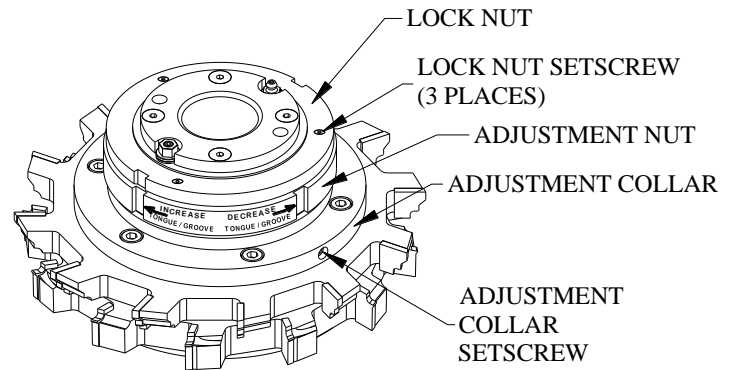


GREASE GUN WITH
PRESSURE GAUGE

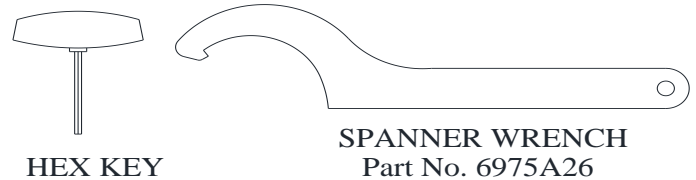


ADJUSTMENT INSTRUCTIONS (CONTINUED)

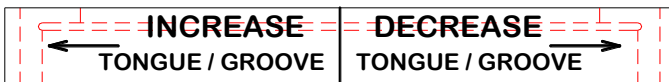
- Using a hex key, loosen the locknut set screws located on the top surface of the locknut.
- Loosen the locknut using a spanner wrench (GLCT Part No. 6975A26). Turn the locknut counter-clockwise (ccw) to loosen.
Loosen locknut just enough to allow for adjusting the adjustment nut. (Loosen locknut no more than ¼ turn!)



ADJUSTABLE HYDRO-SLEEVE WITH CUTTERS MOUNTED



- Using a hex key loosen the adjustment collar setscrew. The adjustment nut will only need to be rotated a few degrees to make the desired adjustment. Radial lines have been etched into the adjustment collar. **As the adjustment nut is rotated from line to line, this equals .001" movement in the axial direction** which opens or closes the width between the top and bottom cutters.
- The Adjustment Nut for this Expansion Matcher Assembly is stamped as shown below:

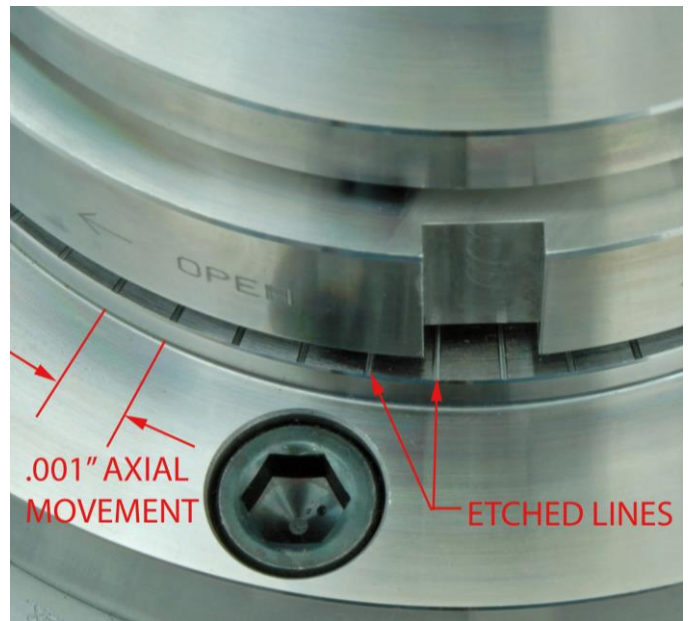


- Use the spanner wrench (6975A26) to rotate the adjustment nut in the desired direction.

Decrease: Tongue/Groove—will narrow the tongue or groove width.

Increase: Tongue/Groove--will increase the tongue or groove width.

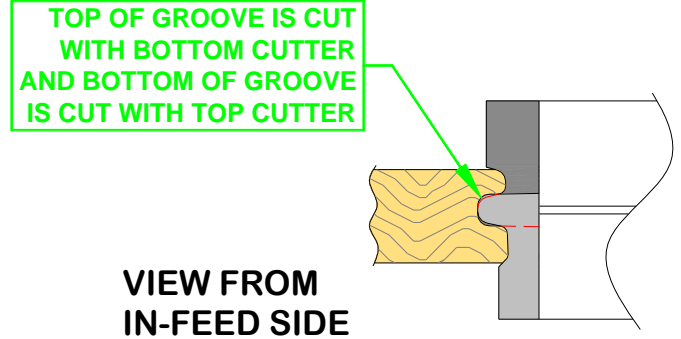
Note: See instructions for adjusting groove cutters that also micro-bevels the flooring edge on the next page.



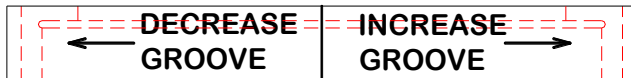
ADJUSTMENT INSTRUCTIONS
for Expansion Matcher Groove Cutter with
micro-levels

- A groove cutter which also bevels the edge of the flooring will be set up differently.

The top of the groove is cut with the bottom cutter and the bottom of the groove is cut with the top of the cutter.



- The Adjustment Nut for this assembly is stamped as shown below:



- Using a hex key loosen the adjustment collar setscrew. The adjustment nut will only need to be rotated a few degrees to make the desired adjustment. Radial lines have been etched into the adjustment collar. **As the adjustment nut is rotated from line to line, this equals .001" movement in the axial direction** which opens or closes the width between the top and bottom cutters.

- Use the spanner wrench (6975A26) to rotate the adjustment nut in the desired direction.

Decrease Groove –will narrow the groove width

Increase Groove- will increase (widen) the groove width

- After adjustment is made, tighten adjustment collar set screw, locknut, and locknut set screws.
- Reinstall the cutter assembly onto the flooring machine.

