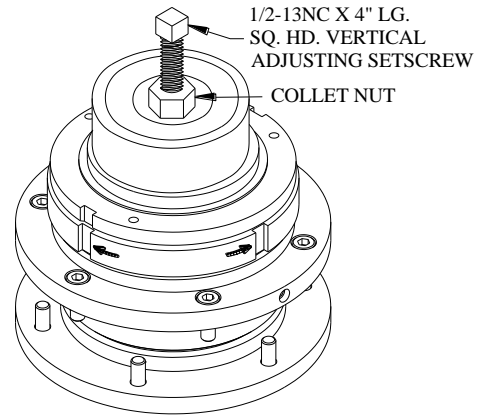


## Adjustable Sleeve Assembly - Collet Mount Mounting & Adjustment Instructions

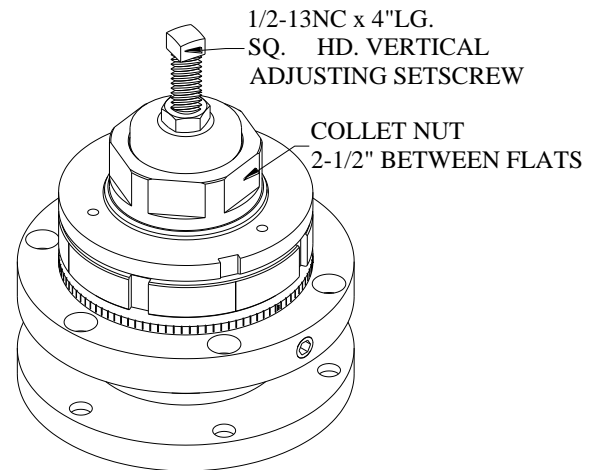
1. Great Lakes Custom Tool recommends the use of safety glasses **at all times**.
2. When cutter is mounted on the machine, be sure to follow **LockOut/TagOut** procedures and use all appropriate personal protection equipment.

### MOUNTING INSTRUCTIONS

1. Position adjustable sleeve assembly with cutter on spindle and adjust height of cutter on spindle by turning the 1/2-13NC square head vertical adjusting set screw. Turn the set screw (cw) clockwise to raise the cutter and (ccw) counterclockwise to lower the cutter.
2. **Lock the cutter assembly to the spindle by tightening the “Collet Nut”.** Using a 7/8” or a 2 1/2” wrench turn the nut (cw) to tighten. This draws the collet up and tightens the cutter assembly securely to the spindle.
3. When it becomes necessary to remove the adjustable sleeve assembly with cutter, turn the collet nut (ccw) to loosen. Turn collet nut 4-8 complete revolutions to loosen. It may be necessary to tap the vertical adjusting setscrew or cutter with a light hammer to loosen the collet from the spindle. Remove adjustable sleeve assembly with cutter from spindle.



COLLET – ADJUSTABLE SLEEVE ASSEMBLY  
Shown without cutter (Ref. 940-01994-0100)



COLLET - ADJUSTABLE SLEEVE ASSEMBLY  
Shown without cutter - Has large Collet Nut, 2 1/2”  
between flats. (Ref. 942-31545-7000)

### ADJUSTMENT INSTRUCTIONS

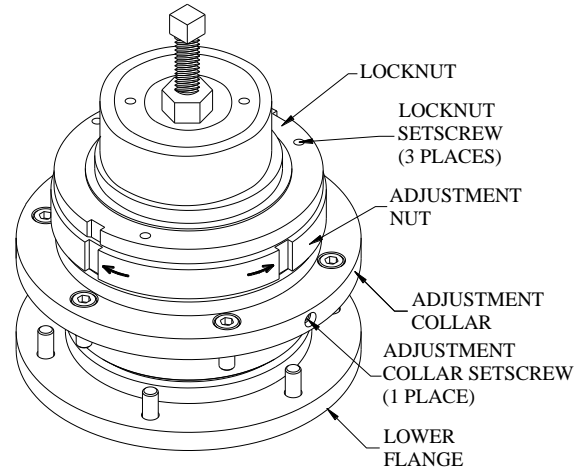
The adjustable sleeve assembly is adjusted to widen or narrow the cut for the profile as required to maintain the proper part dimensions.

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.
2. Using a 3mm hex key, loosen the (3) locknut setscrews. Note: These setscrews are flat point and lock down on the Adjusting nut. When tightening these setscrews, hand tighten snug.  
**Do not torque.**

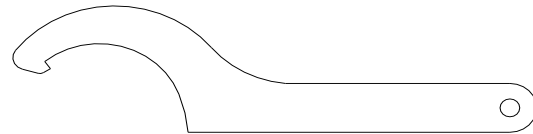
**ADJUSTMENT INSTRUCTIONS**  
**(continued)**

3. Loosen the locknut using a spanner wrench (GLCT Part No. 6975A24). Turn the locknut counter-clockwise (ccw) to loosen. **Loosen locknut just enough to allow for adjusting the adjustment nut. (Loosen locknut no more than 1/4 turn!)**
4. Using a 1/4" hex key loosen the (1) 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.
5. Use the spanner wrench (6975A24) to rotate the adjustment nut in the desired direction.
 

**Close** will decrease groove or tongue width  
**Open** will increase groove or tongue width
6. After adjustment is made, tighten adjustment collar set screw, locknut, and locknut set screws.



COLLET- ADJUSTABLE SLEEVE ASSEMBLY  
 Shown without cutter



SPANNER WRENCH  
 Part No. 6975A24

