

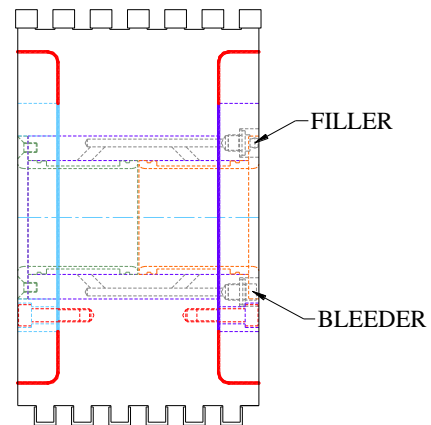
Mounting Instructions for Cutters with Hydro-Bore Sleeves or ETP Sleeves

Note: Instructions are for a typical cutter. The cutter shown may not look identical to your cutter.

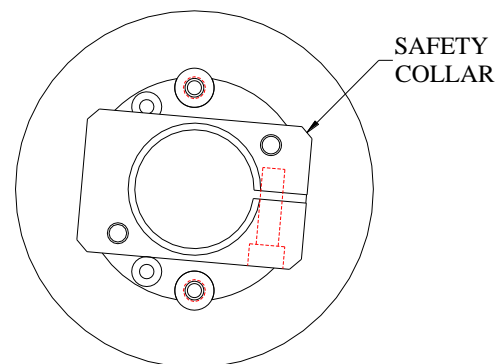
1. Great Lakes Custom Tool recommends the use of **safety glasses at all times.**
2. When cutter is mounted on the machine, be sure to follow **LockOut/TagOut** procedures and use all appropriate personal protection equipment.

Mounting Instructions

1. Position Cutter on spindle and pressurize to a working pressure of 400-450 bar (5800-6500 psi). **Do not pressurize the hydro-sleeve or etp sleeve if the cutter is not on an arbor or if the arbor is Not extending through the full length of the cutter sleeves. Damage will occur to the sleeves 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.
Note: Cutters 230mm long and longer will be in 2 pieces. The 2-piece cutter will have interlocking tabs. Each piece will have one filler and one bleeder on the outer diameter of the body for ease of checking the pressure daily. **It is important to pressurize each part in a 2-piece cutter to ensure that each half is properly clamped to the spindle.**



2. Place a safety collar with pins on the outboard end of the cutter. Position the collar so the pins engage the holes of the hydro sleeve. Tighten the clamping screw in the collar using a hex key.



END VIEW OF CUTTER

SAFETY COLLAR NO.	SPINDLE DIA.
WNW-101719	1 13/16"
WNW-101720	2 1/8"

3. When it becomes necessary to remove the 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 cutter from the spindle.

