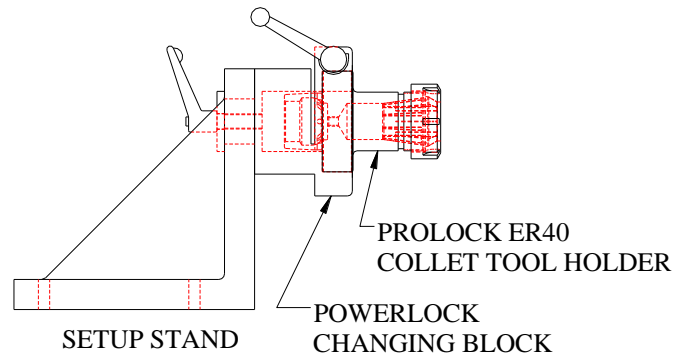


Installing a Router Bit into a Prolock ER40 Collect Tool Holder

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 the cutter is mounted on the machine, be sure to follow **LockOut/TagOut** procedures and use all appropriate personal protection equipment.
3. Remove the cutter from the machine.
4. Place the cutter in a setup stand to change inserts or to replace the cutter. The setup stand must be fastened to a solid work bench or table.
5. Setup stand & accessories can be purchased from Great Lakes. **Order:** 955-07584-0000 Stand Assy. and 950-07584-PL00 Changing Block for PowerLock arbors.



Installing Cutter into Prolock ER40 Collet Tool Holder

(Prolock tool holder part no. 84.026.100.080)

1. Install collet with desired bore into Collet Nut. Collets are ER40.

Collet sizes are available in both inch and metric.



2. Place Prolock Tool Holder into the Changing Block mounted in the Setup stand. This will securely hold the tool holder for installing or working on the cutting tool.

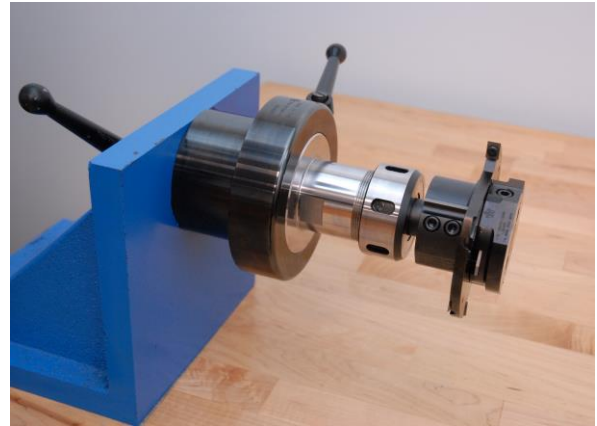


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3. Install the router bit into the tool holder.

It is important to have the shank of the tool engage the collet the full length of the collet. Damage will occur to the collet and the tool will not be properly clamped if the shank of the router bit is shorter than the collet length.

Shown is a 3-piece router bit assembly used for grooving and finishing for a window application.



4. Torque the collet nut using a torque wrench.

Torque Wrench Number: 30-30TW
Spanner Wrench End for Torque Wrench:30-40SPW

Torque the collet nut to 110 ft.lbs.

An additional wrench with a 1 13/16 jaw opening will be required to stop the rotation of the tool holder when torquing the collet nut.



6. Prolock tool holder shown with router bit ready to install onto a machine.

