

ETP Sleeve Type Hydro Expansion Matcher Mounting & Adjustment Instructions

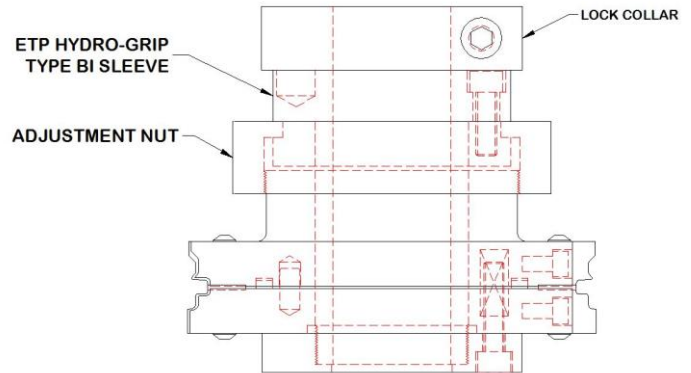
Note: Instructions are for a typical cutter. The cutter shown may not look identical to your cutter.

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

Important: The Hydro Expansion Matcher must *NOT* be pressurized without being mounted on a spindle! The expansion matcher must be fully engaged the length of the bore with the spindle or damage to the bore will occur.

Mounting Instructions

1. Refer to the ETP Hydro-Grip Type BI instruction sheet for cleaning, mounting, and pressurizing information.
2. Place a safety collar with pins above the hydro sleeve expansion matcher 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.
3. When it becomes necessary to remove the expansion matcher assembly from the spindle, loosen the clamping screw in the safety collar and remove the collar. Follow the ETP Hydro-Grip Type BI instruction sheet to depressurize the sleeve.



Adjustment Instructions

1. Determine the amount that the adjustable sleeve assembly must be adjusted by measuring the profile of several samples just machined.
2. To change the size of the tongue/groove you will need to turn the adjustment nut. The sleeve **MUST** be depressurized in order to do so. Follow the ETP Hydro-Grip Type BI instructions.
3. The adjustment nut has graduations marked on its top surface. Each line represents .001" of adjustment. On the side of the sleeve are arrows showing which way to rotate the nut to increase or decrease the tongue/groove.
4. On the side of the sleeve there should be a punch mark that represents the "zero" point of the assembly. Use this point as a reference point for making adjustments. If the punch mark is not visible use a marker to mark the side of the sleeve to use as a reference mark.
5. There are two supplied spanner wrenches for making the adjustment. The larger wrench is for turning the adjustment nut and the smaller wrench is used on the bottom nut to keep the assembly from turning.
6. After the cutter is adjusted follow the ETP Hydro-Grip Type BI instructions to repressurize the sleeve.

