

Portable Cutting Tool Operating Instructions

Operating instructions

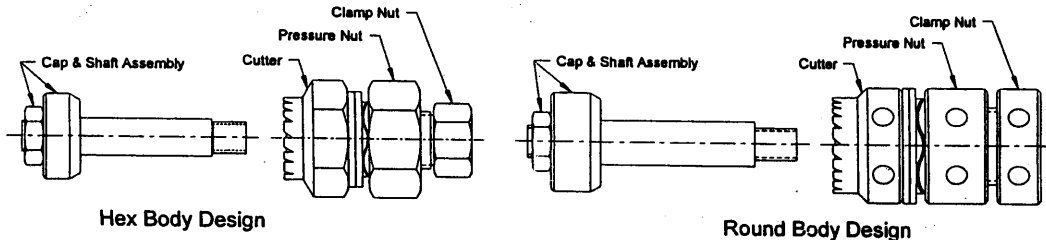
- 1) Unscrew cap and shaft assembly from clamp nut insert in far side of bearing.
Note: Other parts of tool should remain together.
- 2) Turn pressure nut up to clamp nut and screw tool onto cap and shaft assembly.
- 3) Tighten clamp nut securely.

Note: Use standard box or open end wrench on hex body tools and pin type spanner wrench or round bar on round body tools.

- 4) Turn pressure nut up to exert light pressure on cutter.
- 5) Turn cutter one full turn clockwise and then tighten pressure nut 1/8 turn.
- 6) Repeat step 5 until cutter stops cutting.

Note: This occurs when cutter has reached bottom of groove and is against the internal stop.

- 7) Remove tool by unscrewing clamping nut and removing cap and shaft assembly from bearing.
- 8) Push bearing out of housing.



Tool Maintenance Instructions

Shafer tri-roller swaging tools and cutters require only an occasional application of light machine oil. This will assure continued smooth tool operation and prevent any corrosion on the tool parts. Disassembly and cleaning of the rollers and retainer are also recommended whenever the tool operates roughly or there is evidence of foreign materials under the retainer.

To disassemble the drill press design

Remove the set screw in the roller fixture

To disassemble the portable set screw design

Remove the set screw just above the roller/retainer assembly and unscrew the pilot.

To disassemble the portable o-ring design

Pull the roller/retainer assembly away from the roller fixture with your fingers to dislodge the o-ring from its groove. Remove the o-ring from the pilot

This will allow the removal of the retainer and rollers.

Thoroughly clean rollers, retainer, retainer pockets and roller fixture race surface. Apply a light coat of oil on the rollers and roller fixture race surface and reassemble.

DO NOT USE GREASE

To reassemble reverse the disassembly process. Make sure the flat end of the rollers face the center of the tool and the roller/retainer assembly rotates freely.

Tool storage - after reassembly, place tool in polybags and put them in the carton to prevent any damage to the tool.