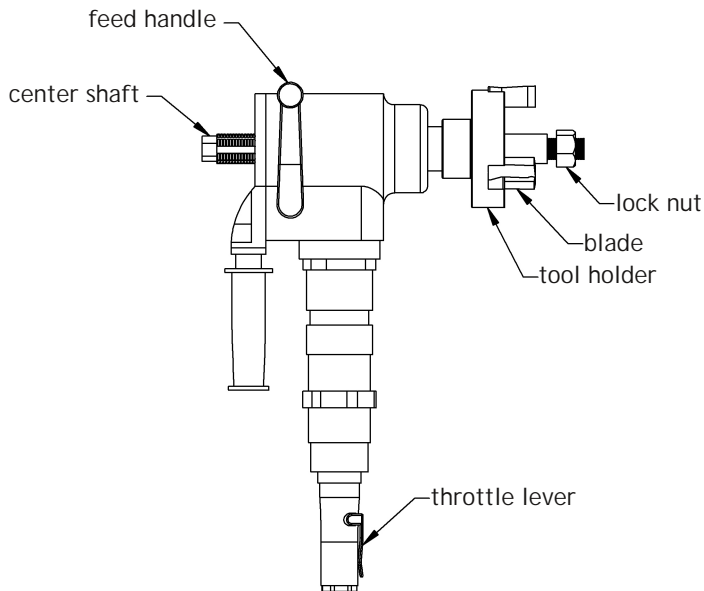


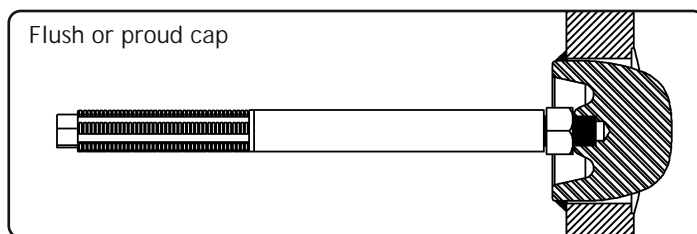
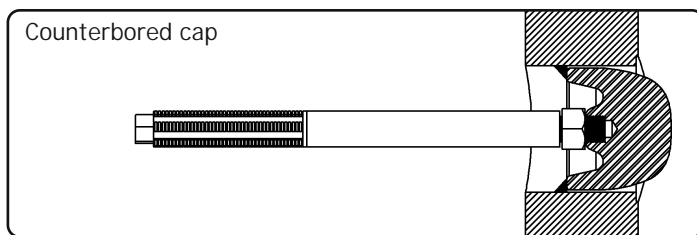
Set-up and Operating Instructions

MS Master Hand Hole (MSH) Cap Removal



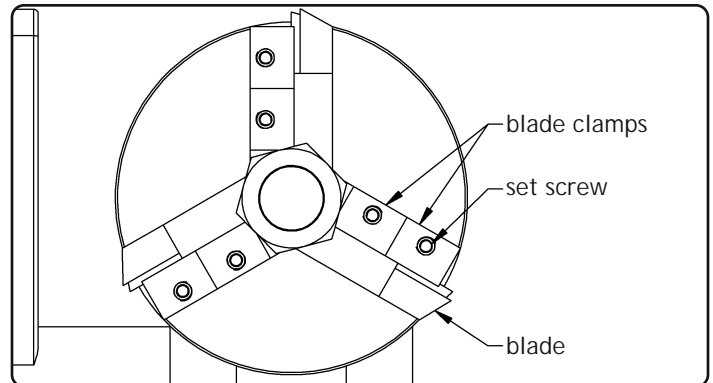
1. The machine ships with the center shaft in place. To remove, turn the feed handle counter-clockwise. Once the center shaft extends to around 4-1/2" past the tool holder it will be free of the machine.

2. Mounting to cap: Thread center shaft entirely into the boss of the cap. Tighten using a wrench on the opposite end of center shaft. The lock nut can now be tightened down against the boss.

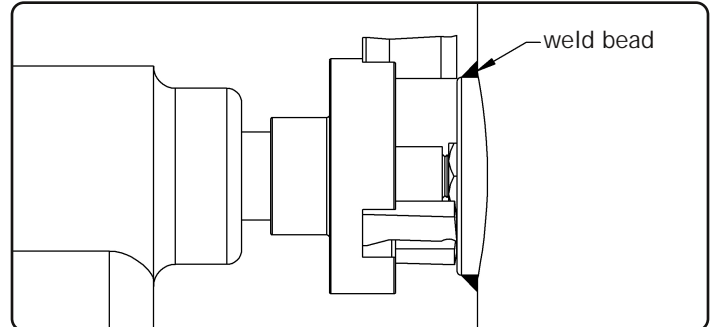


3. Slide the machine over the mounted center shaft and turn the feed handle clockwise to advance the cutting blades in towards the cap.

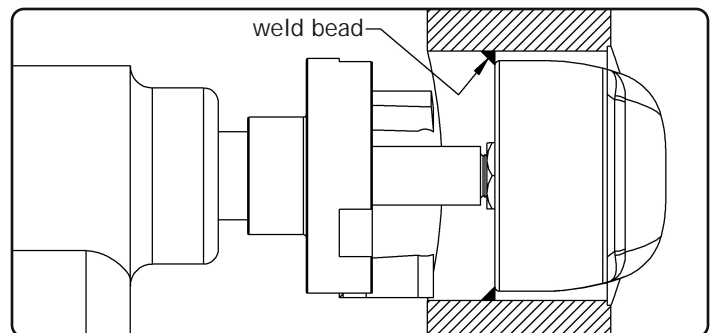
4. Adjustment of blades: Loosen the set screw holding the blade clamps to move blades in and out and adjust width of cut. NOTE: All (3) blades must be installed otherwise damage to the center shaft may occur.



In a flush or proud mounted installed cap adjust blades to outside wall of cap to remove the weld bead.



In a counterbore installed cap adjust the blades to be slightly smaller than the bore.



5. The machine is now ready for operation. Depress the throttle lever and turn the feed handle clockwise to advance the blades. Machine off the weld bead to free the cap.