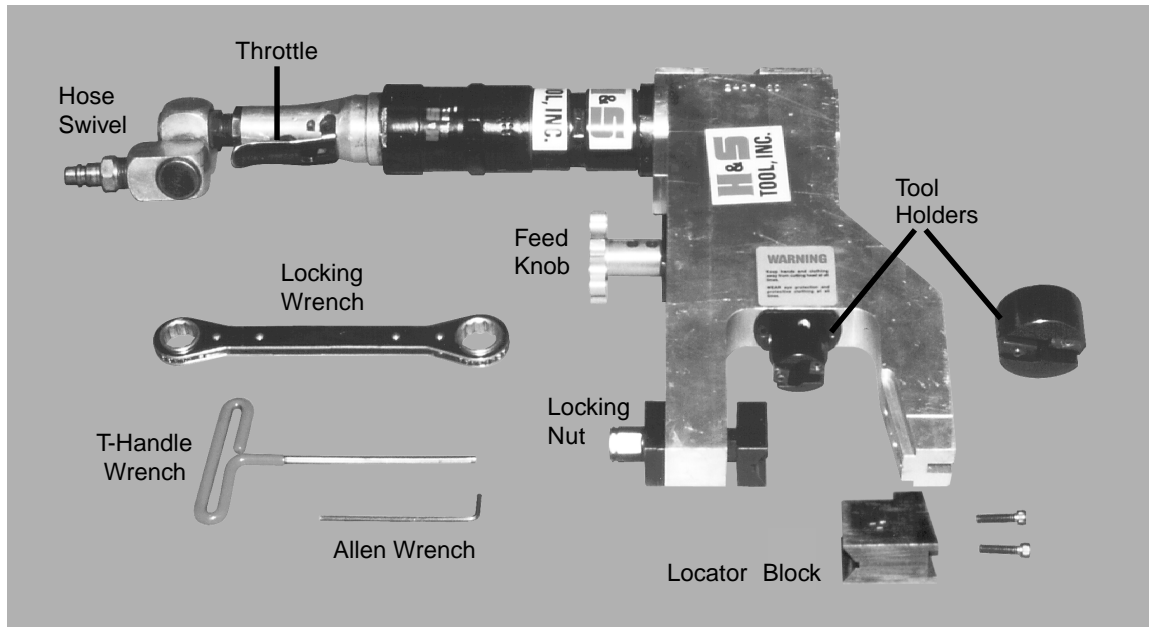




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## OPERATING RECOMMENDATIONS for MODEL OD

### COMPONENT DESCRIPTION



**READ THOROUGHLY AND UNDERSTAND THIS PUBLICATION BEFORE ATTEMPTING TO OPERATE THE EQUIPMENT.**

**DANGER!** The application of this product requires an exposed rotating tool holder and cutting blade. *It produces HOT, SHARP metal fragments requiring*

*that eye, ear, and hand protection and other protective clothing be worn at all times. Do not wear loose fitting clothing that may become entangled with the rotating objects. Only work on properly installed scaffolding or other approved work platforms, with approved safety belts, in elevated areas.*

### Tool Holder & Blades

Select the proper size tool holder for your application. The larger holder is generally installed on the machine at the factory unless otherwise specified. This covers the full range of the Model OD. The smaller holder is used in areas where the 2-1/4" (57.2 mm) holder is too large to fit between tubes.

The tool holder has an allen head setscrew and key. Installing the holder requires that the key be placed in the slot of the shaft and the holder slid on to the shaft, over the key, until it bottoms out. The set screw is then tightened securely.



Select the appropriate cutting blade. Loosen the small allen head setscrew with the allen wrench provided. The base of the blade slides in from the side (machined cutting edge facing the direction of rotation) and positioned to reach past the outside of the tube to be milled. The setscrew is then tightened securely.

## Locator Block Assembly

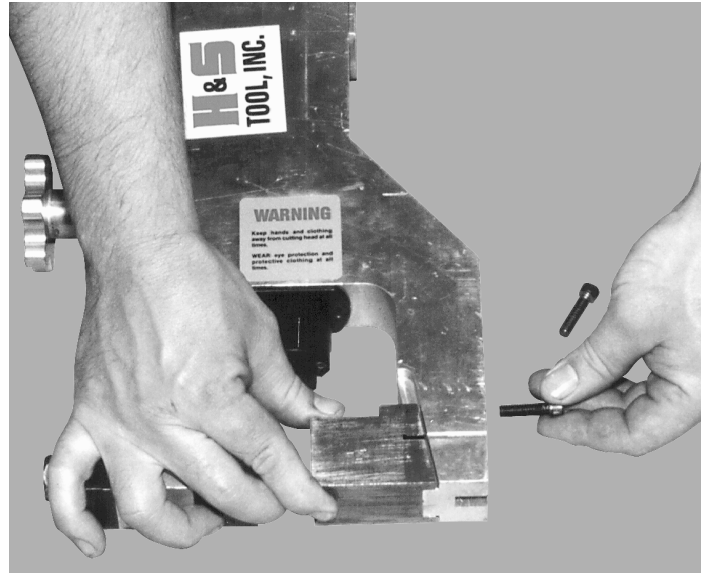
The saddle attached to the locking nut covers the full range of the tool. Locator blocks are available in 1/8" (3.2 mm) increments, starting at 3/4" (57.2 mm) tube OD. The tube size is stamped on the side of the block.

The block is placed on the frame of the tool and the two allen head setscrews are loosely threaded into the block through the slots in the frame.

Centering lines are machined into both the frame and blocks. Matching these lines centers the tool holder for true tube surfaces.

The frame and the block have angle surfaces that allow the block to be adjusted to compensate for warped and out-of-round tubes.

Set the block with the lines matching and tighten both setscrews with the T-Handle wrench provided.



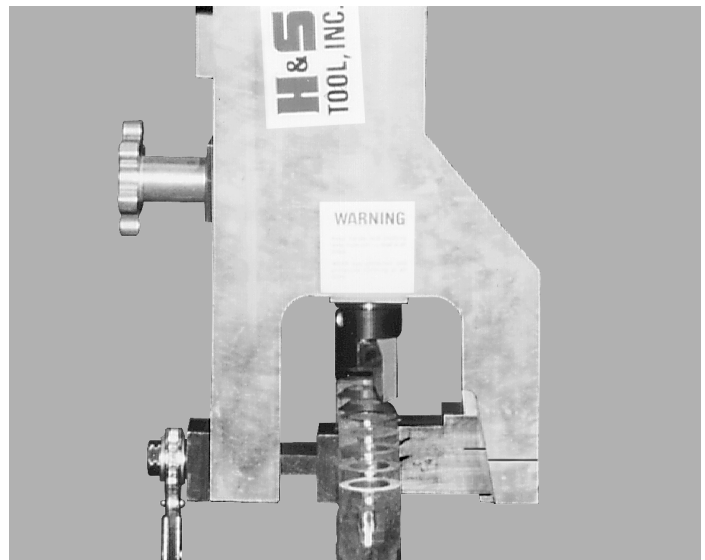
## Adjusting The Locator Block

Rotate the feed knob counterclockwise until the tool holder is fully retracted. Place the tool over the tube to be milled with the blade as close to the tube end as possible without it touching. Tighten the locking nut with the locking wrench provided.

Attach the air hose to the swivel. Depress the throttle handle fully. Rotate the feed knob clockwise until the blade begins to contact the tube end. Release the throttle handle. Inspect the tube end to ensure that the blade is cutting evenly around the outside of the tube. If not, the locator block must be adjusted to center the blade.

To adjust the locator block, loosen the locking nut. Then loosen the two set screws with the T-Handle wrench and slide the block up or down to obtain proper alignment. Tighten the set screws. Repeat the process, making only minor adjustments each time, until the blade cuts evenly.

Once properly positioned, mill the tube end to the desired height. Always start the rotation with the blade away from the tube end. Gradually feed the blade into the tube end and maintain even pressure throughout the cut.



Loosen the locking nut and move the tool to the next tube. Repeat the centering procedure to ensure proper alignment before each cut.

## Maintenance

Always use the portable H & S Air Caddy oiler/filtration system or a quality in-line air oiler.