2. If adjustment is necessary loosen socket head set screw (20) and set micrometer (19) at 5.000.

3. Slide micrometer (19) snugly against setting standard (41) and tighten socket head set screw (20).

4. As a further check, back-off thimble on micrometer (19) and recheck reading.

SETTING THE CUTTER

1. Loosen socket set screw (17) in back-end of cutter (13) and push spring-loaded adjusting pin (15) all-the-way in. Tighten socket set screw (17).

2. Using the Micrometer Block (18) set the micrometer to the following sizes depending on the block you are to bore:

MH & V12, 5-1/2 bore	6.750 dia.
Vim-Vine, V-903	6.625 dia.
H, NH, V12, 4-7/8 or	
5-1/8 bore	6.275 dia.

NOTE: Final cut inside diameter must be within plus or minus .001 inch of above dimensions.

3. Place cutter (13) in MIKE Block (18) as shown in Dwg. 1 firmly against cutter stop (21).

4. Loosen cutter socket set screw (17) and allow adjusting pin (15) to snap out against micrometer spindle. Lock socket set screw (17).

5. As a further check, back-off thimble on micrometer and recheck cutter length again. Back off on micrometer to remove cutter.

PREPARING THE BLOCK

1. Steam clean the block and remove all top deck dowels.

2. Remove all burrs and high spots from top deck with a large mill file. Finish dress with a flat stone.

3. Remove all dents or burrs from the counterbore inside diameter to be cleaned with an emery cloth. This area is used to locate the tool.

ASSEMBLING THE TOOL

1. Select the correct cutter plate (10 or 32) to be used.

2. Assemble cutter plate (10 or 32) on shaft of the main housing (1) and secure with nut (26) and washer (27). See Fig. 4.
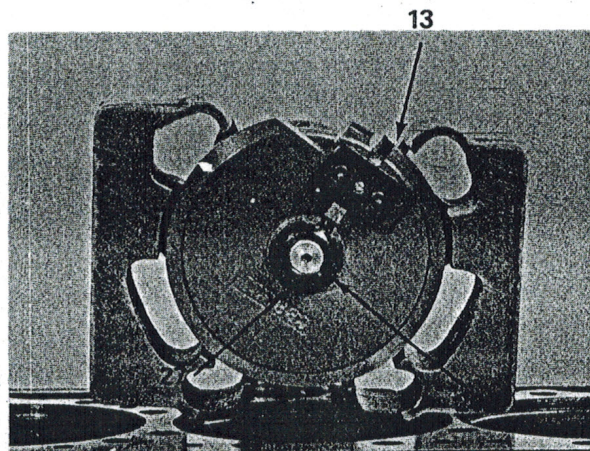

Fig. 4 Attaching the Cutter Plate

MACHINING THE BLOCK

1. Making sure the cutter (13) is removed from the cutter plate (10 or 32), place the boring machine on the cylinder block above the bore to be cut and start mounting the head cap screws, leave loose. The stud adapter (23 or 33) must be on the cap screws. (See Fig. 5).
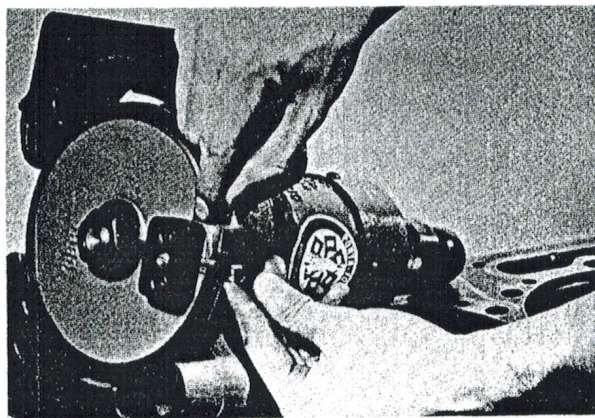

Fig. 5 Preparing to Install Cutter