

2. Lower the cutter plate (10 or 32) into the bore by turning the valve knob (9) counter-clockwise while pushing down.

3. The cutter plate lower diameter is used to center the boring machine in the counterbore. Push cutter plate lower locating diameter into the counterbore and now tighten the four head cap screws alternately to 50 ft. lbs. torque. (See Fig. 6).

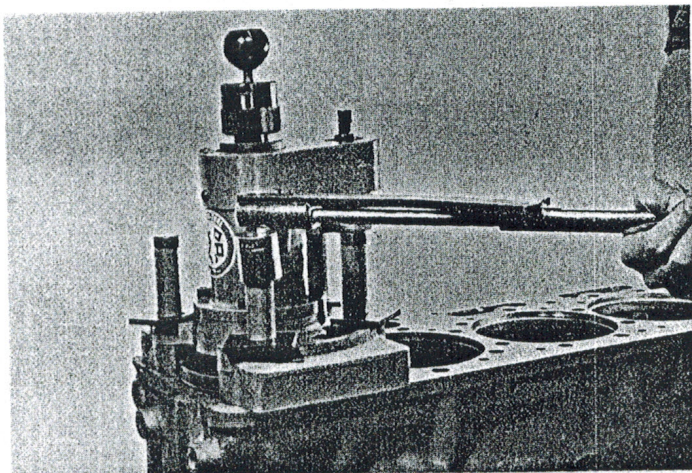


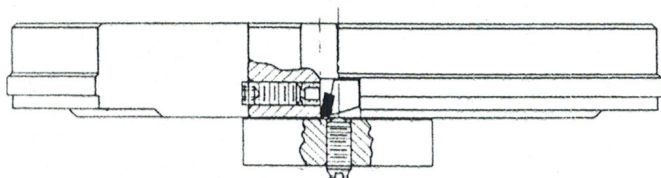
Fig. 6 Mounting Porta-Matic on Block

4. Retract cutter plate (10 or 32) by pulling up on the needle valve knob (9). Once the cutter plate (10 or 32) is at its highest position lock in place by turning the valve knob (9) clockwise till snug.

5. Insert cutter (13) into cutter plate (10 or 32) and tighten cutter plate swivel pad set screw (14). The cutter (13) must be held all the way in against the main shaft of the boring tool. (See Dwg. 2).

**NOTE:** The sharp tip of the cutter must be inserted into the slot in the cutter holder with the tip in the lower left side of the slot.

**NOTE:** The cutters have a shallow hole in them. This must face downward when the cutter is inserted in the slot.



Dwg. 2 Inserting Cutter

6. Place a 0.004 inch feeler gauge between the block and the cutter (13). Lower the cutter (13) onto the feeler gauge by turning the needle valve knob (9) while pushing down very gently. (See Fig. 7).

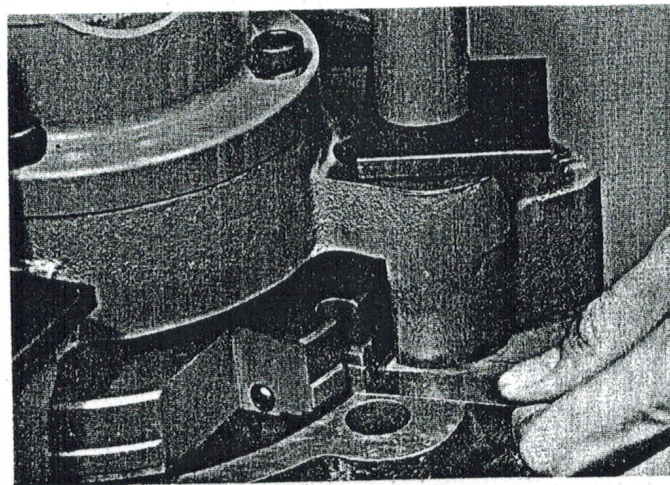


Fig. 7 Use of Feeler Gauge to Set Depth of Cut

7. Loosen the socket set screw (43) on the depth set collar and back-off the depth set collar (8) counterclockwise. Place the bushing to be used between the depth set collar and the sprocket and adjust depth set collar down to bushing, tighten socket set screw.

This spaces the depth set collar (8) to cut to a depth 0.004 inch less than the total height of the salvage bushing to be used.

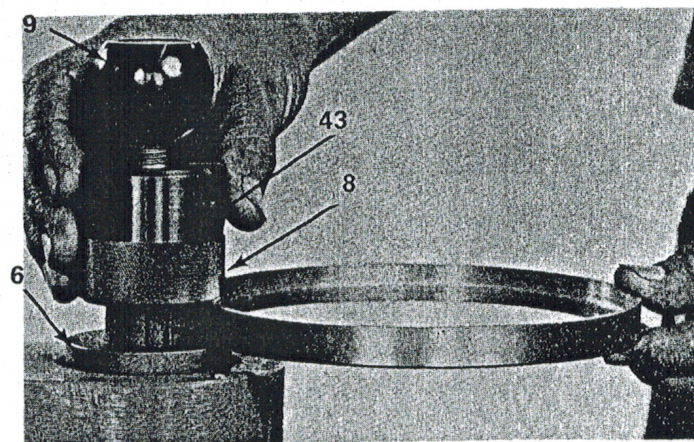


Fig. 8 Setting Length of Cut

8. Remove the feeler gauge from below cutter (13) and pull up on needle valve knob to return cutter to top position. Turn needle valve to right to close valve to hold it in "UP" position.

9. Chuck the 1/2 inch universal drive adapter (40) in a 1/2 or 3/4 inch heavy duty (10 amp. or more) hand drill.