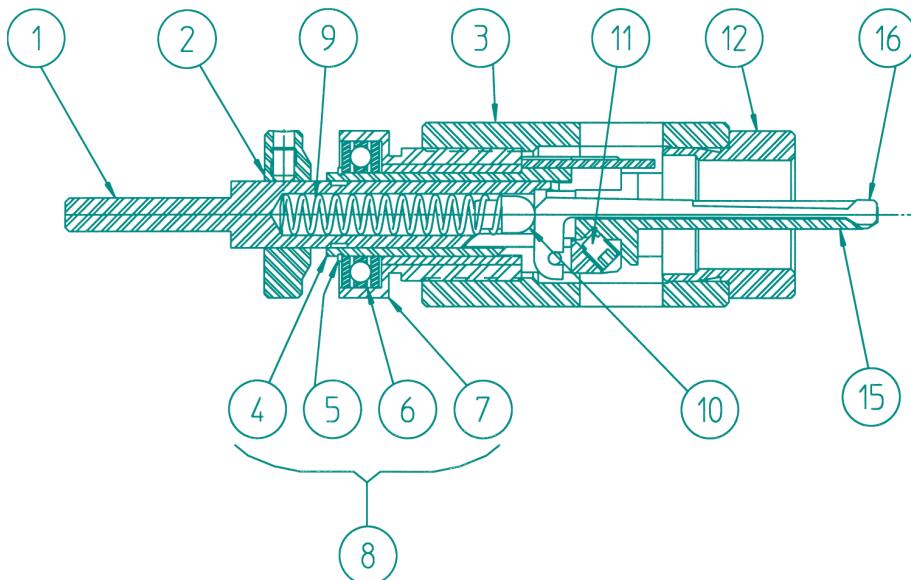


Assembly/Operating Instructions

Nobur® JB Back-Chamfering Tool

JB



- 1- Body Holder
- 2- Stop Nut
- 3- Stop Collar
- 4- Keyed Transport Sleeve
- 5- Retaining Ring
- 6- Ball Thrust Bearing
- 7- Bearing Cage
- 8- Transport Assembly
- 9- Compression Spring
- 10- Ball (19/64) diameter
- 11- Pilot Retaining Screw
- 12- Stop Collar Extension
- 15- Pilot
- 16- Blade

To assemble components into a complete tool:

1. Remove stop collar (det.3) by loosening the set screw at the top of the stop collar. Unscrew the collar from the bearing cage (det.7). The stop collar extension (det.12), if installed, will come off with the stop collar.
2. Unscrew the pilot retaining screw (det.11); this only needs to be backed out a few turns - it is not necessary to remove this screw. Insert the cutter blade (det.16) into the open end of the body holder (det.1) and on top of the spring ball plunger (det.10). Hold the blade at a slight angle with the side arm down and oriented so that it will enter the slot and engage the cross pin in the body. Compress the spring (det. 9) with the blade until the blade enters the body.
3. Once the spring is sufficiently compressed, pass the side arm of the blade under the pin and hook the notch on the top of the blade side arm onto the cross pin. The blade is now installed and can be released. Notice that the blade will angle slightly toward the cross pin due to spring pressure.
4. Next, install the pilot (det.15) by inserting the blade into the long slot on the pilot. Be sure to have the pilot oriented so that the hole in the bottom face of the pilot flange lines up with the small pin on the face of the body holder (det.1). Push pilot into the body holder (det. 1) until it seats, then tighten the pilot retaining screw (det. 11).

(Continued on back)

5. Re-install the stop collar (det.3) by screwing it onto the bearing cage (det.7). Adjust for the correct cutter projection needed for your part thickness by screwing the stop collar on until the correct length is obtained, then tighten the stop collar retaining screw. If the stop collar extension (det.12) is installed, the tool can be adjusted for use in material thickness ranging from 1/32 to 1/2 in. (.79 to 12.7mm). With the stop collar extension removed, the tool can be adjusted for use in 1/2 to 1 in. (12.7 to 25.4mm) thick material. Notice the micrometer-adjustment markings at the top of the stop collar. Use these as reference markings for making small adjustments.
6. The cut stroke of the tool is adjusted by the stop nut (det. 2). Simply adjust this nut so that the cutter moves radially outward enough to cut the desired chamfer. For deeper cuts move the stop nut toward the shank end of the tool. For shallower cuts move the stop nut toward the workpiece. The maximum cutting stroke on the blade is about .050 in. (1.27mm) for most sizes.

To remove blade or pilot:

1. Loosen set screw and remove detail 3 stop collar.
2. Loosen set screw at the bottom of detail 15 pilot and remove - be careful of the blade cutting edge.
3. Tape blade cutting edge or use cloth to protect your fingers while pushing detail 16 blade down on detail 10 ball. Unhook and rotate the used blade around to remove from the unit.

To install blade:

1. Tape blade cutting edge or use cloth to protect your fingers while pushing down on the new detail 16 blade. Push down on detail 10 ball and rotate blade around to engage pin on detail 7 (bearing cage).
2. Locate blade into slot of detail 16 pilot. Push down into unit and tighten set screw.
3. Put detail 3 stop collar back on and set depth.



COGSDILL TOOL PRODUCTS, INC.

Mailing Address:

P.O. Box 7007
Camden, SC USA 29021-7007
Ph. (803) 438-4000
Fax (803) 438-5263
cogsdill@cogsdill.com

Shipping Address:

1001 Guion Drive
Lugoff, SC 29078

COGSDILL-NUNEATON LTD.

Tenlons Road
Nuneaton, England CV10 7HR
Ph: +44 (0) 2476 383792
Fax +44 (0) 2476 344433
sales@cogsdill.co.uk

www.cogsdill.com