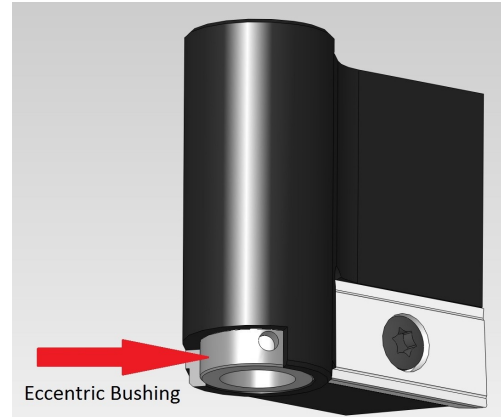




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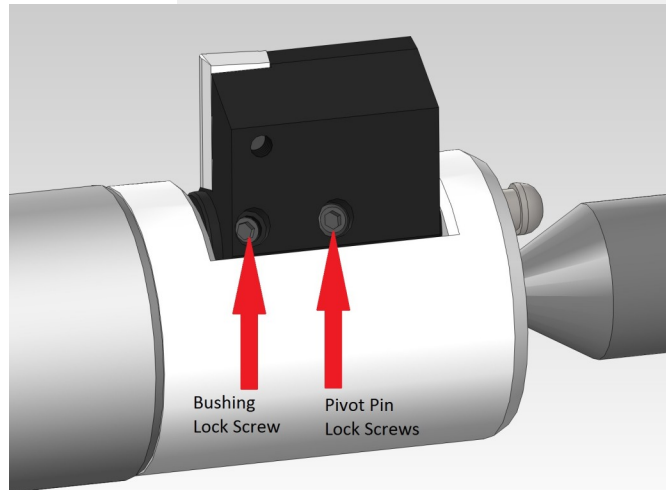
## Setting Your Adjustable Master Holder or Cutter Blade

Your Adjustable Master Holder or Cutter Blade is equipped with an Eccentric Bushing. By rotating the bushing, the blade can be adjusted in or out. A set screw keeps the bushing locked in place after the cutting diameter has been set.

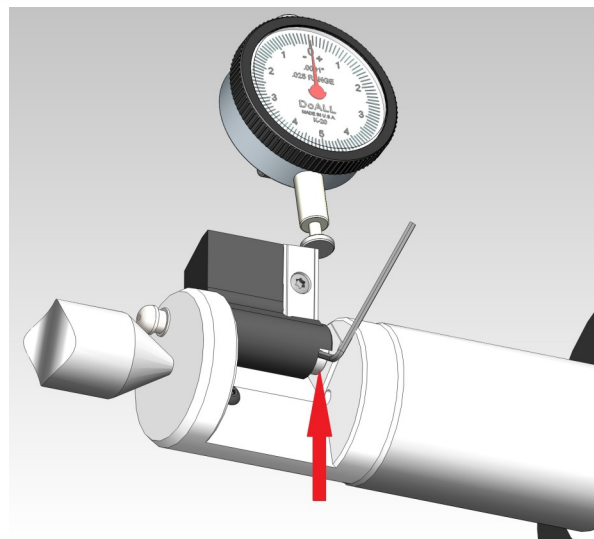


For best results, mount your Autofacer between centers on a surface plate. Make sure the blade is installed correctly and is locked onto the flat of the pivot pin (see "Cutter Blade Installation Instructions").

**Slightly** loosen all set screws. Using a known diameter (usually the pilot diameter which is held within .0005"), calculate cutting radius from centerline of tool.



Using a hex wrench or something similar, rotate the Eccentric Bushing until required cutting radius is met. Re-tighten the set screw that is closest to the shank of the Autofacer to lock the Eccentric Bushing into place. Then re-tighten the Pivot Pin lock screws located midway between the width of the blade.

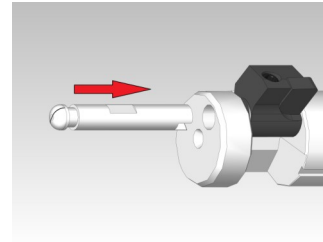


# IMPORTANT

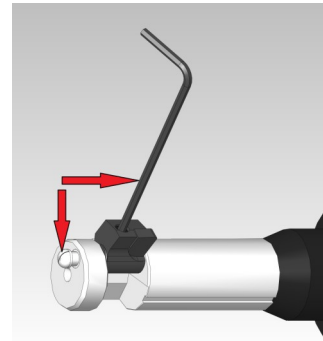
**Reliability of Autofacer depends on cutting blade being locked onto flat of Pivot Pin**

## **Cutter Installation Instructions**

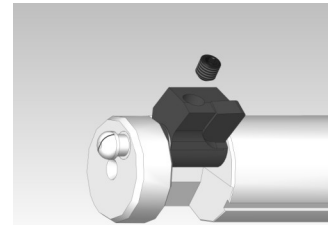
Insert pivot pin into Cutter Body and Blade. Turn Pivot Pin until it engages tang of Activating Rod.



With blade in open position, rotate clutch of tool until the alignment mark line on the pivot pin is aligned with hex wrench and set screw in blade. This will ensure that set screw is aligned with flat on Pivot Pin. (For pivot pins without alignment mark, remove screw completely and visually verify that tapped hole is lined up with flat).



Apply a small amount of serviceable Loctite provided to thread of screw. Hand tighten set screw, being careful not to overtighten. If second follow-up screw is provided, install and hand tighten.

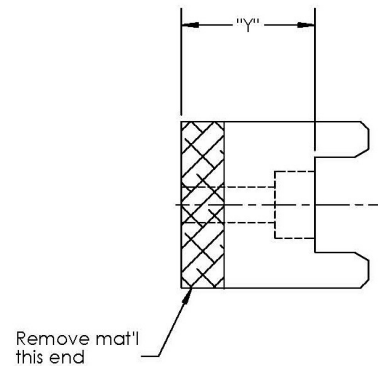


**TIP:** To verify that set screw is located on flat of Pivot Pin, loosen set screw slightly and attempt to pull Pivot Pin out of tool. The pin should only be able to slide until the set screw gets caught on the end of the Pivot Pin flat.

## Torque Bar Driver Installation Instructions

### 1. Mount Stop Block to machine spindle face

- A. Length of Stop Block as well as bolt hole size may need to be altered before installation due to variations in spindle configurations.
- B. Remove the spindle nose bolt where the Stop Block will be installed. **Make sure to choose a bolt location where the Stop Block will not interfere with tool changer arm.**
- C. Remove retention knob from Torque Bar Driver.
- D. Insert Torque Bar Driver into machine spindle.
- E. Measure the distance from the machine spindle face where the Stop Block will be mounted to the face of the Connector Pin on the Torque Bar Driver. This will be distance "X".
- F. Add .175" to distance "X". The result is what you must make distance "Y" shown at right.
- G. Machine Stop Block to proper "Y" length.
- H. Install Stop Block to spindle face using existing screw. Make sure slot in Stop Block is parallel to the radius of the spindle. Bolt hole in Stop Block may need to be opened up. Longer than original screw may need to be used.



### 2. Install Torque Bar Driver

- A. Verify that the Connector Pin offset distance ("R") shown at right matches the bolt circle radius on the machine spindle face.
- B. Remove retention knob from shank.
- C. Loosen the three set screws that lock the Orientation Ring in place so that the complete housing and Connector Pin can rotate freely.
- D. Insert Torque Bar Driver into machine spindle and rotate the housing assembly until the Connector Pin meets up with the Stop Block.
- E. Tighten the three Orientation Ring set screws.
- F. Verify that the Connector Pin is being compressed by the Stop Block and that it is fully disengaged. The shank and spindle should be able to rotate freely.
- G. Verify that the Connector Pin is not being over compressed as there is a limited amount of travel.
- H. Install retention knob back into shank and install Autofacer into Torque Bar Driver.
- I. Make sure Torque Rod coming off Autofacer goes in between the two Driver Rods on Torque Bar Driver.

