

Deburring Tool - Bur Setting Fixture Instructions

The 9150-RC-T-4230 tool is used to set and replicate the exposed length of cutting burs used with ATI's radially compliant deburring tools (RC/RS-300, -340, -660, etc).

1. Replacing the Bur Using the Bur Setting Fixture

Parts required: Replacement Bur

Tools required: 29150-RC-T-4230 Bur setting Fixture, open-end wrenches for the Collet

1. Remove and/or lock-out the spindle motor air supply for safety.
2. On the bur setting fixture, loosen the jam nut and thumb screw, then hold the fixture against the collet nut.



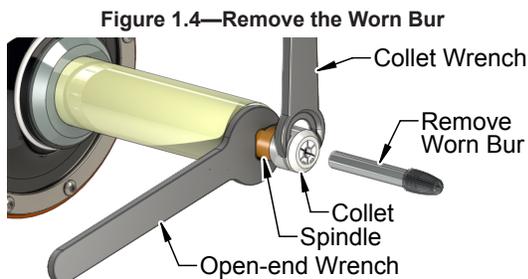
3. While holding the fixture against the collet nut, adjust the thumb screw until it contacts the tip of the cutting bur.



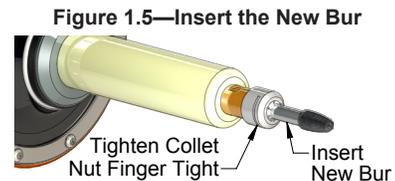
4. Tighten the jam nut against the fixture to secure the thumb screw position. Then remove the fixture.



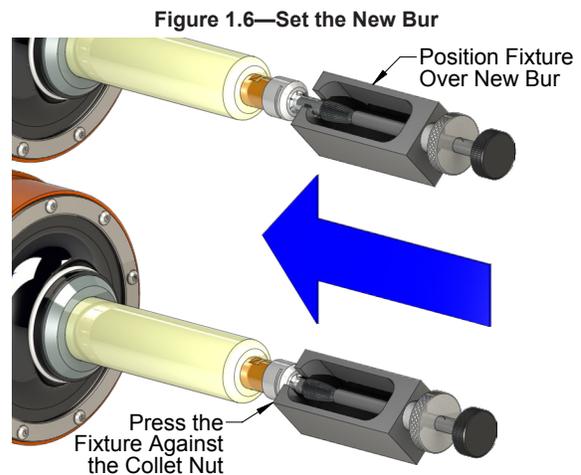
5. Use the open-end wrench to hold the spindle just behind the collet nut.
6. Use the collet wrench to turn the collet locknut counterclockwise (when viewed from the cutter tip) to loosen the collet and pull the worn bur out of the loosened collet.



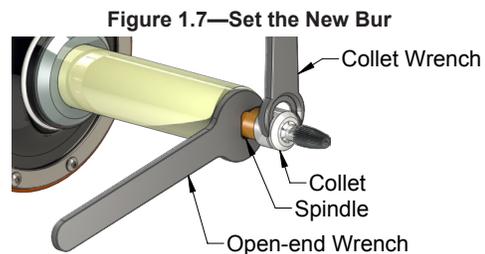
7. Insert the new bur leaving it out of the collet further than its initial position. Tighten the collet nut finger tight, so it snugs the bur in the collet. The bur should move with a little force, but stay in position when released.



8. Position the bur setting fixture over the bur.
9. Gently press the fixture downward against the collet nut. The bur will slide deeper into the collet until the fixture presses against the collet nut.



10. Remove the fixture and fully tighten the collet nut.
11. Use the open-end wrench to hold the spindle just behind the collet nut.
12. Use the collet wrench to turn the collet locknut clockwise (when viewed from the cutter tip) to tighten the collet.



13. If repair is complete, return to normal operation.