

Tool Case Contents

- Coning Tool
- ID Deburring Tool
- 1/4, 3/8, and 9/16 in. Collets
- 1/4, 3/8, and 9/16 in. Tool Bits
- 3/32 in. Allen Wrench
- Lubricant with MSDS

Operating Instructions

Refer to Fig. 1 during these instructions.

1. Turn the **notched wheel** against the **gauge pin**.
2. Completely insert tubing. Tighten the collet by turning the **collet handle**.
3. Apply lubricant into **lubricant hole** as needed.
4. Turn the **handle** clockwise, moving the **notched wheel** one notch for every three turns of the **handle**.
5. When the **notched wheel** is against the **body** the coning operation is complete.
6. Loosen the **notched wheel** and remove tubing.
7. Inspect work. A proper cone has ends that are faced and smooth, free of any scratches and leave-off marks. See Fig. 2.
8. After every 15 to 20 coning operations, unscrew the **reservoir** to empty it of lubricant and chips.



Fig. 2

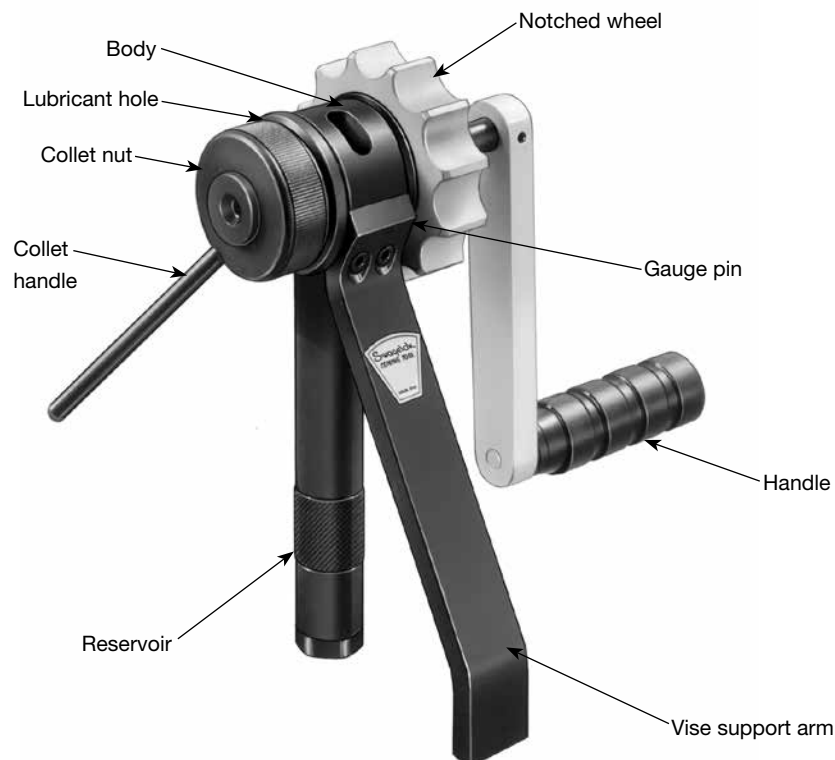


Fig. 1

Maintenance Instructions

Disassembly of Tool Holder for Replacing or Resharpener Tool Bit

1. To remove tool holder, turn the **notched wheel** counterclockwise and remove assembly. See Fig. 3.



Fig. 3

2. Loosen **lock screw** with provided allen wrench and remove **tool bit**. See Fig. 4.

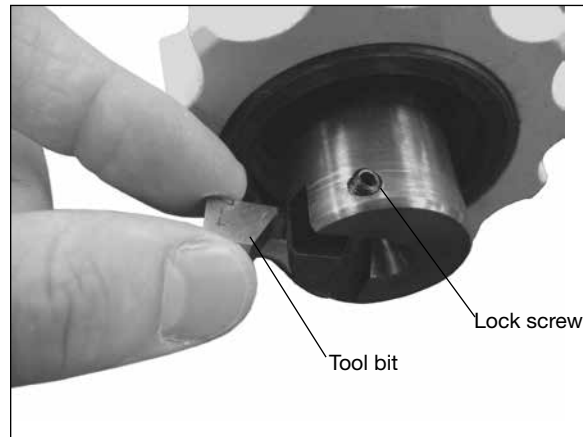


Fig. 4

3. To re-sharpen tool bit, grind on top surface (side opposite the lock screw). See Fig. 5.
Contact your local authorized Swagelok sales and service center for replacement bits.



Fig. 5

4. Clean all parts before re-assembly.
5. To re-assemble, place top surface of tool bit opposite lock screw, tighten lock screw, and replace notched wheel assembly.