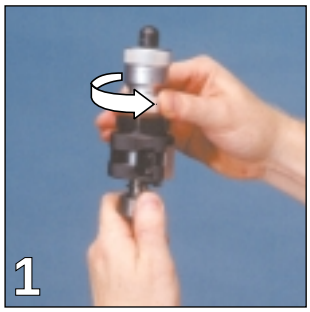
Working instructions *multicut** precision tools

Before using ***multicut**** to work on leakproof surfaces, you must choose the appropriate steel profile, which must correspond to the diameter of the leakproof surface (see steel profile data sheet). Insert the steel profile into the ***multicut**** as shown above (inscription must be legible). Clamp the steel profile in place by turning the two set screws with a fitting Allen key.

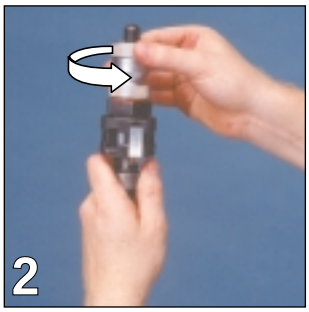
Avoid damage to the cutting edge of the steel profile. Damaged cutting edges affect the surface quality of the leakproof surface.

The steel profile can be reground by hand. Please note that the angle which the cutting edge has in relation to the bearing surface must, in the case of flat leakproof surfaces according to DIN 3852, form X or Y, always measure 90°. Too much deviation from this angle can impair the function of the leakproof surface.

In order to assure a constant high surface quality, please use only original ***multicut**** steel profiles with relief of the tap.



Grasp the ***multicut**** with one hand at the screw thread and turn the thrust piece with the other hand to the left (counterclockwise), until the cutting edge of the steel profile is far enough away from the thread shaft (normally approx. 5-7 mm).



Grasp the ***multicut**** with one hand at the screw thread and turn the straining ring to the left (counterclockwise) with the other hand until you feel the stop. Do not use force!

Press the cap slightly with the ball of the hand to release the pulling bolt and bring the thread shaft into the home position.

The thread of the bore hole must not be damaged. If necessary, rethread with a suitable screw tap. Grasp the ***multicut**** at the base part and the thrust piece. Screw it into the bore hole.

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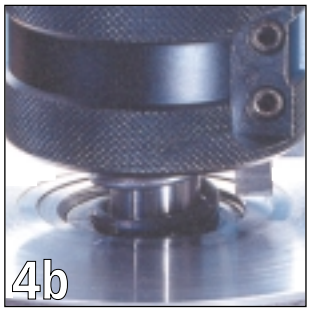


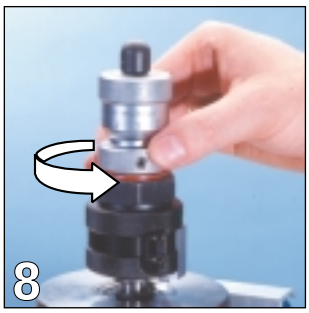
In order to avoid damage to the thread shaft, make sure that you screw in the thread shaft to a greater depth than you plan to subsequently trim off the material to.

Grasp the ***multicut**** with one hand at the thrust piece and at the base part. Turn the straining ring to the right (clockwise) with the other hand until you have definitely clamped the thread shaft and affixed the ***multicut****.

It can be useful to oil the surface of the work piece before assuming work!
Turn the thrust piece to the right until the steel profile comes into contact with the surface of the work piece.

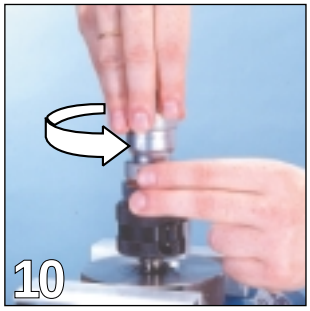
Turn the base piece occasionally in order to check if the steel profile is “free” within a range of 360°. This is recommended in case the axis of the bore hole is not squared to the surface of the work piece and an initial chip removal is expected.

When the steel profile comes into contact with the surface of the work piece, turn the base part continuously with a suitable fork or ring wrench, thus turning the steel profile around the center line to the right (clockwise), and increase the depth by using the other hand to turn the thrust piece to the right (clockwise) along the small scale marks (one rotation corresponds to 0.5 mm depth increase, one scale mark corresponds to 0.01 mm).
Continuously turn the base part and repeat the depth adjustment until you have reached the desired depth of the leakproof surface.
Turn the base part several times without adjustment until the steel profile has “cut itself free”.



Lay the fork or ring wrench aside and turn the thrust piece to the left (counterclockwise) approx. 3-5 rotations in order to lift the steel profile up off of the work piece surface.

As a general principle, we recommend removing any swarf which has accumulated before you unscrew the ***multicut**** from the bore hole.



Turn the straining ring to the left (counterclockwise) until you feel the stop, thus unblocking the axial mobility of the pulling bolt.

You can release the pulling bolt by lightly tapping the cap with a fork or ring wrench and the thread shaft springs back into its home position.

Attention!
Only let the fork or ring wrench tap the cap with its own weight in order to avoid damaging the *multicut!**

Grasp the ***multicut**** at the base part and the thrust piece. Unscrew it from the bore hole. Make sure that the pulling bolt stays unblocked.

To oil or lubricate the ***multicut****, hold it on one hand and push the base part against the pressure spring, so that you can see the thread shaft.
Oil or lubricate the section of the thread shaft which is visible and let the base part slide back into its original position.

If, during use of your ***multicut****, you should notice that when you turn the base part, the thrust piece turns along with it, adjust the pressure by means of the set screw. Use a suitable Allen key for this purpose.

Guarantee
We guarantee perfect function at delivery of the tool. We cannot guarantee perfect functioning or take responsibility for the consequences if the ***multicut**** is improperly handled or serviced, particularly if the original steel profiles are not employed.

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