

# COOL CLEEVE INSTALLATION GUIDE

Fit is important to carefully follow these instructions.

Improper use may result in damaging the machine tool turret or injury to the operator.

Steps for proper installation of the Cool Cleeve are as follows:

Cut the coolant fed tool to the proper length. Leave .700 to .750 sticking out of the back of the tool block or boring bar sleeve. This will be the amount the tool will be inserted into the cool cleeve. For shorter coolant fed tooling it may be necessary to use a shorter boring bar sleeve. Omit this step if coolant pressure is under 50 psi. If it is a high pressure coolant system , it may be necessary to grind a small notch on each rod flat. The notches should be aligned with the series of set screws. Do not grind deep. Insert the tool through the boring bar sleeve. Make sure there are no burrs around the tool. Press the tool into the Cool Cleeve by hand. Do not release until all set screws are tight. A leak will occur if the tool is not tightly held against the seal. Insert the assembly into the tool block. If the Cool Cleeve is larger than the tool block I. D., put the Cool Cleeve on after inserting the tool through the tool block. Tighten one 1/8" NPT compression fitting into the back of the Cool Cleeve. Some Cool Cleeve sizes may have an existing hose barb. Piping to the Cool Cleeve may be accomplished with copper tubing or a rubber hose. this will depend on the Cool Cleeve configuration. It is recommended to use copper tubing for higher pressure systems. For extremely high pressure 1,000 psi refer to the original pump manufacturer for proper hose and clamping material. Make sure all hoses and clamps are tight. Test unit by turning the coolant on and off several times before machining first part.