

Boyd Machine Co. Inc.

Installation of Accessories

Installation of Cutter and Bushing-

1. Disconnect power from machine.
2. Remove quick clamp assembly (see installation of quick clamp assembly instructions.)
3. Manually rotate spindles to position set-screw(s) for access.
4. Slip locking wrench into slot in top cover above right-hand spindle. Rock spindle, using ½ nut driver (supplied), to assure that locking wrench is engaged.
5. Use 3/32" Allen wrench to loosen set screw a half turn.
6. Gently! Push cutter toward rear of machine about 1/8 inch using wooden or soft-tipped instrument. Never push on carbide edge with metal!
7. Remove hex bushing from spindle end with ½" hex driver (supplied with machine).
8. Eject old cutter using "T" handle push rod inserted into rear access hole of spindle. Push gently and slowly to avoid damage to cutter. If cutter snags, loosen set screw more. If still unable to remove, re-set to rear and blow out any chips in spindle. Proceed as above to remove cutter.
9. Insert new cutter into spindle, with flat horizontal, pushing very gently with soft-faced instrument – preferably eraser end of pencil. If cutter does not slide easily, remove and blow out any chips.

BOYD
Precision CNC Machining

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10. Making sure cutter edge is recessed beyond threaded part of spindle, install appropriate guide bushing and tighten securely.
11. Very gently position cutter against guide bushing. Hold with light pressure while snuggling set-screw to align flat. Tighten securely.
12. Remove locking wrench.

Installation of Jaws and Quick Clamp Assembly –

1. Remove power from machine.
2. Remove screw from left side of quick clamp assembly.
3. Lift quick clamp assembly from traverse block.
4. Install appropriate jaws for cable to be stripped.
5. Inspect and clean, if necessary, mating surfaces of quick clamp assembly and traverse block. Check alignment pin of clamp block for burrs and irregularities. Dress to remove anything which will damage mating hole in traverse block.
6. Gently lower clamp block assembly onto traverse block while guiding pin into hole – do not force.
7. After seating clamp block, firmly hold in place while tightening holding screw.
8. Strip a sample piece of cable to determine if block assembly is aligned. If cable center conductor is damaged, repeat steps 1 – 7.

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Attaching Chip Collector Assembly-

1. Loosen two front screws on left side cover of machine.
2. Slide chip collector cover over screws and slide down to lock cover in place. Tighten screws.
3. With screened opening at top, facing rear of machine locate bottom pin of chip collector can in hole of cover. Push top of can inward to snap into place.

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