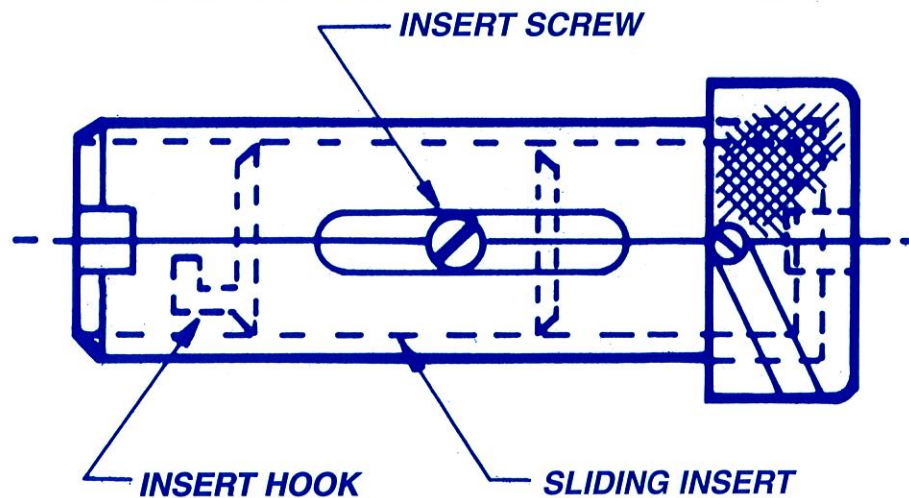


DIRECTIONS FOR INSTALLING THE TENNESSEE ABRASIVE T-1000 ADAPTER



The Tennessee Abrasive T-1000 Adapter is made to adapt Superior-type Mandrels and Stones (from .060 to 3" Dia.) to Sunnen Honing Machines.

The one adapter is the only one needed and is installed as follows:

Turn the machine spindle until the spindle set screw is on top. This places the feed rod in a vertical position. Now take the T-1000 Adapter and the hook end of the sliding insert in a horizontal position and with your right index finger holding the insert screw, slide the T-1000 Adapter into the spindle. This makes a "T" with the machine feed rod vertical and the adapter insert hook horizontal, slide the adapter back, (while holding the large insert screw), until the adapter insert hook engages the machine feed rod and turn the adapter a quarter turn to the right, thereby locking the machine feed rod, and body back into the spindle about 1/4" farther, the T-1000 Adapter should now be engaged. Tighten the set screw firmly and not tight enough to bind the sliding insert, and you are now ready to use Superior-type Mandrels in the Sunnen Machine.

IMPORTANT: For 33% more stone life, on mandrels 3/8" and larger, see the following:

Superior-type Mandrels are set as follows:

You will notice there is a 5/16" hole and a bayonet hook in the mandrel. These two mandrel positions must be used on mandrels 3/8" and larger because the Sunnen Machine does not have enough expansion to use up all the stone life that Superior-type Stones have. Therefore, the insert screw in the T-1000 Adapter is always placed through the 5/16" hole first. This starts the mandrel in the #1 position. After the stones have been expanded to the machine limit (on mandrels 3/8" and larger only) remove the insert screw and install the mandrel, using the bayonet hook. This additional expansion then allows you to utilize all of the stone life. Your machine operation has not been changed by this adaption.

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