

BTS INSTRUCTIONS

The BTS comes completely assembled, other than attaching the fluid line to your fluid nozzle, you're just about set. Because of the many different sizes of coolant lines and fittings of machines you will have to supply these parts. This can be accomplished in one of two ways. Mount directly to your existing fluid line or put in a "T" fitting with a shut off valve. This will allow no disassembly of fluid lines and runs both at the same time if need be.

After this has been accomplished you are ready to chamber with the flood coolant adapter. First mount your barrel and adjust to run true with bore, chamber and muzzle ends. Then and only then do you mount the adapter. If you center drill muzzle 60 deg. a very small amount this will aid in a perfect seal. That's, assuming you haven't already crowned the muzzle to length.

First loosen the thumbscrews so the adapter will slide over barrel. Then making sure that the rubber tip of adapter seats into bore of barrel, apply pressure so rubber tip is pre-loaded with spring tension. A good starting point is to compress spring all the way then back off about a 1/4 of spring travel. While holding in this position tighten all four screws evenly to center adapter to barrel. Which means, screw pressure and thread length. DO NOT OVER TIGHTEN! You will be surprised at the holding power. Finger tight is plenty. Also double stack swivel assembly. See picture above.

That's it. Turn on fluid supply and lathe. Chamber ream as your convictions lead you to accurately complete the job. Always go slow when trying something new. Haste makes waste. The adapter will work with rpm's up to 750, with no problems. It's simple, fast, and it works flawlessly.