

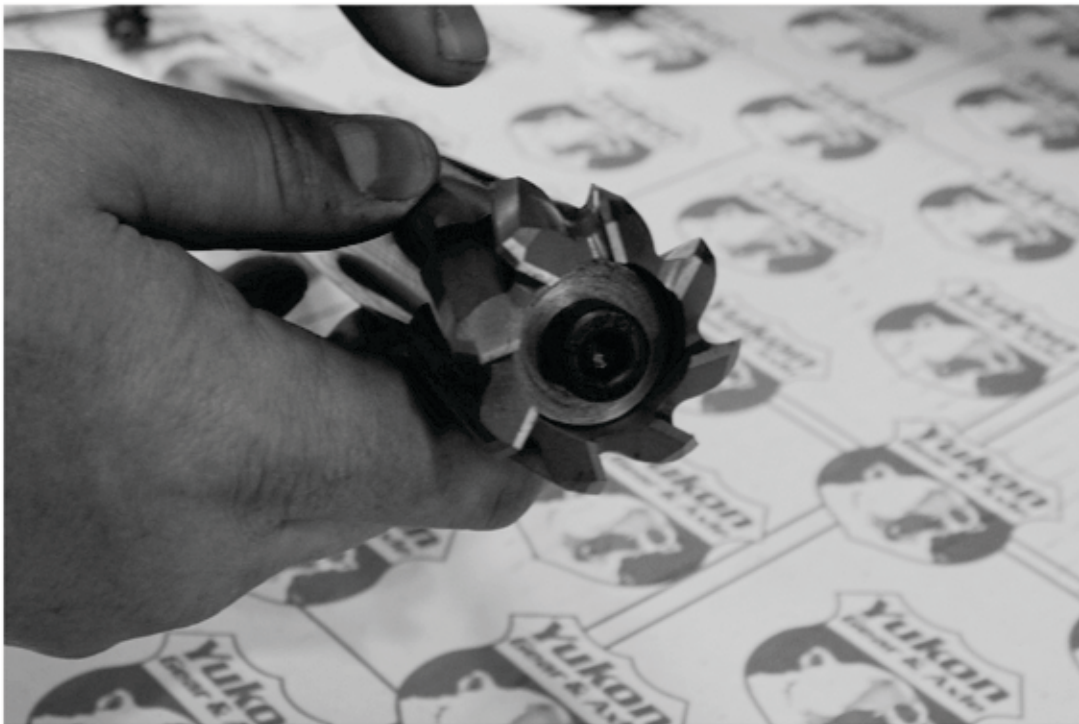


Yukon Spindle Boring Tool Instructions



In order to use this tool, you will need:

- Cutting/Tapping fluid.
- **LOW-SPEED** drill.
- High-quality bearing grease.



Begin by securing the cutting head and tightening down the bolt.



Apply a liberal amount of bearing grease to the spindle threads.



Apply a liberal amount of bearing grease to the boring tool threads.



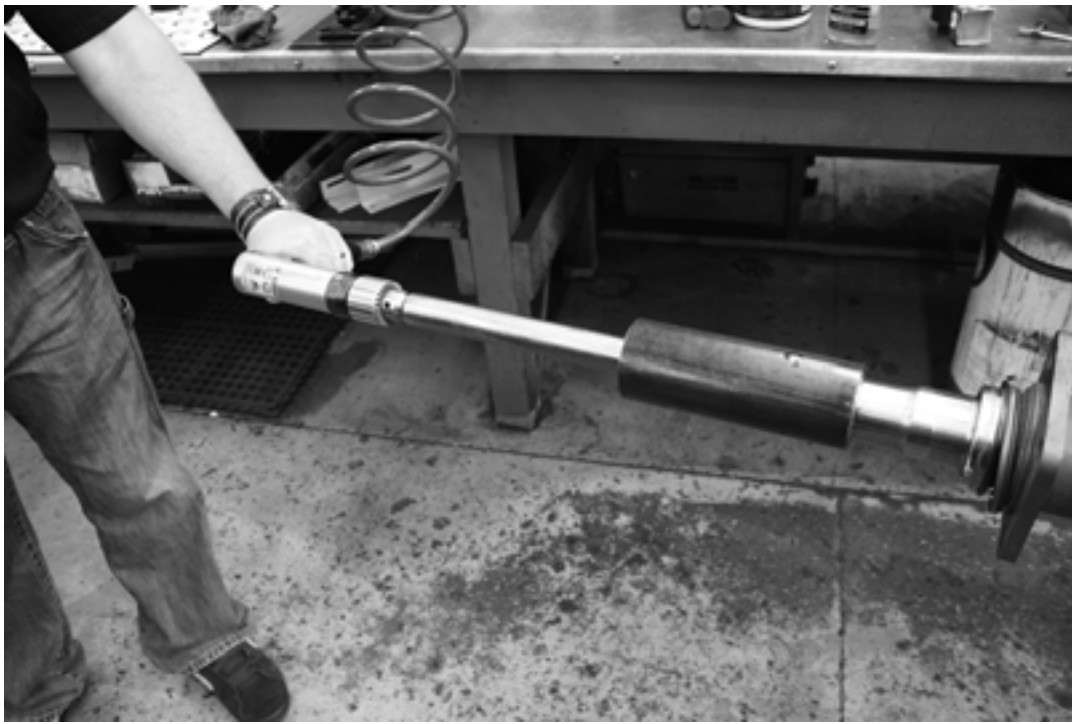
Slide the cutting head/boring shaft into the boring tool housing.



CAREFULLY thread the boring tool onto the spindle. Be sure that you have enough grease on both the boring tool and the housing. Thread the tool on **slowly** as to not damage the threads.



Apply a liberal amount of cutting fluid through the oiling port on the boring tool housing. You will need to add more fluid as you go. It is **VERY IMPORTANT** to add cutting fluid as necessary to make sure the cutting head has proper lubrication. **FAILURE TO DO THIS WILL RESULT IN PERMANENT DAMAGE TO BOTH THE BORING TOOL AND YOUR HOUSING.**



Using a low speed drill, **SLOWLY** begin to bore out the spindle. **DO NOT** spin the cutter too quickly or apply too much pressure. Keep the tool well lubricated during the cutting process. Once completed, repeat for the other side. After both sides have been successfully bored out, thoroughly clean the housing to remove all metal shavings.