PRO-CUT
ROTOR MATCHING SYSTEMS

SERVICE BULLETIN #9

#9

MODELS:
- PFM 9.2
- PFM 9.0
- PFM900
- VBG620
- A10 WARTHOG

You balance wheels. You match rotors.

How to Cut Drilled and Slotted Rotors *with the Pro-Cut lathe*

There are **three** types of Drilled and Slotted Rotors:

1) Cross-Drilled and/or Slotted (Follow Procedure **A**)
2) Dimpled and Slotted Opposed (Follow Procedure **A**)
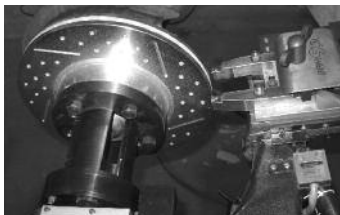3) Dimpled and Slotted Offset (NOT Opposed) (Follow Procedure **B**)

WARNING: If rotor holes are NOT directly opposed, you MUST follow Procedure B and cut only one side at a time.

A: BASIC PROCEDURE

1. Set up the Pro-cut lathe as usual.
2. Remove excessive rust on rotor surface.
3. Inspect the cutting head and cutting tips previous to cutting rotors.
4. The cutting arms must be perfectly aligned / opposed.
5. The gib must be properly adjusted, contact service department for proper procedure.
6. The rotor must be perfectly centered between the cutting arms.
7. Depth of cut should be 3/1,000 of an inch per side (0.003").
8. Use a 50-754 thick silencer for solid rotors.
9. Upon cutting rotors, sand for 1 minute per side with 150 grit sand paper and wash down with soap and water.

B: PROCEDURE FOR OFFSET ROTOR SLOTS (NOT OPPOSED)

You will still cut 3/1,000 of an inch (0.003") or less per side, per pass. You will still use a silencer as well as sand and wash the rotor upon finishing the cut. **IMPORTANT:** You must cut only one side at a time. Cut the inboard side of the rotor first (outboard cutting bit NOT touching rotor), and then make a second pass to cut the outboard side of the rotor (inboard cutting bit not touching rotor). Do not engage both inboard and outboard cutting tips at the same time.

The rotor must be perfectly centered between the cutting arms. Depth of cut should be 3/1,000 of an inch (0.003") per side.

Upon cutting rotors, sand for 1 minute per side with 150 grit sandpaper and wash down with soap and water.

Contact the Pro-Cut Service Department with any questions: 800-543-6618.