

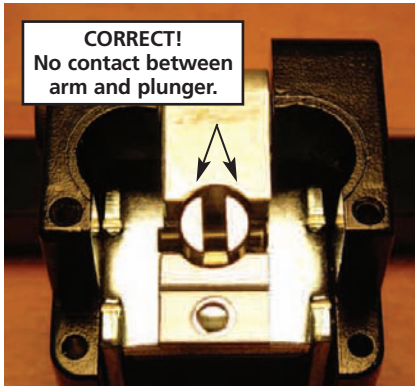
Perfect Brake Job. Every time.

- MODELS:**
- PFM 9.2
 - PFM 9.0
 - PFM900
 - VBG620

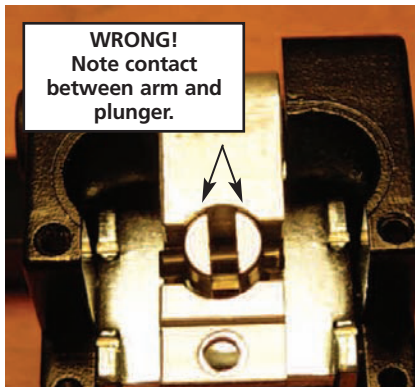


50-100 SOLENOID COIL ALIGNMENT PROCEDURE

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▲ **Figures 1/2.** Correct solenoid adjustment should always have clearance between 50-102 striker arm and plunger for the entire travel of the plunger.



INDICATION: If the Solenoid “clicks” loudly then progressively clicks softly after the part has been cleaned and rebuilt. This procedure is for the 50-100 “Black” Solenoid only.

PROCEDURE:

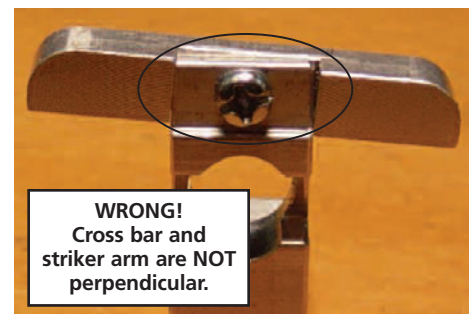
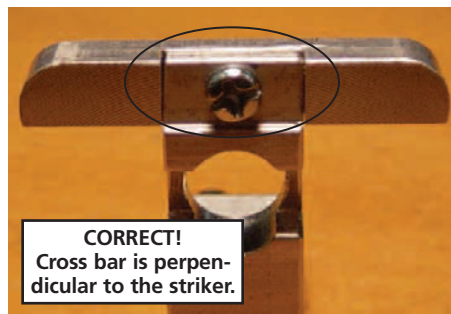
1. Remove the solenoid from the lathe.
2. Remove the cover.
3. Inspect the top of the plunger. Is there clearance between the plunger and the striker arm? Actuate the solenoid by hand and inspect the movement of the plunger. Is it moving on an angle? (See Figures 1 & 2.)

COIL ADJUSTMENT:

1. Locate the two Phillips head screws on the side of the solenoid and loosen them.
2. Adjust the coil by moving it in or out until the plunger sits correctly.
3. Hold the coil in place and tighten the screws, inspect the plunger and ensure that it is properly centered.

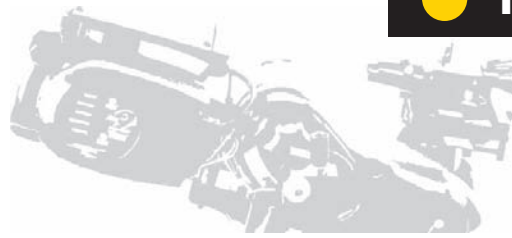
OTHER ADJUSTMENTS:

Inspect the **Cross Bar** (where the springs seat into) to be sure that it is straight (See Figures 3 and 4). There is a single screw that holds it in



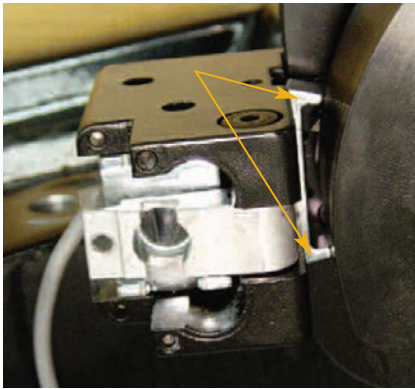
▲ **Figures 3/4.** Surfaces must be flush and even, so 50-105 cross bar is perpendicular to the striker arm.

Continued on page 2



● **50-100 SOLENOID COIL ALIGNMENT PROCEDURE**

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▲
Figures 5. Both ends of 50-103 striker arm must be touching the side of the flange when assembled properly.

place. If adjustment is required, loosen the screw and move the bar until it is perpendicular to the striker arm. Tighten the screw.

Inspect the **Striker**; this section of the striker arm also needs to be straight. In order to adjust the striker, the striker arm assembly must be removed from the solenoid body (see the **Solenoid Repair Kit and Procedure**, Technical Service Bulletin #21).

1. Locate the two 2mm Allen screws and loosen.
2. Adjust the striker so that it is perpendicular to the striker arm assembly. Hold the striker in place and tighten the Allen screws (see Figure 5).
3. Assemble the solenoid as per the solenoid repair procedure instruction.

Remember when installing the solenoid unit back on the lathe, that it is adjusted properly. The screws vs. the slotted holes in the bracket **MUST** be in the same position. I suggest starting where the screws are in the middle of the slotted holes. Hold the bracket in place and tighten the screws. It is not necessary to over-tighten the screws — you will distort the bracket holes. Firm pressure is good enough.

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



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