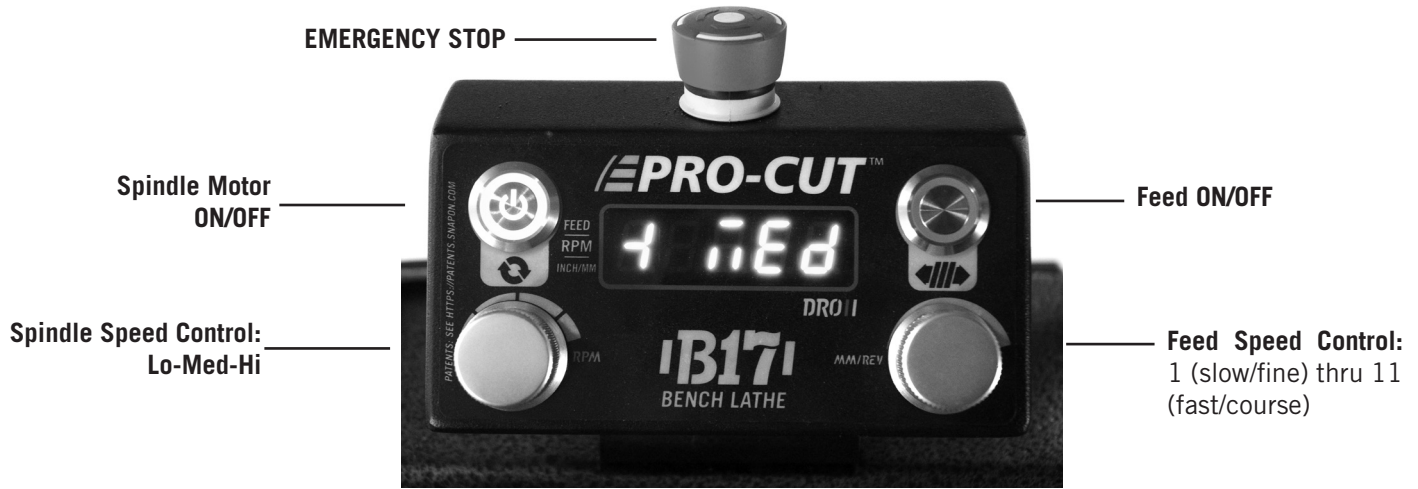


COMMAND MODULE MACHINING MODE



CUTTING BITS

• When sufficient wear causes an inferior finish, rotate the carbide insert clockwise. Always begin on the single dot or brand icon corner and rotate clockwise to 2 dots, then 3 dots. For best results use only Pro-Cut 50-778 Performance Plus, or 50-742 Cutting bits. **DO NOT TURN THESE INSERTS OVER.**



SPINDLE & FEED SPEED RECOMMENDATIONS

• The B17 has 3 spindle speeds and 11 feed speeds and should be adjusted before engaging the feed. Speed & Feed recommendations are based on use of Pro-Cut 50-778 Performance Plus cutting bits. These bits offer the most material removal per pass, and the smoothest surface finishes.

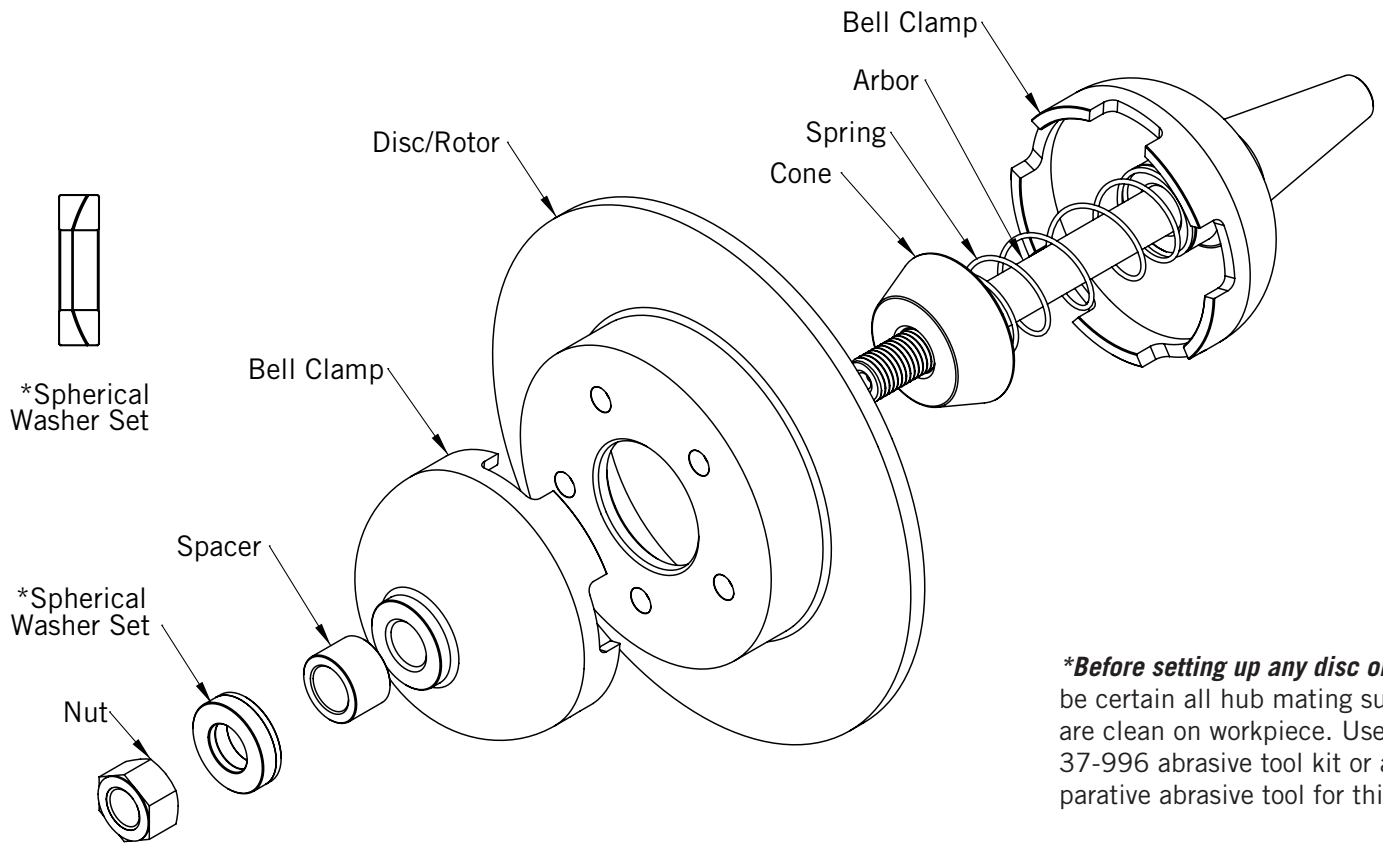
Disc/Drum Diameter	Max Speed	Max Feed	Max Recommended Cut Depth per Side
Up to 12" (305mm)	High	11	.010" (.254mm)
12" to 14" (305-355mm)	Medium	7	.010" (.254mm)
14" to 19.5" (356-495mm)	Low	4	.010" (.254mm)

***Note:** 50-742 cutting tips and or deeper than recommended cuts may require a slower feed rate.

GENERAL TIPS

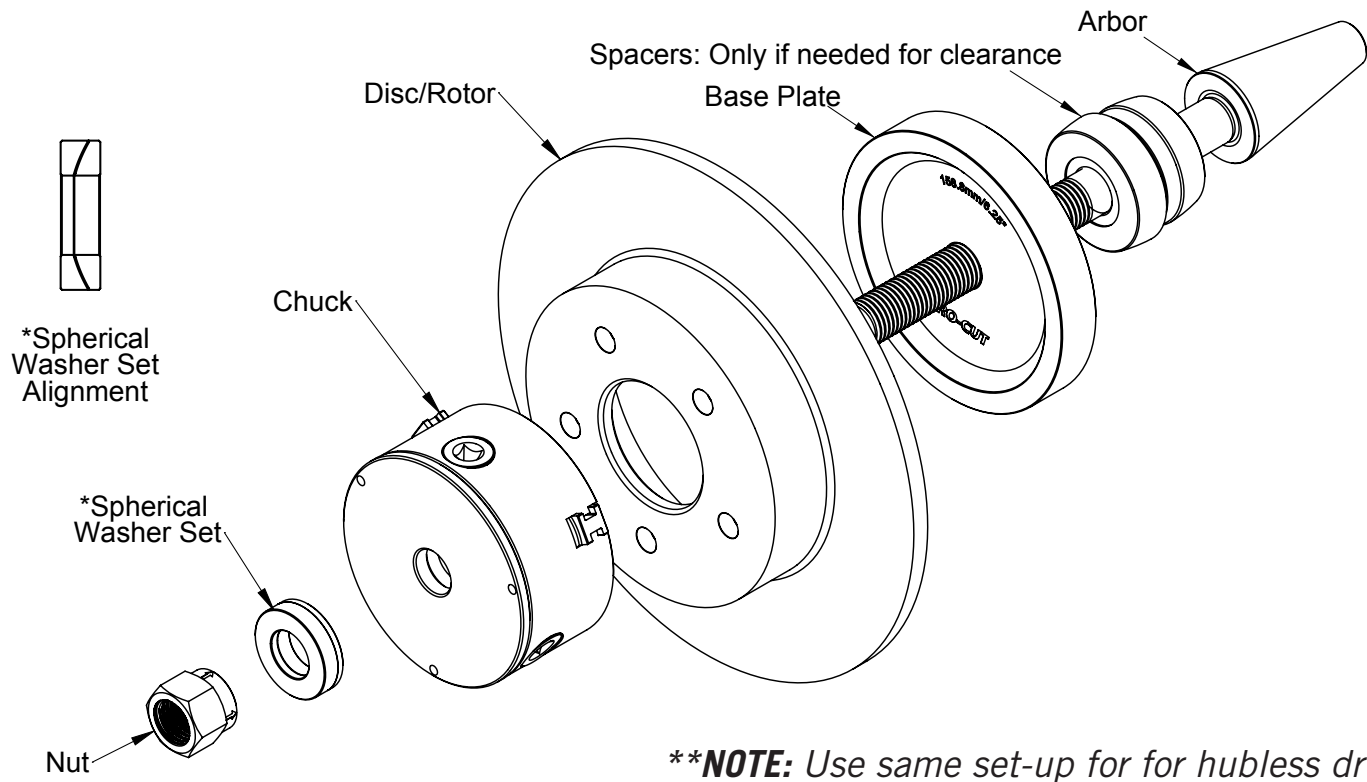
- Measure rotor or drum first to check for taper and sufficient existing material to stay within specification, after machining. Adjust cut depth accordingly.
- Always remove excess rust and any raised sections on the inside or outside of the rotor BEFORE beginning machining.
- For extra small diameter drums, use longest tool bit holder.
- Before re-installing machined disc or drum, be certain hub of vehicle is cleaned with abrasive kit 37-996 or the like.
- Wash all machined friction surfaces on drum or disc with soapy water before reinstalling on vehicle.
- **DO NOT MACHINE A ROTOR TO LESS THAN MANUFACTURER'S THICKNESS SPECIFICATIONS.**
- **DO NOT MACHINE A DRUM ABOVE THE MANUFACTURER'S DIAMETER SPECIFICATION.**

B17 STANDARD ADAPTERS / Recommended Hubless Disc/Drum Set-up



**Before setting up any disc or drum, be certain all hub mating surfaces are clean on workpiece. Use the 37-996 abrasive tool kit or a comparative abrasive tool for this task.*

B17 QUICK-CHUCK ADAPTERS / Recommended Hubless Disc/Drum Set-up



****NOTE:** Use same set-up for for hubless drums.