

PFM9.1TM
TECHNICAL MANUAL



PFM 9.1™

TECHNICAL MANUAL

P · 800.543.6618

F · 603.298.8404

info@procutusa.com

www.procutusa.com

PFM 9.1 DRO Notes

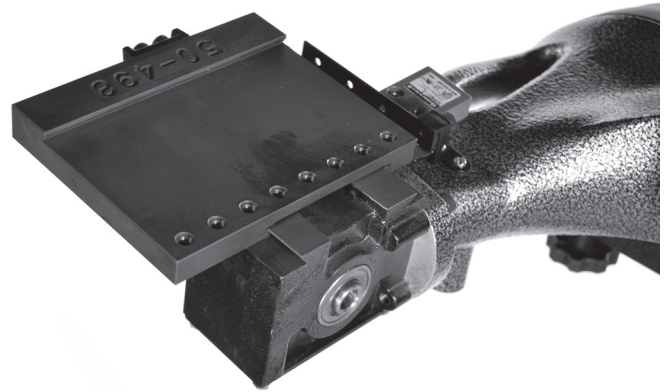
- The 9.1 comes standard with a 3 legged trolley (50-380)
- Refer to page #78 in the 9.2 technical manual
- The 9.1 comes with a 50-238 Cutting Head
- The 9.1 is not compatible with the G2X (50-1200) cutting head
- The 9.1 is not compatible with the GYR system

USING THE 50-238 CUTTING HEAD

Positioning The Cutting Head

Notice that there are several mounting holes in the slide plate that can be used to lock the cutting head. The cutting head assembly can be secured into any one of the holes. It is a good idea to clean out these holes as well as the dovetail and plate surfaces when you change cutting head position, as they can easily fill up with metal chips. Use the T-handle 6mm allen wrench to remove the securing screw and center the head so the cutting arms will straddle the rotor.

It is critical that you pull the tool holder plate back into the dovetail so that it is square as you tighten the securing screw. You can use one hand to push the cutting head firmly back into the dovetail as you tighten the set screw with your other hand. If the tool holder is not squarely and firmly pressed into the dovetail, a poor surface finish will result.



SET SHUT-OFF CAM

Next you will set the shut-off cam. Crank the feed knob until the tips clear the outside edge of the rotor. Loosen the cam screw and slide the cam back until it contacts the automatic shut-off switch plunger. Tighten the cam screw. The cam will press the shut-off switch when the tips clear the rotor. This allows for unattended operation.



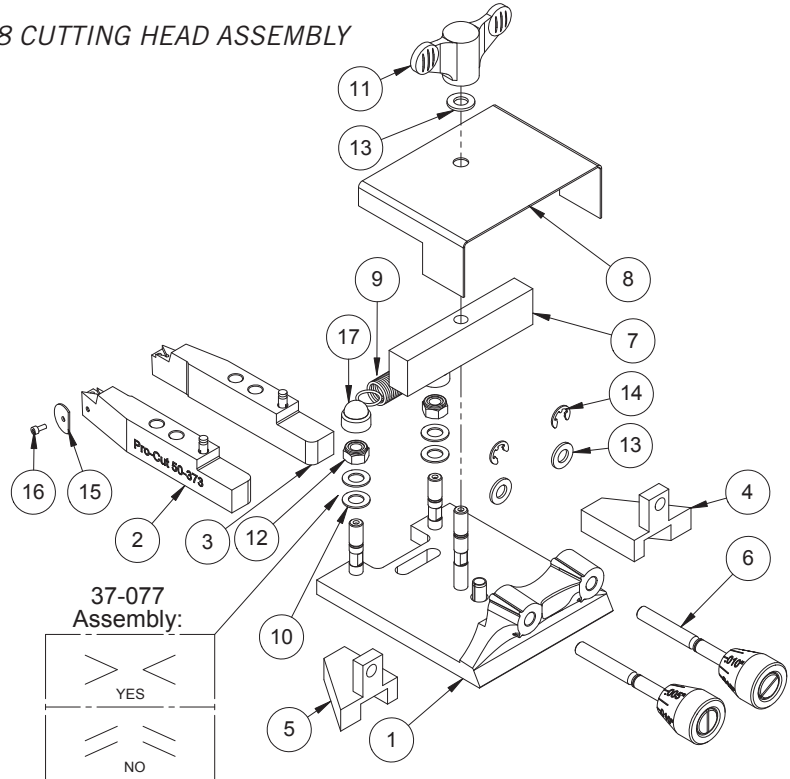
NOTE *The Pro-Cut will mount right-side up on one side and upside down on the other. Always start right-side up; this way, when you proceed to the other side of the vehicle, the offset of the cutting head will already be set, with the cutting head firmly in the dovetail. Never attempt to move the cutting head laterally with the lathe upside down.*

9.1 DRO PARTS DIAGRAM

50-238 CUTTING HEAD ASSEMBLY

ITEM NO.	PART NUMBER	QTY.
1	50-292	1
2	50-373	1
3	50-374	1
4	50-253	1
5	50-254	1
6	50-098	2
7	50-252	1
8	50-251	1
9	50-053	1
10	37-077	4
11	37-184	1
12	36-002	2
13	37-003	3
14	37-082	2
15	50-365	1
16	50-364	1
17	36-010	2

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PRO-CUT™
BRAKE SOLUTIONS

Pro-Cut International, LLC
10 Technology Drive #4
West Lebanon, NH 03784

P. 800.543.6618 / 603.298.5200
F. 603.298.8404
E. info@procutusa.com

Global inquiries please see:
www.procutusa.com