

## ATTENTION:

**IF** your Pro-Cut lathe will not compensate you should first check the trolley/lathe/adaptor/hub connections. The Pro-Cut lathe works best when the hub turns freely and without binding the lathe. The check points below will help you assure that the set-up is correct

## START:

- 1 VEHICLE SHOULD BE WARM**  
If temperature is below freezing, warm up vehicle by driving it. A warm vehicle has less binding and smoother hub rotation.
- 2 PUT VEHICLE IN NEUTRAL AND RELIEVE THE PARKING BRAKE**  
Vehicle must be in neutral and parking brake removed so hub will turn smoothly.
- 3 REMOVE WHEELS & CALIPERS FROM BOTH SIDES OF VEHICLE**  
Wheels and calipers must be removed on both sides of the vehicle. Leaving a wheel or caliper on the opposite side can bind the hub. Be sure to stabilize the opposing rotor with lug nuts.
- 4 BE SURE BEARINGS ARE SNUG**  
It is impossible to distinguish run-out from excess play in the bearings. Be sure bearings are snug before connecting the lathe.
- 5 ADAPTER CONNECTIONS (TO BOTH LATHE AND HUB) MUST BE SECURE**  
Be sure there is no play between the adapter and the rotor. Excessive rust should be removed before to mounting the adapter. Similarly, be sure the connection between the lathe and adapter is well mated. The drawbar knob should be hand tight.
- 6 RELEASE LIMITED SLIP AND FLOATING REAR AXLES**  
If working with limited slip rear end with a lot of resistance, disconnect driveshaft.  
If you're on a floating rear axle, pull driver side axle.
- 7 BE SURE TROLLEY IS NOT BINDING THE LATHE**  
Lathe working height should be somewhere in the middle of the trolley range. Working at either the highest or lowest trolley height can bind the lathe. The run-out in the hub must be able to freely express itself through the lathe in order for the computer to see and eliminate that run-out.
- ! IF YOUR LATHE IS SET-UP CORRECTLY AND STILL WON'T COMPENSATE, PLEASE CHECK THE FOLLOWING:**
- 8 CALIBRATION SHOULD BE SET @ 18**  
Check owner's manual for instructions on how to read and change the lathe calibration. You may also call Pro-Cut's service hotline @ 800-543-6618.
- 9 CONFIRM DRAWBAR DEPTH**  
With the draw bar knob pushed forward, count how many threads are showing beyond the flange. There should be 5-6 threads. Fewer threads leads to poor connection, more threads may bind the adapter.
- 10 INSPECT ADAPTER AND LATHE FLANGE FOR DAMAGE**  
Dings, chips or burrs in the mounting faces of the flange or adapter can allow play in the system. Be sure are mating areas are smooth and free from debris. Also, be sure the flange has all 4 star wheels in place and snug.
- 11 DISCONNECT LATHE, ROTATE ADAPTER 180 DEGREES AND TRY AGAIN**  
Sometimes a fresh start can provide a cleaner connection and make all the difference.
- ! IF LATHE DOES NOT COMPENSATE UP SIDE DOWN, PLEASE CHECK THE FOLLOWING:**
- 12 INSPECT THE RATE SENSOR**  
Rate sensor should be held firmly in place. If it is loose please tighten the securing screws.
- ! IF THE SOLENOID DOES NOT ACTUATE IN THE COMPENSATION MODE, PLEASE CHECK THE FOLLOWING:**
- 13 INSPECT THE MAGNET ON THE BACK OF THE FLANGE**  
The lathe will not compensate if the magnet is either missing or covered with debris. Please use brush- NOT COMPRESSED AIR!
- 14 INSPECT THE 25 PIN CONNECTOR**  
Make sure that all pins are nesting correctly.

**STILL NOT WORKING? CONTACT THE PRO-CUT SERVICE DEPARTMENT @ 1-800-543-6618.**