



HOW-TO:

Workhorse chassis motor homes and commercial vehicles with 8 on 275mm bolt patterns



Match-machining rotors on Workhorse chassis vehicles with the 8 on 275mm bolt pattern is now a simple task with these new parts from Pro-Cut. This pattern can be found on both motor homes by several coach manufacturers, and also on common commercial vehicles, like trucks used by UPS and FedEx.

ITEMS REQUIRED FOR THE FRONT ARE:

- 50-944 medium duty truck adapter (qty1)
- 50-960 25mm spacers (qty 4)
- 50-987 M22 Tapered nuts (qty 4)

*INSTRUCTIONS FOR THE FRONT:

1. Install 50-960 spacers on every other of the 8 studs
2. Install the 50-944 adapter using pattern #1
3. Install the 50-987 nuts on the studs with the spacers, with the taper towards the adapter in order to center it on the studs
4. Attach your Pro-Cut lathe and match-machine the rotor as per normal

ITEMS REQUIRED FOR THE REAR ARE:

- 50-944 medium duty truck adapter (qty1)
- 50-1007 M22 x 140mm stud extensions (qty 4)
- 50-987 M22 Tapered nuts (qty 4)
- 50-492 reach extension plate (alternate: 50-1492 med.duty reach plate)

*INSTRUCTIONS FOR THE REAR:

1. Install four 50-1007 stud extensions on every other of the 8 studs by hand and then loosen slightly so they wiggle a little at the end (this will help with installing the adapter).
2. Install the 50-944 adapter over the stud extensions being certain that it is seated properly.
3. Install the 50-987 nuts on the studs with the stud extensions making certain the flat side of the nut is facing the adapter (the shoulder on the stud extensions centers the adapter on the rear).
4. Remove the cutting head, and install the 50-492 (or 50-1492) reach extension plate. Re-install the cutting head on the reach plate and attach the machine to the adapter. Be certain draw bar is tight (1/8 of a turn by wrench beyond hand tight) and remove no more than .005" of material from each side of the rotor each pass.

*Instructions presume you have a properly functioning Pro-Cut PFM 9.2 lathe or A10 Warthog lathe with a speed-lock cutting head, vehicle is in neutral, all wheels are removed, and brake calipers are removed and hung clear of match-machining operation. All safety warnings should be observed as per the owners manual for your machine.

Please call your Pro-Cut Rep, or the Pro-Cut Service Department with any questions: 800-543-6618.