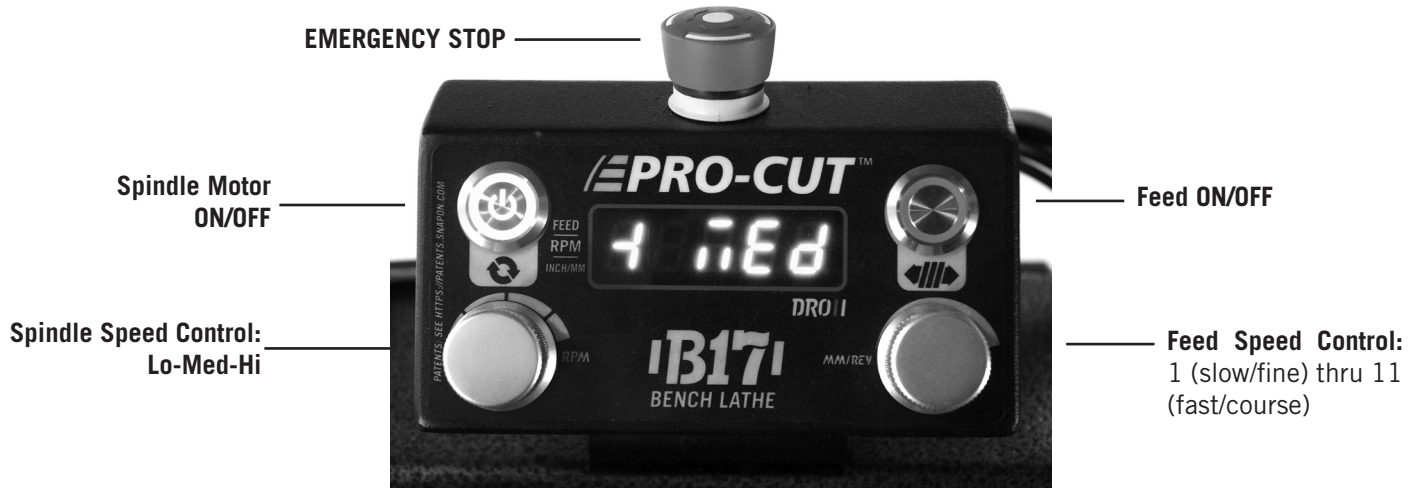


COMMAND MODULE MACHINING MODE



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.

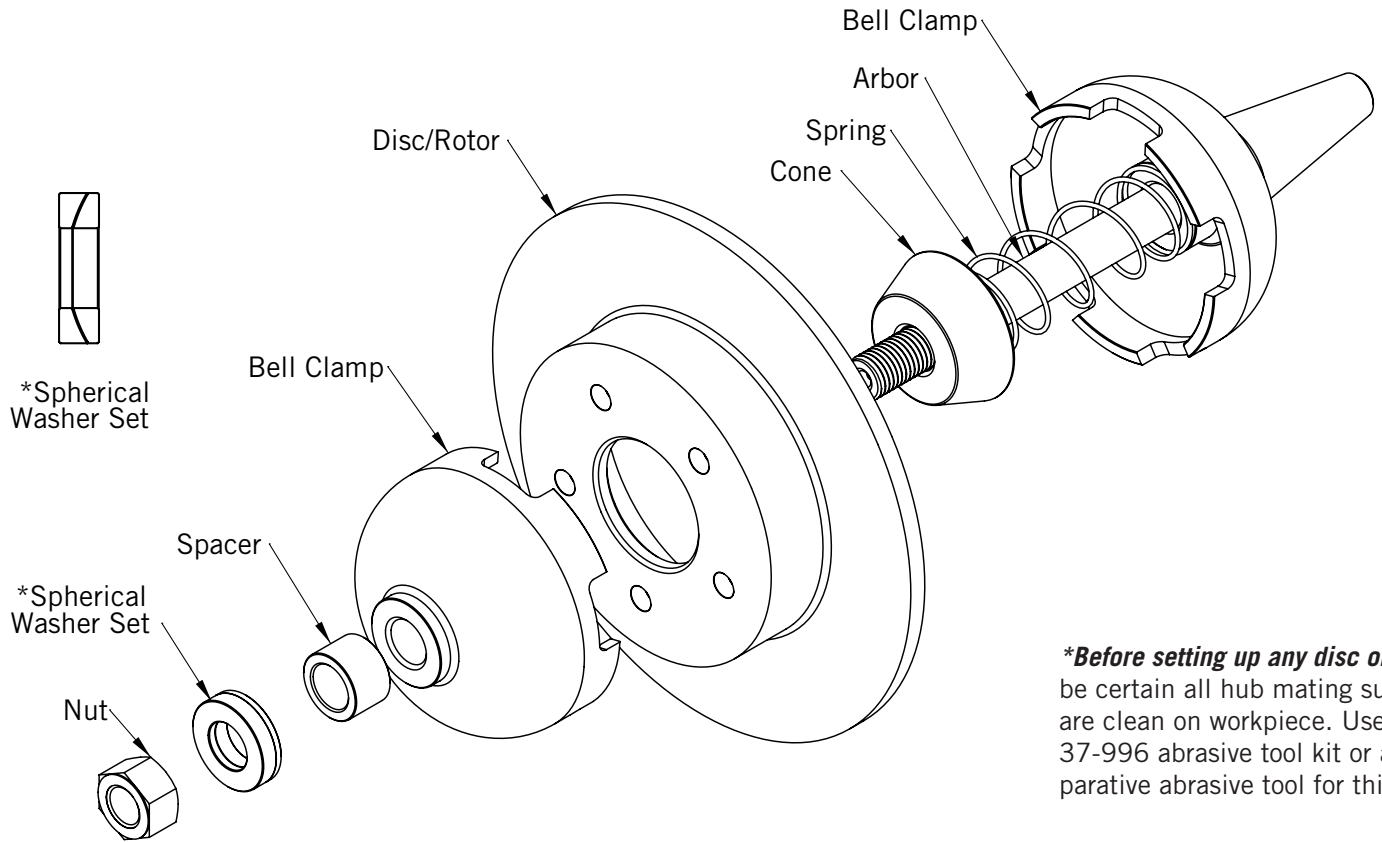
Disc/Drum Diameter	Max Speed	Max Feed	Max Recommended Cut Depth per Side
Up to 12" (305mm)	High	11	.010" (.254mm)
12" to 14" (305-355mm)	Medium	7	.010" (.254mm)
14" to 19.5" (356-495mm)	Low	4	.010" (.254mm)

***Note:** Inferior 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, set the boring bar at an angle towards the arbor while extending the boring bar outward from the boring bar holder. Tool bit holder can also be rotated slightly if needed.
- 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 ADAPTER / Recommended Disc Set-up



B17 STANDARD ADAPTER / Recommended Drum Set-up

