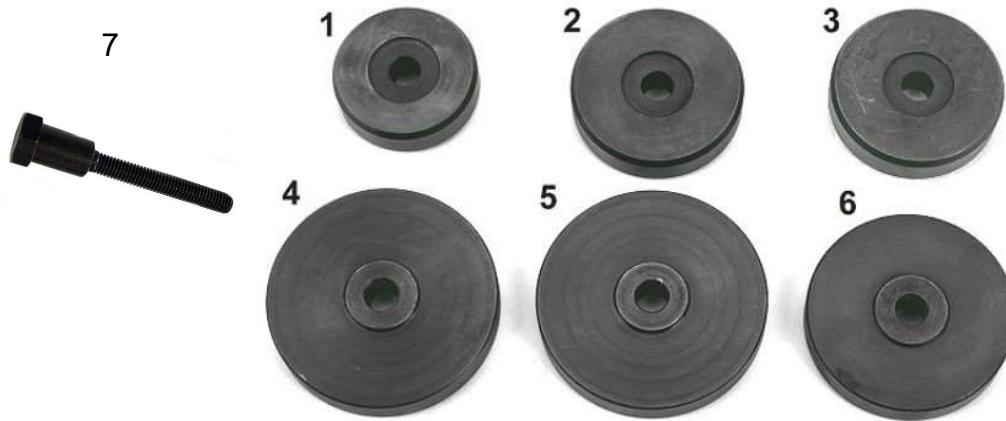




Heavy Duty Centering Adapter Set Instructions

PN: 794-8680-18



ITEM	PART #	DESCRIPTION	QTY
1	794-8657-37	Ford/Caterpillar 205, 2.040" (51.8 mm)	1
2	794-8657-38	Mack 305, 2.435" (61.8 mm)	1
3	794-8657-39	Ford Truck, 2.495" (63.4 mm)	1
4	794-8657-40	Cummins/GMC 306, 2.830" (71.9 mm)	1
5	794-8657-41	Ford 307, 3.149" (79.9 mm)	1
6	794-8657-42	Ford Truck, 3.255" (82.7 mm)	1
7	794-8677-99	4.25" Centering cone bolt assembly	1



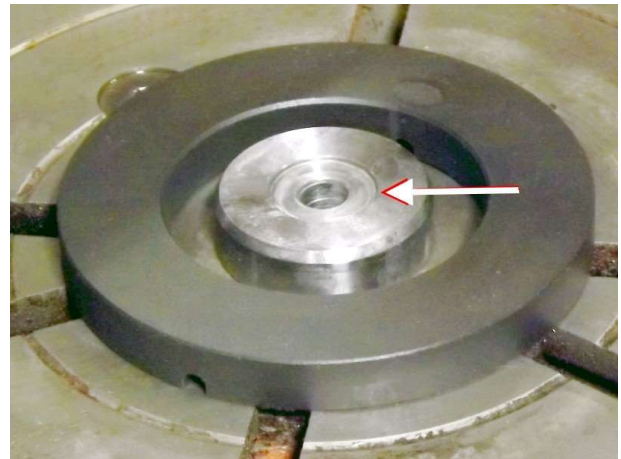
The HD Centering Adapter Set is designed to make it faster and easier to mount several common sized flywheels. The adapters are made to precisely fit the center hole of these common flywheel and have a lip that captures the opening in the center of the table. The adapters must be stacked with each one locking into the one below and the lowest one locking into the table center hold.

The final step is to add a cone or two so that the hold-down bolt engages the threads and allows you to tighten the cone (or cones if needed) down to hold the flywheel in place.

The adapters capture the flywheel so that it is centered on the table and the cone(s) and hold-down bolt secure the flywheel from moving. (flanges, cones and hold-down bolts that are standard equipment with all FG flywheel grinders)

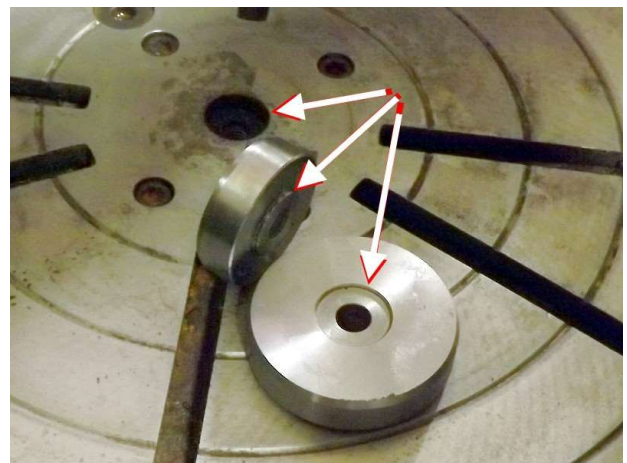
A Visual Walk Through

As you normally would, select the correct flange adapter to fit the location where the flywheel bolts to the engine. Place it on the table. Select the appropriate HD Centering Adapter for the flywheel you are going to grind and select the next smaller HD Centering Adapter.



Place the smaller HD Centering Adapter and the flange on your table as shown to the right.

NOTE: The HD Centering Adapter will "lock" into the center hole of the table. You should not be able to slide it off the center hole of the table.



Picture on the right are the adapters. The arrow pointing to the center (smaller) adapter will go down into the center hole of the table.

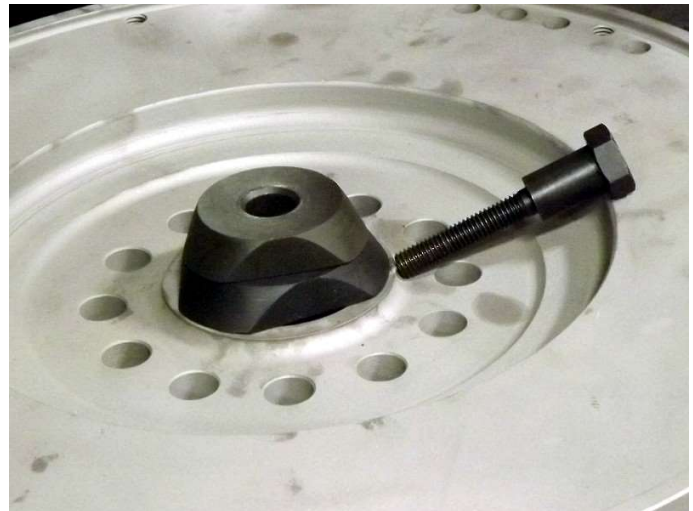
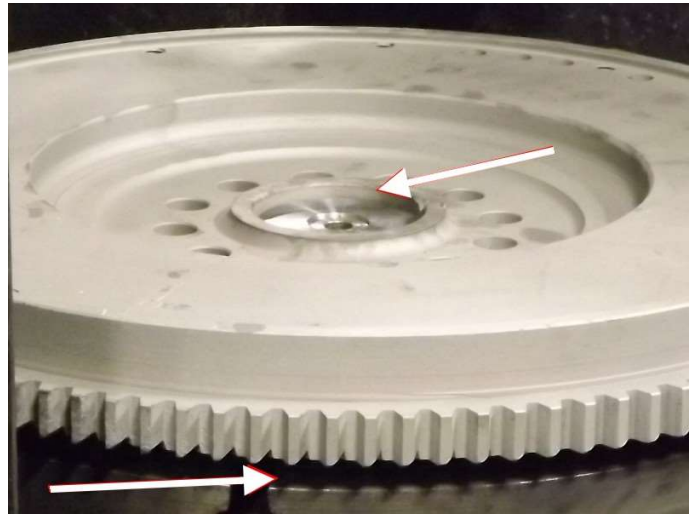
Then the larger adapter will go on top of it also locking into the center.



It's OK if the adapter doesn't stick all the way through the flywheel. It just has to grab the center. To make this happen you may have to use a thinner flange adapter OR perhaps an additional HD Centering Adapter. Every flywheel is a little different so you will need to find the combination that works.

You can also use any of the shorter hold-down bolts that came with your flywheel grinder if they work better for the particular flywheel you are grinding.

Now take one or more centering cones that are needed to cover the opening and allow the centering hold down bolt to apply downward clamping force on the flywheel. You'll notice in our image to the right we flipped the centering cone over. The flywheel is already centered, we just need to hold it down. And the bottom cone must be larger than the flywheel opening to apply the correct downward force.



Step-by-step

1. Place correct flange adapter on table. (standard equipment with machine)
2. Place a centering adapter that is not for your flywheel into table center hole.
3. Place flywheel with correct size centering adapter on top of flange and lock into the center indentation of the centering adapter that is below and already locked into the table.
4. Place one or more centering cones over flywheel center opening and tighten with hold-down bolt. (cones and hold-down bolts are standard equipment.)



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