INSTRUCTIONS FOR
FLYWHEEL GRINDER HEAVY DUTY TRUCK ROTOR KIT

Item	Description
1	Alignment Pin Assembly
2	SC HD CS 3/8-16X4.25
3	Grinding Wheel Spacer Asm
4	Arbor Nut Wrench
5	1-1/4”-12 Nut
6	Mounting Washer
7	Arbor Spacer 3.00”

Item	Description
8	Arbor Spacer 2.00”
9	Arbor Spacer 1:00”
10	Centering Cone 4.5-5.5
11	Centering Cone 5.0-6.5
12	Centering Cone 5.875-7.375
13	Centering Cone 6.875-8.125

794-8628-00

Install 2” vertical arbor by threading the 7/16th threaded stud at the base of the arbor into the center hole of the turntable. Make sure all mating surfaces are clean. Hand tighten snug.

Install special offset grinding wheel flange adapter onto the grinding motor shaft. And install the 6” CBN wheel for grinding.

Wipe flywheel turntable clean before placing the truck rotor onto the turntable.

Clean truck rotor flange area to assure the factory machined surface of the flange is free of any dirt, nicks of burrs that would effect its flatness. File of stone flat if needed.

Mount the truck rotor over the vertical arbor with the flange area down, exposing the outer portion of the truck rotor to the grinding wheel as this will be the first side to be ground.

Choose the correct size mounting cone to center and hold the truck rotor in place on the turntable. Using the spacer, washer and arbor nut lock rotor firmly in place. Do not over-tighten.

The rotors outside surface is now ready to be ground in a similar fashion to how you would grind a flywheel.

Once the surface of the truck rotor has been ground turn off the grinder, raise the motor column up and out of the way. Remove the arbor bolt, washer, spacer and cone.



Flip the Truck rotor over. Make sure the turntable and ground portion of the rotor are wiped clean then place the ground side down, over the arbor and onto the turntable.


Select the correct size mounting cone to fit into the upper flange area and lock the rotor firmly it in place using the required spacer, washer and arbor nut. Do not over-tighten.


Position grinding motor to the right of the truck rotor and lower the column so the grinding wheel is slightly above the same level of the rotor surface to be ground.

Swing the grinding motor back in place to cover the rotor surface. Be careful not to allow leading edge of the grinding wheel to hit the inner hub of the rotor as this can damage the wheel.

You are now ready to grind the exposed portion of the rotor in a similar fashion to how you would grind a flywheel.