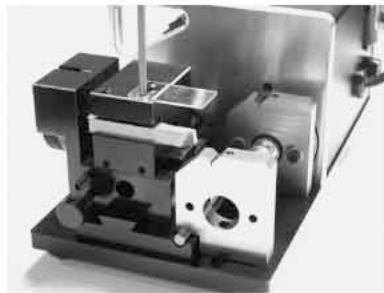
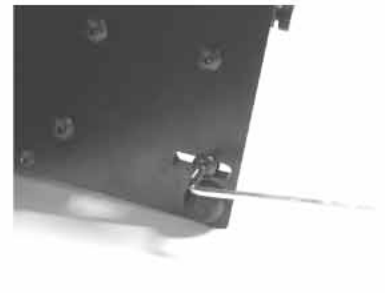




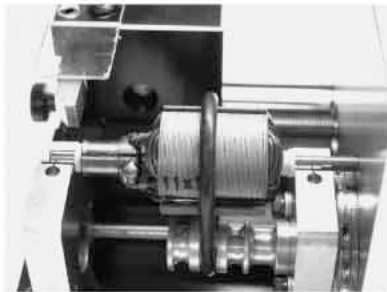
The unit comes with drive o-rings, carbide cutting bit, metal shims & Teflon washer for armature.



Start with installing two metal shims on the bottom and one metal shims on top of the cutting bit. Adjust as necessary.



You can adjust the width between the two v-blocks using this hex screw on the bottom of the unit.



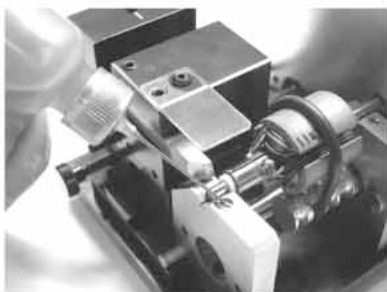
Use Teflon washers to take up spacing between the armature and v-blocks, connect input alligator clips to a 12VDC source.



With auto feed and drive motor off, back out the cutting bit and adjust where it stops using the right hand side knob.



Still with the drive motor off and cutting bit out, turn on the auto feed and do a test run. Make sure the bit doesn't hit arm. tabs.



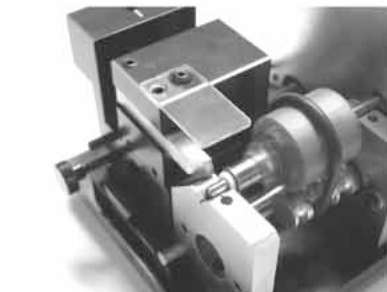
Put some lubricant in the v-block oil reservoirs and on the v-blocks. You can use WD40 or any motor oil.



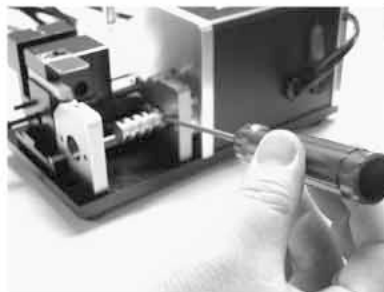
You can now turn on the drive motor. Start with a slow feed speed first and slowly close in the cutting bit against the commutator.



In order to achieve to best possible cut, try to take off thin layers from the commutator. Take off as little material as possible.



You can damage the commutator easily if the lathe is setup to take off too much material. Practice using old armature first.



From time to time, you need to remove the drive pulley using a 1.5mm hex wrench and lube the drive motor support bearing.



Put a small dorp of oil as shown and put the drive pulley back in place. Good luck racing and visit us at [www.integy.com](http://www.integy.com)