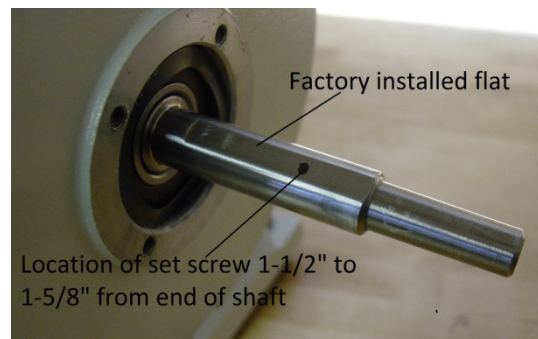
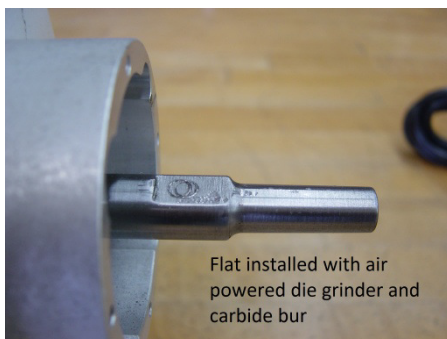


## Instructions for installing B660 Lapping Disc on PR90 Variable Speed Polishing Lathe

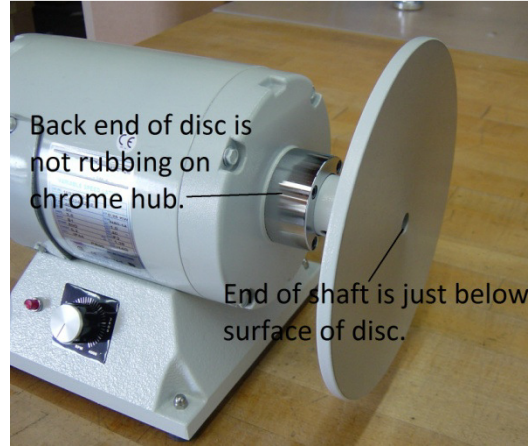
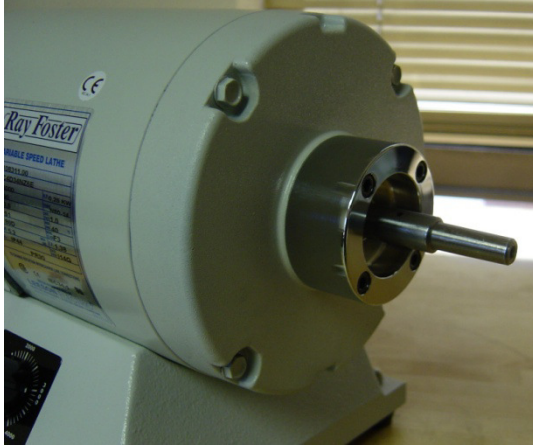
1. Remove chrome chuck stripper from right or left side of lathe. There are 4 - 10/32 socket cap screws that secure the stripper to the lathe. Use a 5/32 Allen wrench (included). Do not remove any washers behind the stripper.



2. Slip the aluminum lapping disc onto the motor shaft. If it does not slip on freely, you will need to sand the shaft. Use a 240 grit cloth backed sandpaper (included). Turn the motor on and run the sandpaper up and down the 1/2" diameter. Don't sand the taper part of the shaft. A little lubrication always helps installing and removing the disc.
3. You will need to file or grind a flat on the shaft where the set screw of the disc will be secured. This will be approximately 1-1/2" to 1-5/8" from the end of the shaft. Make sure that it is wide and deep enough to accommodate 5/16-24 screw. If you don't do this it will be difficult to remove the disc once installed. If you plan on permanently installing the disc it will not be a problem.



4. After sanding the shaft if needed and installing the flat the chrome hub will be installed using 4 - 10/32 socket cap screws provided with the hub. Remember to keep any washers in place and secure the hub with 4 screws.



5. Rotate the flat of the shaft so that it is on top or facing up. Slip the disc onto the shaft with the set screw facing up and align it with the flat. Slip it all the way on until the end of the shaft clears or is below the surface of the disc. Make sure that the back end of the disc is not rubbing on the chrome hub. Secure the set screw using a 5/32" hex wrench.