

BRF-25(C,M&F) Brake Rotor Flexhone Instructions

GOODTOOL

Automotive Service Tooling and Supplies

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Please read instructions before using.

Safety Instructions

WARNING: In normal power brushing operations, the material being removed, such as burrs, scale, dirt, weld slag, or other residue, will fly off the brush with considerable force along with brush filaments which break off due to fatigue.

The potential of serious injury exists for both the brush operator and others in the work area (possibly 50 or more feet from the brush). To protect against this hazard, wear safety goggles or full face shields worn over safety glasses with side shields, along with protective clothing. Operators should wear dust masks and make certain that dust collecting equipment is operating properly to avoid dust inhalation.

SAFETY STANDARD: Comply with the Safety Standards of the Industrial division of the American Brush Manufacturers' Association and the American National Standards Institute. ANSI B165-1-1985 Safety Requirements-Power Brushes and ANSI B165.2-1982 Safety Requirements-Power Brushes-Wood, Plastic or Composition Handles.

Instructions for Use

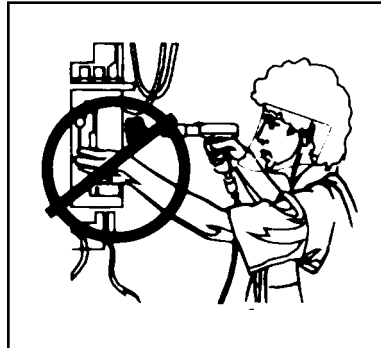
The Flex-Hone for Rotors should be securely held in a collet, chuck or similar holding device. The disc rotor should be mounted on a brake lathe and rotated between **125 and 210 RPM**. Position all guards before starting the tool.

The tool should be chucked securely in a variable speed electric drill motor or low speed air drill. The tool should rotate **300-600 RPM**. (never exceed 1000RPM). Bring the tool into contact with the rotating rotor at a slight angle and work in towards the center and out to the edge of the rotor face. Light, uniform pressure is used. Dwell time against the part produces the desired finish not excessive pressure. The tool is used dry and should be worked for 15 to 20 seconds at a time.

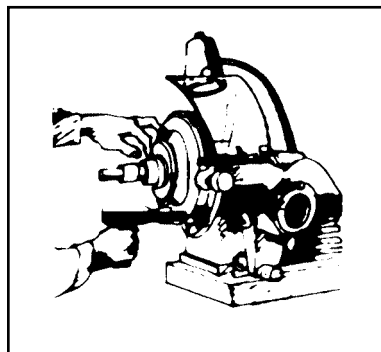
NOTE: Do not overheat by dwelling for longer periods of time. 10-15 seconds clockwise and 5-10 seconds counterclockwise should produce the desired finish.

For Best Results

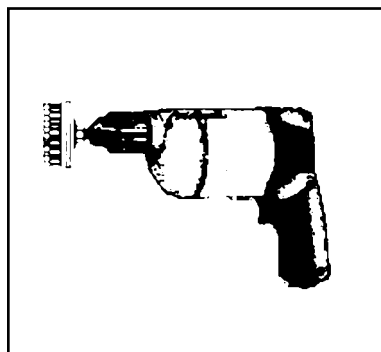
- Apply light, even pressure.
- Do Not OVERHONE.
- Never exceed 1000 RPM.
- Wear full face protection.



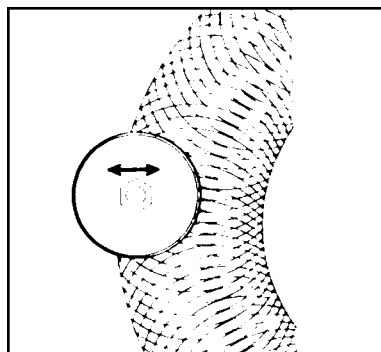
1. Remove rotor from car. Do not use die grinder or high speed drills.



2. Mount rotor on brake lathe spindle. Rotate motor 125-210 RPM.



3. Mount tool in 3/8" reversible variable speed, drill motor. Rotate tool 300-600 RPM.



4. Stroke tool in towards center and out 8-10 times. For improved pattern, reverse tool rotation stroke 4 to 6 times.