



## TORQUE CONVERTER PARTS

## MACH-FRC

### FRICTION RING CUTTING MACHINE INSTRUCTIONS

The friction ring cutting machine MACH-FRC does not directly accommodate the Sonnax/Raybestos Master Rings which have large inside diameters. Centering disks will be needed to support and hold them on center when cutting. Below is a sketch of the three stepped centering disks needed for cutting master rings. The  $\frac{3}{8}$ " hole must be on center to the stepped diameter. These can be made out of aluminum, steel, Plexiglas, or fiberboard. A  $\frac{3}{8}$ " diameter by  $\frac{3}{8}$ " long shoulder screw will be needed to hold the disk on the cutter and the screw threads will have to be cut to length shown.

A quick alternative is to use a cardboard disk with a  $\frac{3}{8}$ " hole in the center. The cardboard disk should be about  $\frac{1}{2}$ " larger than the inside diameter of the master ring. The Raybestos Master Rings should be taped on center to the  $\frac{3}{8}$ " hole so it runs true. The tape should be applied close to the inside diameter so as not to damaged the friction material surface used. A weight, such as a turbine hub, can be placed on the center of the cardboard disk to prevent the disk from lifting when cutting.

### Master Rings

Part Number	Dimensions	Thickness/Material
RMR1245	12" X 6"	.045" Tan
RMR1275	12" X 6"	.075" Tan
RMR1344HC	13" X 6.125"	.040" High Carbon
RMR1374HC	13" X 6.125"	.070" High Carbon
RMR1345	13" X 7"	.045" Kevlar
RMR1375	13" X 7"	.075" Kevlar
RMR1366	13" X 7"	.066" PowerTorque

### Friction Ring Cutter Centering Disks for Master Rings

