Bulletin BES 00-07
All Vehicles

Subject: Severe Duty Rotors

Vehicle Involved: All

Condition: Resurfacing

Repair Procedure: Bench type Brake Lathe

When resurfacing Severe Duty drilled and/or slotted rotors, it is recommended they be machined on a bench style brake lathe. On the Car lathes tend to set up a vibration on this style of rotor, which has an adverse affect on the rotor finish.

The arbor (shaft) speed should be set at the highest RPM available. The rake (cutting tool) speed should be set at the lowest possible rate.

When making the final cut (pass), the cutting tool should be set to remove no more than .002". Upon completion of the final cut, use a sanding block with 120 to 150 grit sandpaper, should smooth the rotor surface.

Clean the rotor with detergent and water using a brush. Rinse the rotor with clean water, before installing on the vehicle. This procedure will clean the pores of the casting, preventing any carbide or metal particles from being imbedded into the friction material. This procedure is more thorough and less expensive than using brake clean chemicals.