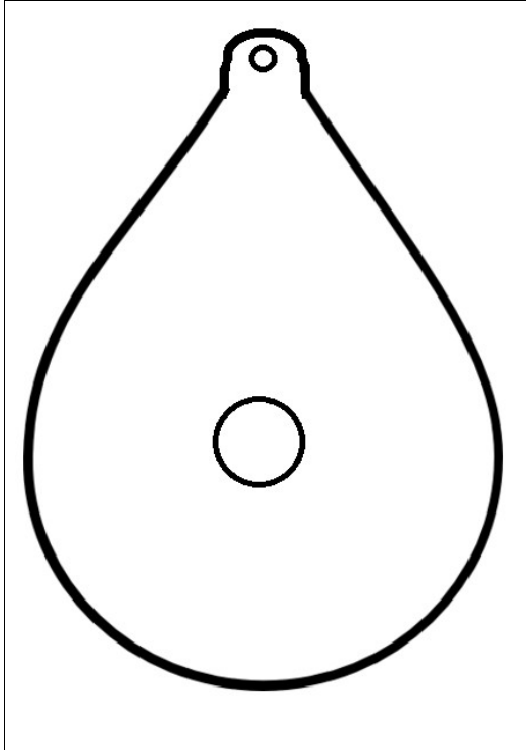


# 45. How to do Driving Hubs plates

Driving hubs plates are plates that will be welded on a big hub



1. Put square jaws
2. Check bore size on paper
3. Check measure from bottom of part to center of bore, on paper mark it with chalk
4. TURN OFF MACHINE WHEN TIGHTENING BOLTS OR TAKING OUT PART
5. Put part, check that is centered on the base jaw
6. Make sure that bottom and top bolt are tight
7. Check Tir on Face and that the part is all the way to the back
8. Tight the bolts of the sides, side to side, tight the high side first (mark highest and lowest)
9. Tight the base and high side, then tight all four sides.
10. Make sure that all bolts are tight mark 2 of them to see which ones you will loose later
11. Use speed 312, Make sure that your insert wont hit the back
12. Make some cuts, measure the part from side to side they must match less that 40 thousand, if not do the tir again, tight the highest to move it sideways, make some more cuts and measure again
13. Check check TIR on face again because it may move.

14. Check concentricity again before finishing bore.
15. Cut sharp edges and make 45 on one side.