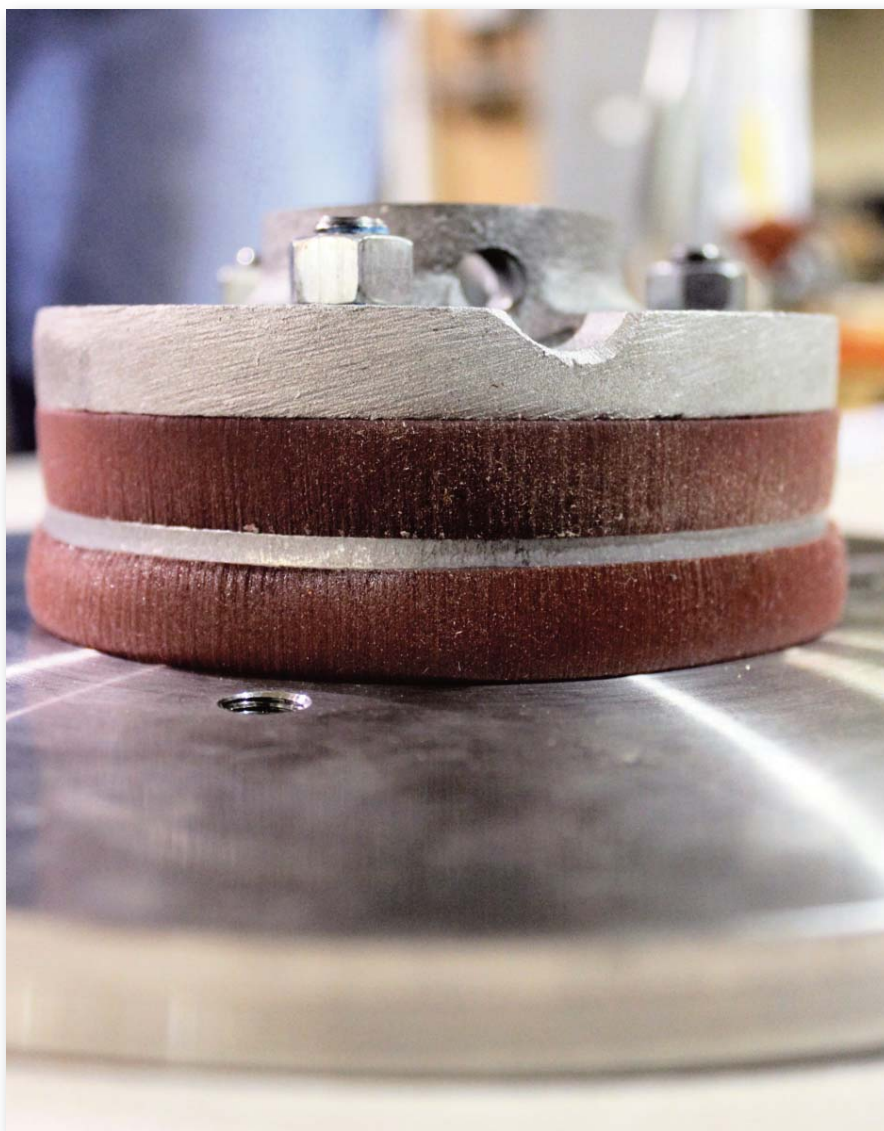




MAGNA-TRAP™ Disc Assembly Manual

10" MAGNA-TRAP™ DISC



100 Thomas Johnson Drive, Frederick, MD 21702-4600 USA
Phone: 301-638-3326 • 301-663-1600
Fax: 800-447-3326 • 301-663-1607
edcoinc.com • sales@edcoinc.com

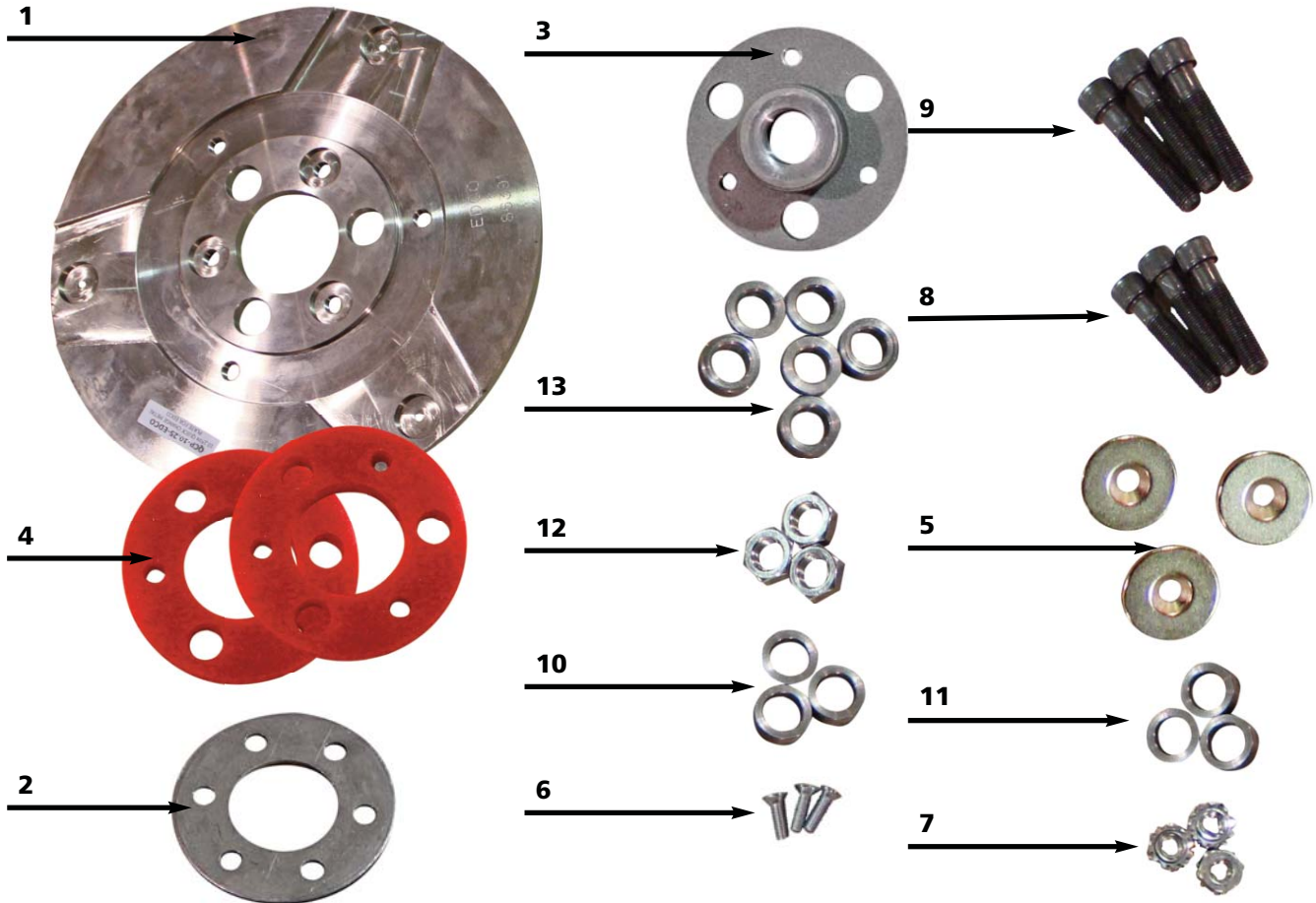


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MAGNA-TRAP™ Parts



PARTS NEEDED TO BUILD A 10" MAGNA-TRAP™ ACCESSORY DISC PART # 8C391A

Part	Part #	Quantity
1. Magna-Trap 10" Disc w/Magnets	86391A	1
2. Hub Carrier Ring - 6 Holes	77020	1
3. Hub, Aluminum 6-Hole (Grinder)	77010	1
4. Rubber Ring , 4-1/2" OD x 1/2" THK	10112	2
5. Magnet, Neodymium Ring 7/8 x 1/8	36064	3
6. Screw, Flat HD Phillips 8-32 x 1/2	10647	3
7. Nut, Keps Lock 8-32 Zinc	10462	3
8. Screw, SKT HD CAP 3/8-24 x 1-3/4	10354	3
9. Screw, SKT HD CAP 3/8-24 x 2	10012	3
10. Spacer, Steel 9/16OD x 3/8ID x 7/32	10113	3
11. Nut, Hex Lock 3/8-24 w/Nylon Patch	10058	3
12. Nut Hex Jam 3/8-24 Zinc (Use Blue Loctite)	11725	3
13. Spacer, Steel 5/8OD x 3/8ID x 3/8T	10011	6



10" MAGNA-TRAP™ DISC ASSEMBLY

- **ASSEMBLY HUB:** On three (3) 2" long bolts place the larger spacers as shown (See figure 1).
- **POLY RINGS:** Place one of the poly rings on the hub orienting the large holes over the large holes in the hub (See figure 2).
- **HUB CARRIER RING:** Place the hub carrier ring over the poly ring so holes in hub carrier ring line up with holes in the poly ring as shown (See figures 3 and 4).
- **BOLTS WITH SPACERS:** Thread the pre-assembled bolts with spacers through the hub carrier ring, poly ring and into the threaded holes of the hub (See figures 5 and 6).

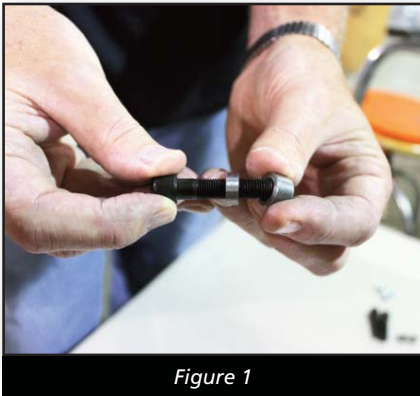


Figure 1

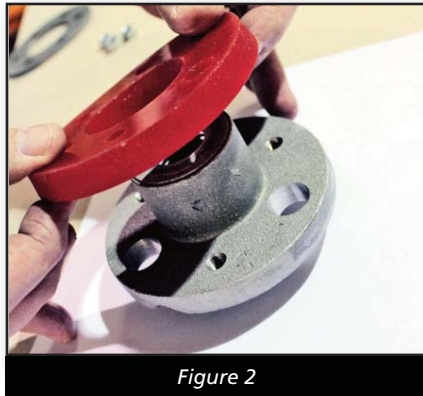


Figure 2

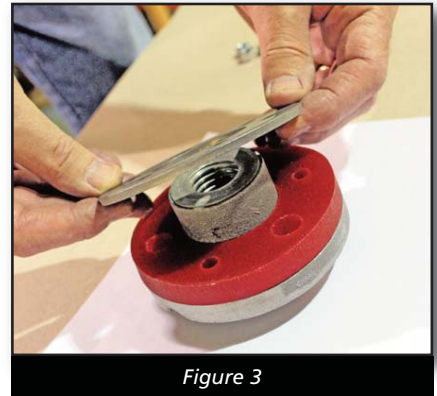


Figure 3

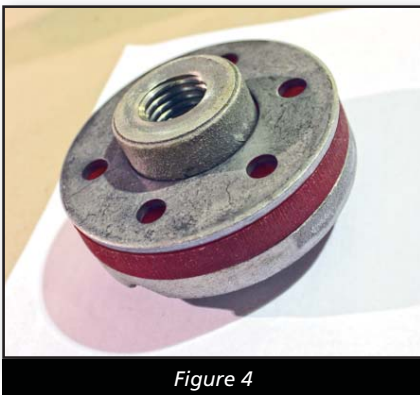


Figure 4



Figure 5

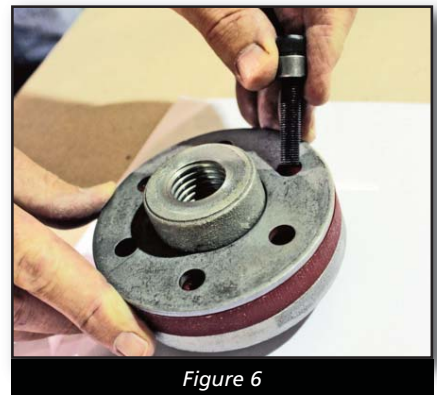


Figure 6

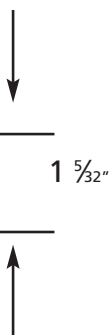
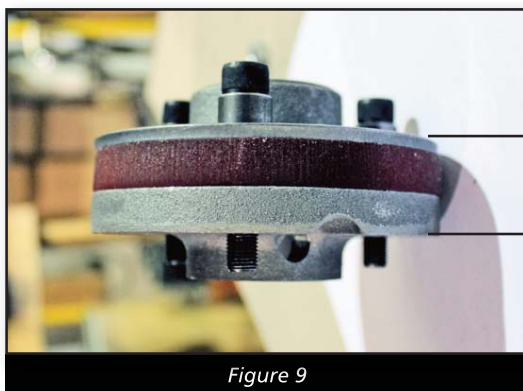
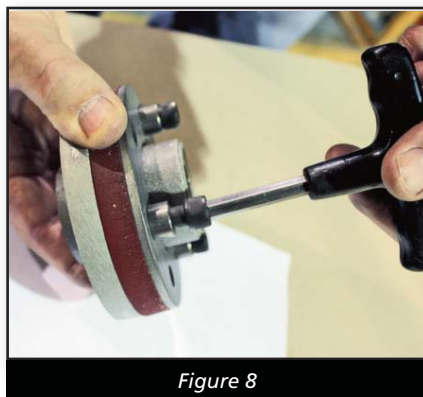
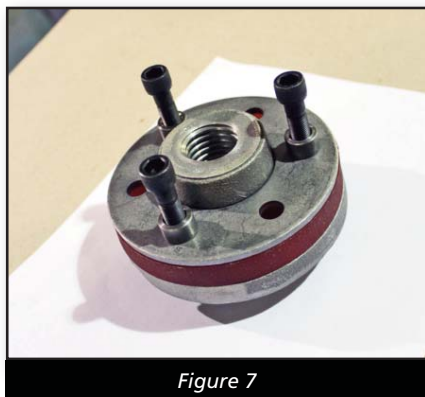


10" MAGNA-TRAP™ DISC ASSEMBLY

- **BOLTS:** Tighten the bolts finger tight as shown (*See figure 7*). *Do not wrench tighten!*
- **ADJUST BOLTS:** Using a 5/16" hex wrench as shown, adjust the bolts until you feel the ring starting to compress and the bolt reaching the point of being snug, you should feel some resistance. *Do not overtighten, this is a critical adjustment.* The ring should compress to the point where there is a slight radius, this can be seen in the photo on the left.

This does not mean the poly ring has to squash out between the hub carrier ring and hub. There should be a small radius as the poly ring begins to compress (*See figure 8*).
- **DON'T COMPRESS:** The pressure should be identical on all three (3) bolts. Do not tighten to the point where the poly ring is badly distorted or compressed to much. This will defeat the purpose of the poly rings. This measurement should be close to 1 5/32" from the bottom of the hub to the top of the hub carrier ring. Measure at each of the three (3) bolts around the edge of the hub and adjust each of the bolts to maintain the same measurement at all three (3) bolts as shown below (*See figure 9*).

IMPORTANT! Once set do not move or turn the bolts from this setting.





10" MAGNA-TRAP™ DISC ASSEMBLY

- **LOCK NUTS:** Place three (3) nuts as shown, finger tighten (*See figures 10*).

IMPORTANT! Do not wrench tighten at this time.

IMPORTANT! Making sure not to move or turn the bolts, insert a hex wrench in one of the bolts, hold in position do not move or turn hex wrench (*See figures 11*).

Holding the hex wrench as stated above, using a 9/16" socket tighten the lock nuts securely making sure the hex wrench did not move during the process. If it did move then the measurement and alignment will have to be performed again, this applies to all of the bolts. Repeat the process with the two (2) remaining bolts. When finished repeat the measuring steps perform earlier to insure they did not change. If they did change, the process will have to be repeated (*See figures 12*).

Once the previous step has been completed and the measurements are correct, continue with the following steps.

Place a 2nd poly ring on the hub as shown in the photo with the large holes over the bolts. (*See figures 13 and 14*).



Figure 10



Figure 11

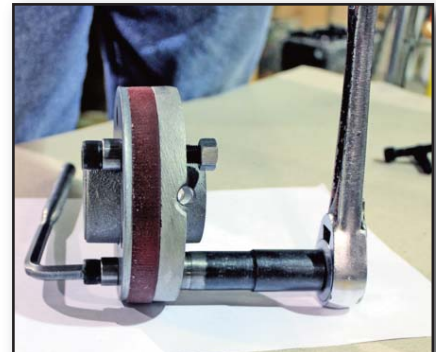


Figure 12

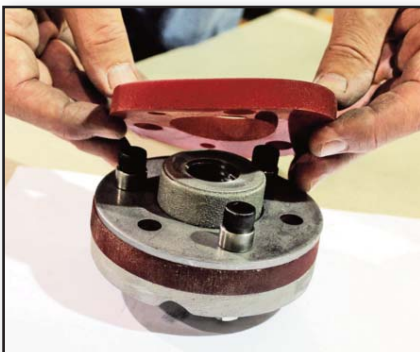


Figure 13



Figure 14



10" MAGNA-TRAP™ DISC ASSEMBLY

Place the hub and newly installed poly ring onto the disc so the small bolt holes line up with the small bolt holes in the disc (*See figures 15*).

Pre-assemble 3/8 - 24 x 1 3/4" S.H cap screw with one large and one small spacer. Install small spacer first (*See figures 16*).

- **PRE-ASSEMBLED** Insert the three bolts with spacers into the three (3) remaining bolt holes in the hub and tighten finger tight, do not wrench tighten at this time. Make sure bolts align with holes so you don't cross the threads (*See figures 17*).
- **TIGHTEN SCREWS:** Using a 5/16" hex wrench tighten the screws until you feel the poly ring starting to compress and the bolt reaching the point of being snug. This step is similar to the one performed earlier on the hub. You should feel resistance for the adjustment, do not overtighten to distort the poly ring. It should compress to the point where there is a slight radius, just like on the hub earlier. This measurement should be approximately 2 1/8" from the top edge of the hub to the surface of this disc (*See figures 18*).
- **JAM NUTS:** Place three (3) Jam nuts on the three (3) bolts as shown (*See figure 8*), finger tighten, do not turn the bolts, if you do the adjustment will have to be performed again. Use a drop of Red loctite on each nut (*See figures 19 and 20*).



Figure 15



Figure 16



Figure 17

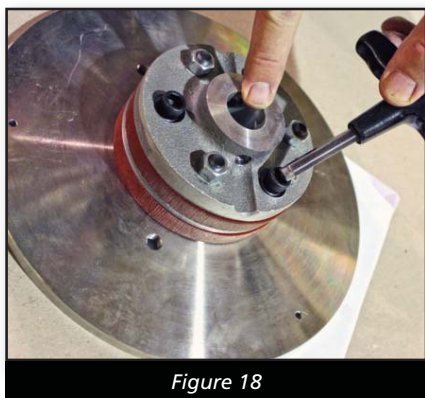


Figure 18

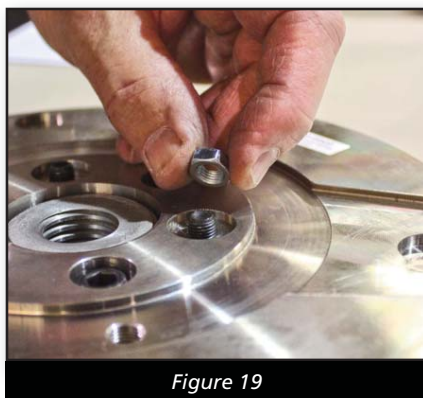


Figure 19

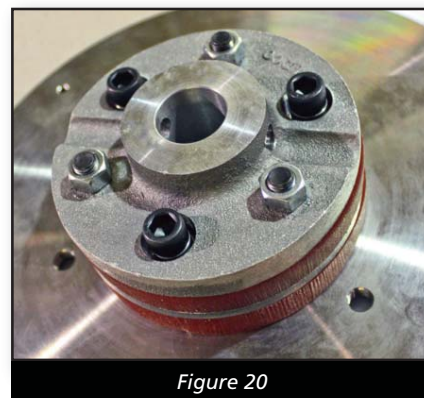


Figure 20



10" MAGNA-TRAP™ DISC ASSEMBLY

IMPORTANT!: Make sure not to move or turn the bolts, insert a 5/16" hex wrench in one of the bolts, hold in position, do not move or turn the hex wrench (*See figures 21*).

Holding the 5/16" hex wrench as stated above, using a 9/16" socket tighten the lock nut securely making sure the hex wrench did not move during the process. If it did move then the measurement and alignment will have to be performed again, this applies to all of the bolts. Repeat the process with the two (2) remaining bolts. When finished repeat the measuring steps performed earlier to insure they did not change. If they did change, the process will have to be repeated (*See figures 22*).

Once the previous step has been completed and the measurements are corrected, continue with the following step.

When the disc has been completely assembled place it on a flat level surface as shown on the left, measurement three points around the disc, a good reference point is straight out from each of the three (3) bolts with lock nuts. The measurement should be 2 1/8" (*See figures 23*).

If the measurements are off then the alignment will have to be repeated for the last part of this procedure. ***If this did not correct the problem then the whole procedure will have to be repeated.***

If this is the case, remove the lock nuts, back the bolts out and let the poly ring regain its uncompressed state, this might take a few minutes, then repeat the procedure.

Completed disc assembly
(*See figures 24*).

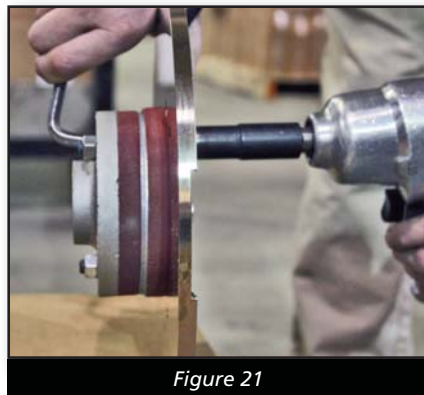
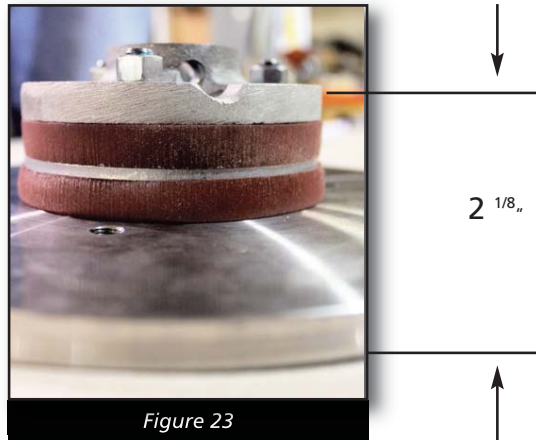


Figure 21



Figure 22

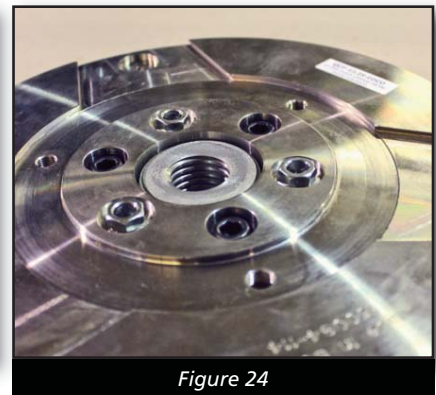


Figure 24



INSTALL MAGNETS

Put one magnet in each pocket with countersink taper up (*See figures 25*).

Install one 8-32 x 1/2 Flat Head Phillips screw in each magnet (*See figures 26*).

Install 1 8-32 Keps Lock Nut on each screw. Hand tighten (*See figures 27*).

Complete installation by tightening screws. Use Phillips head screw driver and rest against thumbs to overcome magnetic pull. Don't overtighten. Magnets will split (*See figures 28*).



Figure 25



Figure 26

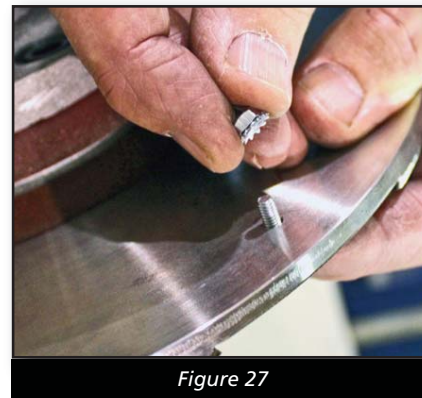


Figure 27

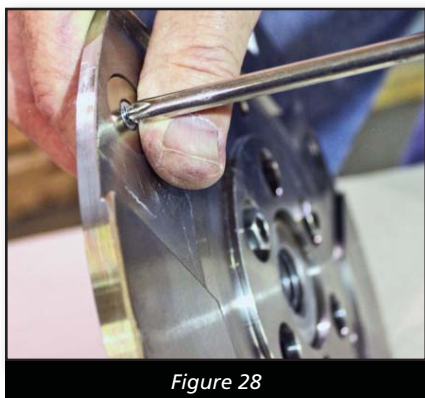
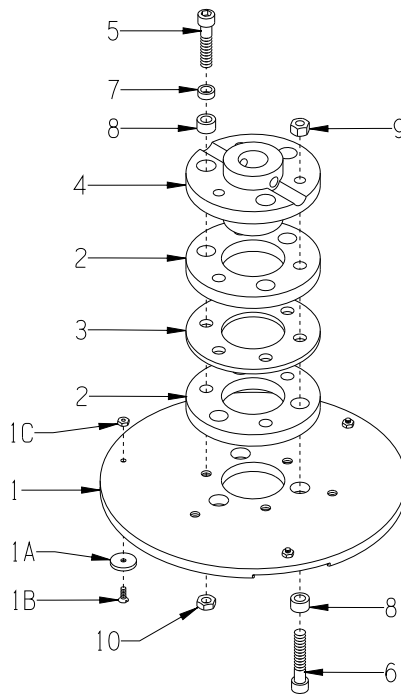


Figure 28



**10" MAGNA-TRAP™ DISC ASSEMBLY
FOR MODELS
SEC-NG, 2EC-NG & 2GC-NG
PART # 86391A**



ITEM #	PART #	DESCRIPTION	QTY
1	86391	MAGNA-TRAP™- 10" DISC W/MAGNETS (INCLUDES ITEMS 1A, 1B AND 1C)	1
1A	36064	MAGNET, NEODYMIUM RING 7/8 X 1/8	3
1B	10647	SCREW, FLAT HD PHILLIPS 8-32 X 1/2	3
1C	10462	NUT, KEPS LOCK 8-32 ZINC	3
2	10112	RING, RUBBER, 4-1/2" OD X 12" THK	2
3	77020	RING, HUB CARRIER, 6-HOLE	1
4	77010	HUB, ALUMINUM 6-HOLE (GRINDER)	1
5	10354	SCREW, SKT HD CAP 3/8-24 X 1-3/4	3
6	10012	SCREW, SKT HD CAP 3/8-24 X 2	3
7	10113	SPACER, STEEL 9/16 OD X 3/8 ID X 7/32	3
8	10011	SPACER, STEEL 5/8 OD X 3/8 ID X 3/8 T	6
9	10058	HUT, HEX LOCK 3/8-24 W/NYLON PATCH	3
10	11725	HUT, HEX JAM 3/8-24 ZINC (USE RED LOCTITE)	3



NOTES:

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