



TClinic

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DYNAMO PULLEY SALVAGE by Phil Marino, TCMG

The following will salvage an original aluminum dynamo pulley that has worked loose and had the center bore mangled up. Basically we are boring out the damage and inserting a new piece with new bore.

Fabricate new bushing per attached sketches. Chuck pulley in lathe, making sure belt groove runs concentric & square prior to boring .8755 (plus .001, minus .000) diameter hole. This will barely skim bottom of old pull keyway in pulley. Press in new bushing from the back of pulley. Use arbor press or suitable instrument. Back inner bore of pulley with suitable block in order not to crack the front flange while pressing. Use lanolin paste or heavy oil on bush and bore to ease the pressing task.

Turn pulley with cooling vanes down on drill press table. Drill $\frac{7}{64}$ " starting hole by $\frac{9}{16}$ " deep. For safety, dowel, ream hole to .125 diameter, using a reamer for new drill. Install $\frac{1}{8}$ " dia. x $\frac{1}{2}$ " long dowel. If .125 hole is larger than the dowel, stake bore with center punch. (This pin is to ensure that the new bushing will not rotate in the pulley under load.)

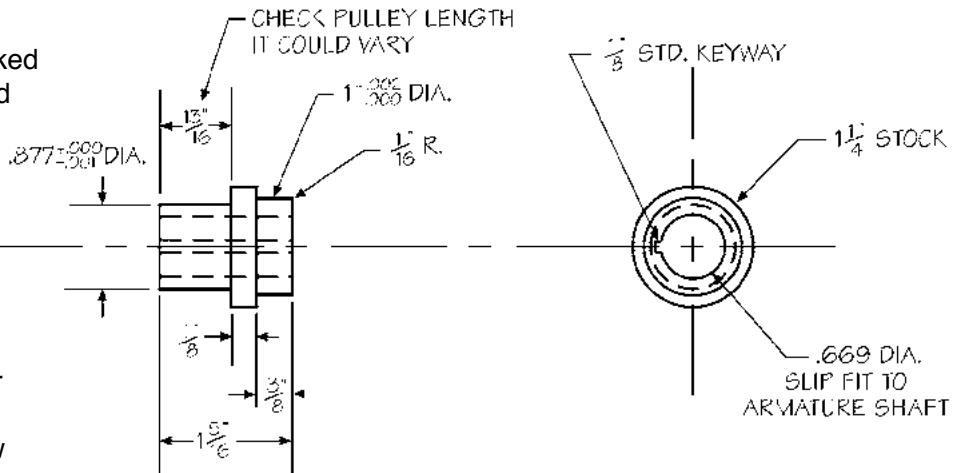
You will notice that the new bushing is longer than the pulley. This is because it has been lengthened to incorporate the old thrust sleeve that went in the back of the pulley, pushing against the front bearing inner face. As a result the new assembly is much stronger than the original design.

By following the above procedure, you are now ready to install your pulley back on the dynamo for a long and trouble-free life.

First printed by TCMG in 1986

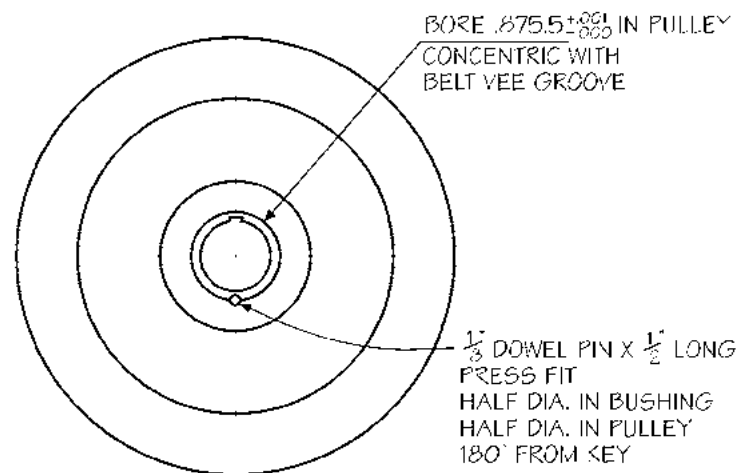
2002 Update

To repair the V groove see TClinic #34.



NOTE: THRUST SLEEVE HAS BEEN INCORPORATED IN THE BUSH FOR ADDED STRENGTH

BUSH GEN. PULLEY REPAIR MATERIAL - STEEL



FRONT VIEW
GENERATOR PULLEY REPAIR