

THM700-R4/AT540

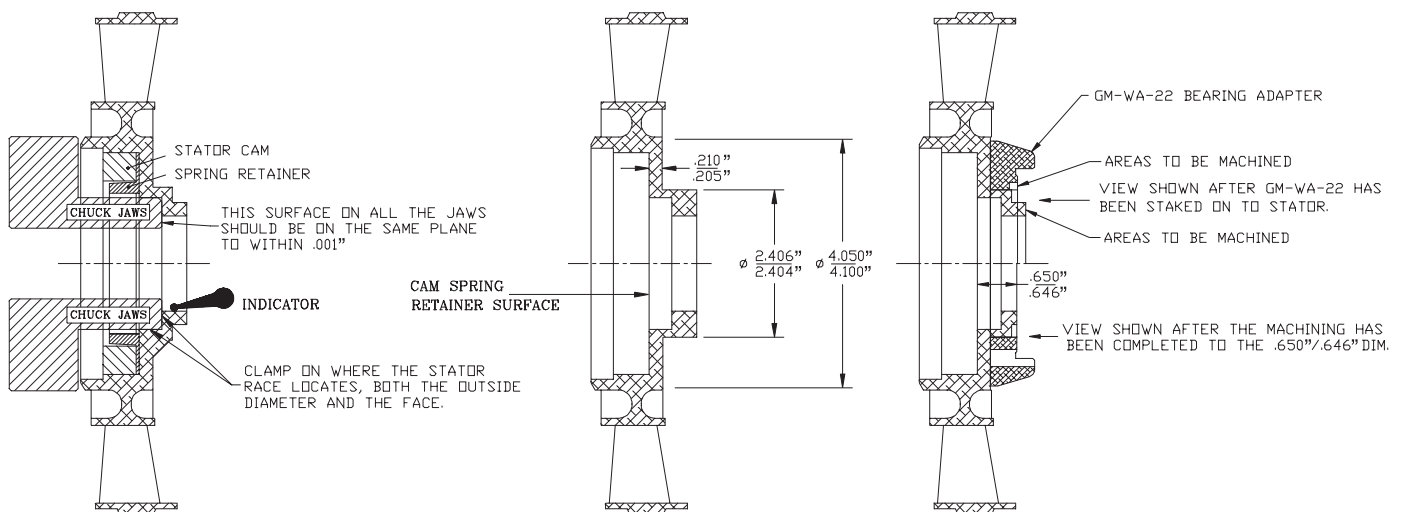
GM-WA-22

Bearing Adapter to Convert THM400 Stator to AT540 Application

VIEW A-A

VIEW B-B

VIEW C-C



RECOMMENDED MACHINING INSTRUCTIONS FOR THM400 STATOR

- 1) With the stator cam and spring retainer still in the stator, chuck and locate on the areas as shown in view A-A. Make sure that the face of the chuck jaws at the locating point are all on the same plane to within .001" TIR (Total Indicator Reading).
- 2) Make sure that the stator is pushed up against the stator race surface face. Indicate area as shown in view A-A to within .001" TIR (Total Indicator Reading).
- 3) Once everything is indicated, machine the area (shown in view B-B) where you will mount the **GM-WA-22** bearing adapter, (2.406"/2.404" Diameter .210"/.205" Dimension out to 4.05"/4.10" Diameter).
- 4) After machining, you are ready to install the bearing adapter **GM-WA-22**. See drawing on reverse side for manufacturing a clamping fixture and assembly instructions.
- 5) Once the bearing adapter GM-WA-22 has been installed, machine the bearing surface to .650"-.646" Dimension as shown in view C-C.

GM-WA-22 Bearing Adapter to Convert THM400 Stator to AT540 Application

INSTALLATION INSTRUCTIONS FOR GM-WA-22 BEARING ADAPTER USED WITH GM-N-13H

1) Recommended tools:

- A) $\frac{3}{16}$ " Diameter Flat Punch
- B) Clamping fixture, as shown in Figure (4) Clamping Fixture

2) Clamp everything together as shown in Figure (1) Assembly View.

Note: Make sure holes in GM-WA-22 bearing adapter lineup with the holes in the stator, as shown in figure (2), and also that the slots in the top plate line up with staking area on GM-WA-22 adapter.

3) Stake the area as shown in Figure (3) and section A-A.

Note: GM-WA-22 bearing adapter should be clamped in place to avoid the possibility of getting staked in place.

4) After the bearing adapter has been staked on, it still has to be machined. See view C-C on the machining instructions.

FIGURE (1)
ASSEMBLY VIEW

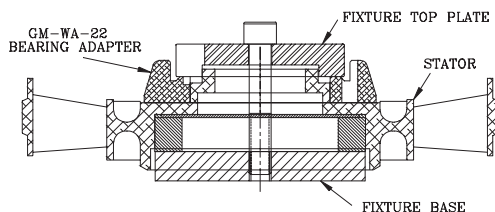


FIGURE (2)

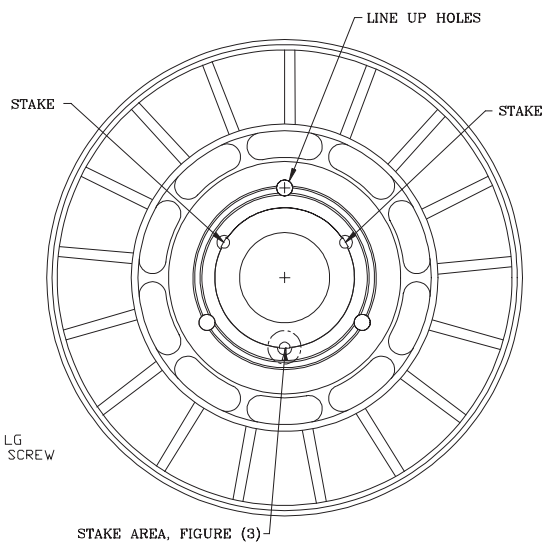


FIGURE (3)
SCALE 4/1

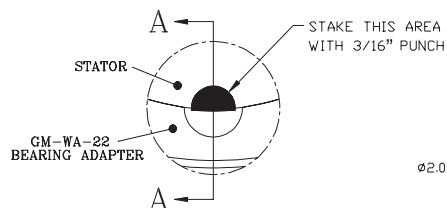
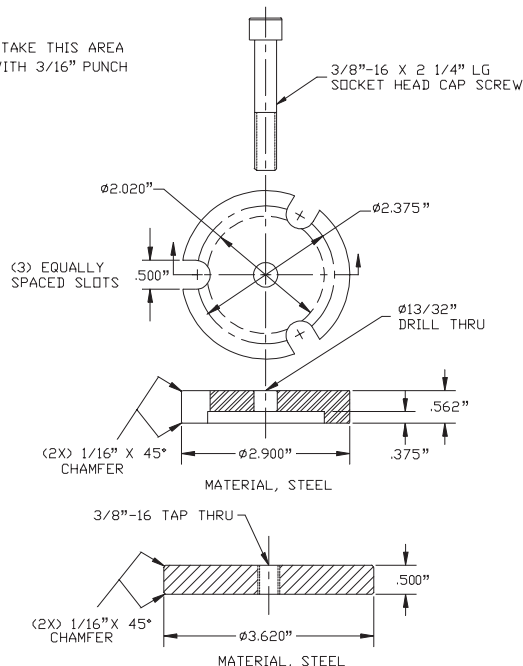


FIGURE (4)
CLAMPING FIXTURE



SECTION A-A
SCALE 10/1

