



1 N Haven St  
Baltimore MD 21224  
(410) 732-3500  
www.sullivanuv.com

## ***Procedure for Enlarging the Center Bore of Sullivan Pancake Style Alternators***

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Step 1: Align drill head and table to provide clearance for thru drilling.

**Notes:**

- Choose a drill bit that will provide  $+0.0005$  to  $+0.0025$  clearance to the shaft the alternator will be mounted to.





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Step 2: Mask windings from swarf and fluids.

**Notes:**

- Do not mask outer edges of the shell as this is where you will be clamping.



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Step 3: Center alternator to drill head.

**Notes:**

- Use a pin or drill bit that matches the original size of the alternator center bore.
- Make sure table is locked from moving from this point forward





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Step 4: Clamp alternator to table with centering pin still in place.



**Notes:**

- Clamp snugly on outer edges. Be sure clamps are flat and wide at contact area to avoid damaging the edge of the alternator.

**Notes:**

- Be sure to avoid contacting the wires of the stator when clamping.





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## ***Procedure for Enlarging the Center Bore of Sullivan Pancake Style Alternators***

Step 5: Exchange centering pin for desired drill bit or reamer and drill.

**Notes:**

- Ensure the table and alternator are not moved before drilling takes place.
- Cutting fluid may be used lightly to improve cutting. Do not use flood or mist cooling fluids.
- Edges of the new bore should be chamfered or deburred.

