McCULLOCH SERVICE BULLETIN

NO. 1583

MODEL H-Series Generators

DATE March 24, 1975

SUBJECT New Temporary Tooling For Removal of Rotors of H-Series Generators.

Generators now in production are manufactured with Shrink-Fit Rotor Hubs. Rotors are permanently attached to the hubs, which eliminates the need for the 1/4-in.-socket retaining screws. Spanner Wrench, P/N 21506, is no longer required for disassembly of the new generators (although the spanner wrench should be kept for use with earlier units). Instead, a small block of wood is used to brace the rotor when the Rotor Retaining Bolt, P/N 21743 (H-1500 and H-2000); P/N 21143 (H-3000), is removed.

Figure 1 shows the shape and dimensions of the Rotor Brace Block. The block can easily be made of almost any wood, such as soft pine, and with ordinary shop tools. Dimensions are approximate and only need to be held to ± 1/16 in. (1.6 mm), except for the rotor fin clearance notch (Dimen. F), which should be no less than 1/4 in. (7 mm), but can be more.

Figure 2 shows the generator on a firm, flat surface, with the front cover removed, and the rotor brace block being positioned under any fin in a horizontal (flat) position, on the left side of the rotor.

NOTE: The generator shown is an H-2000. In removing the rotor of the H-3000, the Cradle, P/N 21613, must be removed before the rotor can be taken off.

Be sure that the rotor brace block is positioned so that all of the flat surface of the fin is supported by the block; this will prevent bending of the fin.

Figures 3 and 4 show the removal and re-installation, respectively, of the rotor retaining bolt.

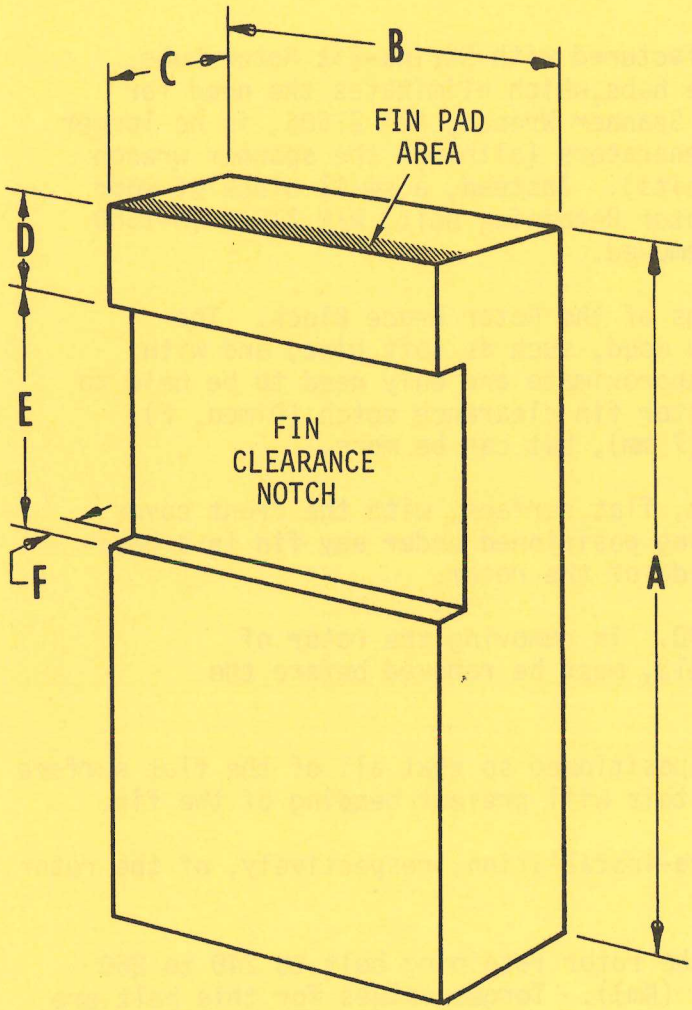
When re-installing the rotor, torque the rotor retaining bolt to 240 to 260 pound-inches (26.4 to 29 Newton-meters (Nm)). Torque values for this bolt are the same for all three generators.

McCULLOCH CORPORATION

Product Service
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Dimension	Inches	Millimeters
A	7-3/4	197
B	3-1/2	89
C	1-1/2	38
D	1	25
E	2-1/2	64
F	1/4	7

Figure 1. Rotor Brace Block.

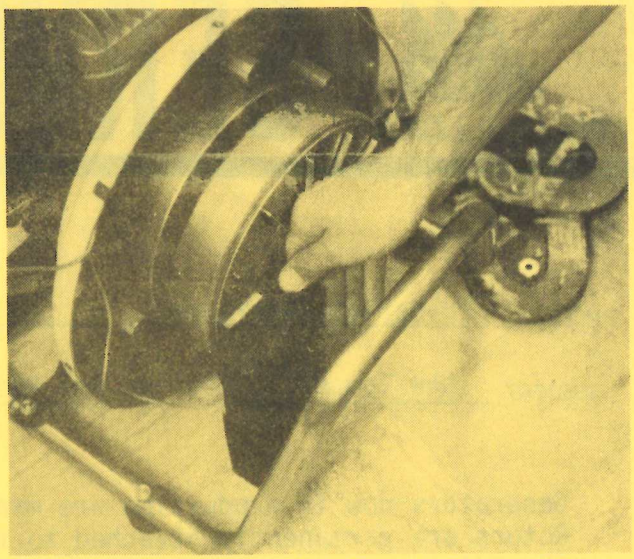


Figure 2. Positioning Rotor Brace Block.

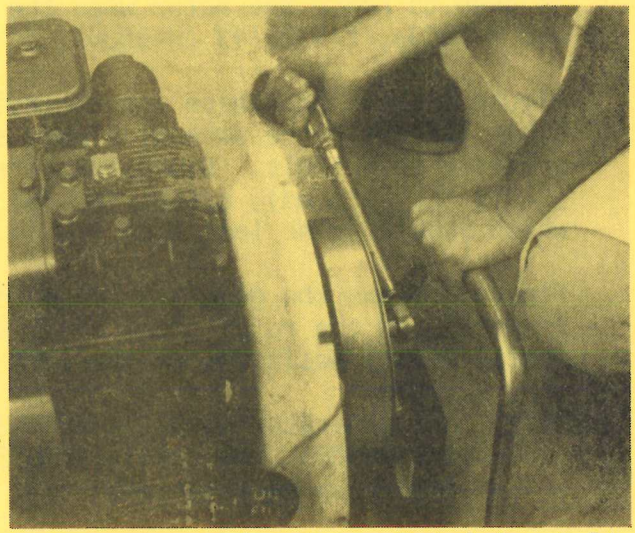


Figure 3. Loosening Rotor Retaining Bolt.

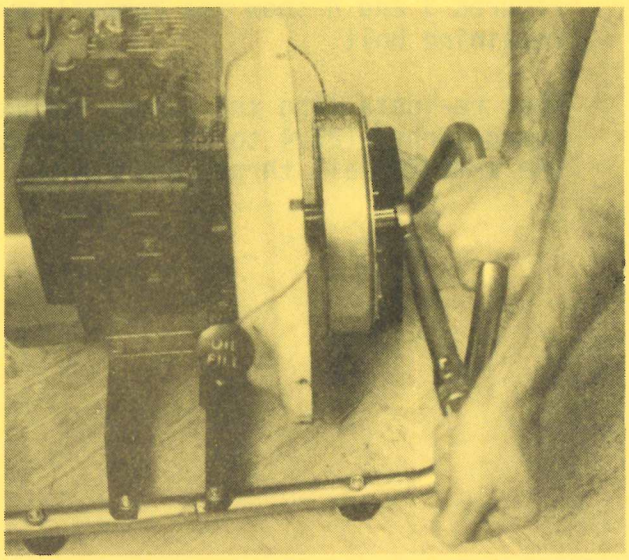


Figure 4. Tightening Rotor Retaining Bolt.