

# SERVICE

## SHOP DOPE

No. 295A  
(Supplement to 295)

November 23, 1955

### ADAPTER KIT FOR ASSEMBLING MODEL 165 AND HUMMER FLYWHEELS

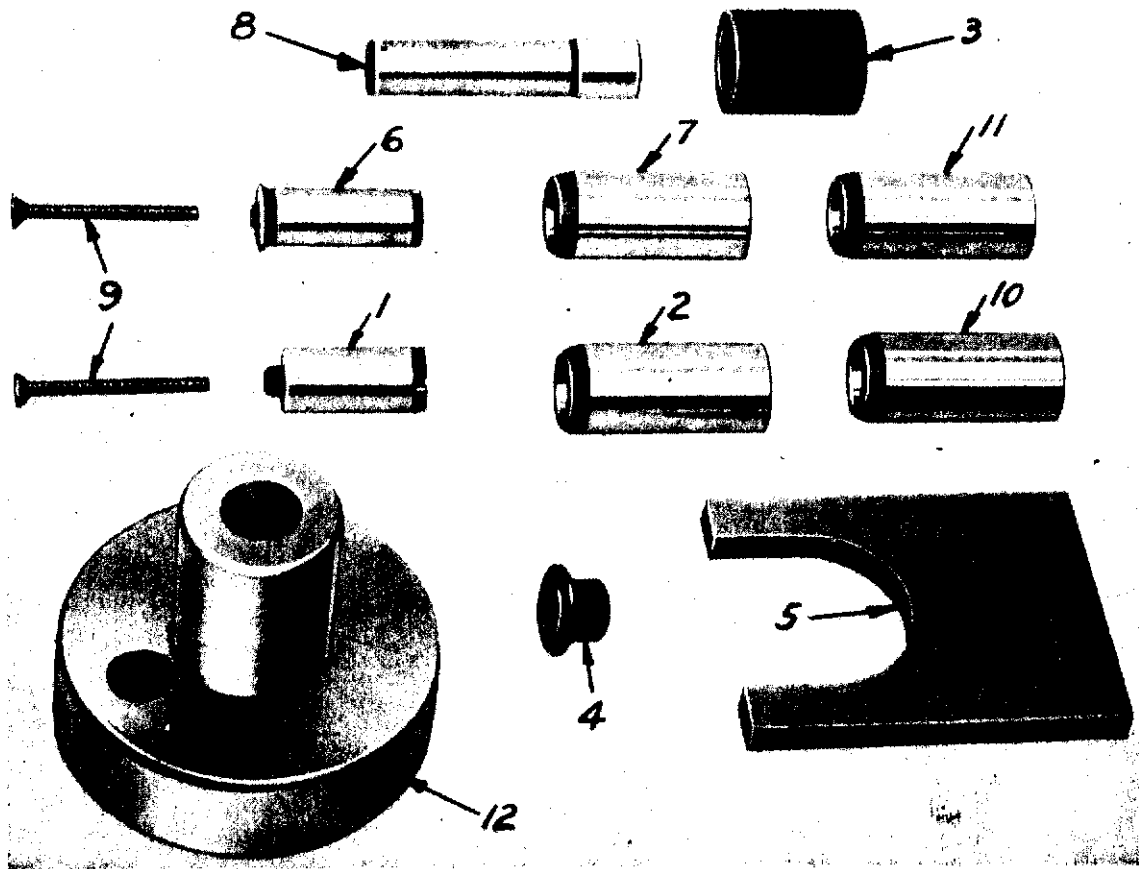


ILLUSTRATION I. FLYWHEEL ADAPTER KIT -- PART NO. 96124-55

Item No.	Part No.	Description
1	96136-55	Crank Pin Aligning Pilot
2	96134-55	Crank Pin Pilot Aligning Sleeve (for standard size pin)
3	96135-55	Crank Pin Press Cap
4	96149-55	Crank Pin Support Plug
5	96150-55	Flywheel Spacer Gauge
6	96152-55	Crank Pin Aligning Pilot
7	96155-55	Crank Pin Pilot Aligning Sleeve (for standard size pin)
8	96153-55	Armature Shaft and Sprocket Shaft Pilot
9	96139-49	Crank Pin Aligning Pilot Screws (2)
10	96155-56	Crank Pin Pilot Aligning Sleeve (for .002" oversize pin) Use with Crank Pin Aligning Pilot (1) in same manner as Aligning Sleeve (2) for standard size crankpin.
11	96134-56	Crank Pin Pilot Aligning Sleeve (for .002" oversize pin) Use with Crank Pin Aligning Pilot (6) in same manner as Aligning Sleeve (7) for standard size crankpin.
12	97195-56	Magneto Shaft Locating Press Block

NOTE: Above item numbers correspond with the  
number stamped on each part of the adapter kit.

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This supplement, Shop Dope No. 295A, is used in connection with Shop Dope No. 295, to install flywheel shafts in the Model 165 and Hummer flywheels. The instructions contained herein cover use of the adapter kit which is required when using the Model 125 Flywheel and Connecting Rod Assembly Tool Set Part # 96125-49 for assembling Model 165 and Hummer flywheels.

Instructions in Shop Dope No. 295 apply to Model 165 and Hummer flywheels except as outlined herein.

NOTE: The tool numbers appearing in the following instructions correspond with the items listed below the illustration on page 1 of this bulletin (295A), and the tool letters correspond with items listed below the illustration on page 1 of the Shop Dope 295.

#### INSTALLING MAIN SHAFTS

Install key in armature shaft or magneto shaft and place end of shaft in "Locating Press Block" (Item I for 165 Model or Item 12 for Hummer Model). Insert other end of shaft through "Shaft Installing Plate" (B) into flywheel.

For 165 and Hummer Models, use "Armature Shaft and Sprocket Shaft Pilot" (8) instead of "Drift and Pilot Pin" (J) Page 1 Shop Dope 295. Insert larger end of pilot into crank pin hole, then smaller end through hole in installing plate and hole in press block. Proceed to press in as described in Shop Dope 295, page 5.

#### INSTALLING CRANK PIN PILOT

Use "Crank Pin Aligning Pilot" (1) and "Crank Pin Pilot Aligning Sleeve" (2), instead of "Crank Pin Aligning Pilot" (H) and "Crank Pin Pilot Aligning Sleeve" (G), as shown on page 1 of Shop Dope No. 295 and described on page 6.

#### PRESSING CRANK PIN INTO RIGHT FLYWHEEL:

Use "Crank Pin Press Cap" (3) instead of "Press Cap" (K), as shown on page 1 of Shop Dope No. 295 and described on page 6. This press cap is designed to press the crank pin the correct distance into the right flywheel, therefore, it is of utmost importance that this press cap be used when pressing the

crank pin into the Model 165 or Hummer right flywheel. After crank pin is pressed into the flywheel, remove the press cap and crank pin pilot.

On the other end of the crank pin, attach "Crank Pin Aligning Pilot" (6), with tapered end of pilot located in end of crank pin. Pass "Screw" (9) through crank pin from opposite end. Start screw into the tapered end of crank pin aligning pilot, but do not tighten. Slide "Crank Pin Aligning Sleeve" (7) over crank pin aligning pilot and crank pin. Tighten screw. Remove crank pin pilot aligning sleeve. Install connecting rod and rod and roller bearings.

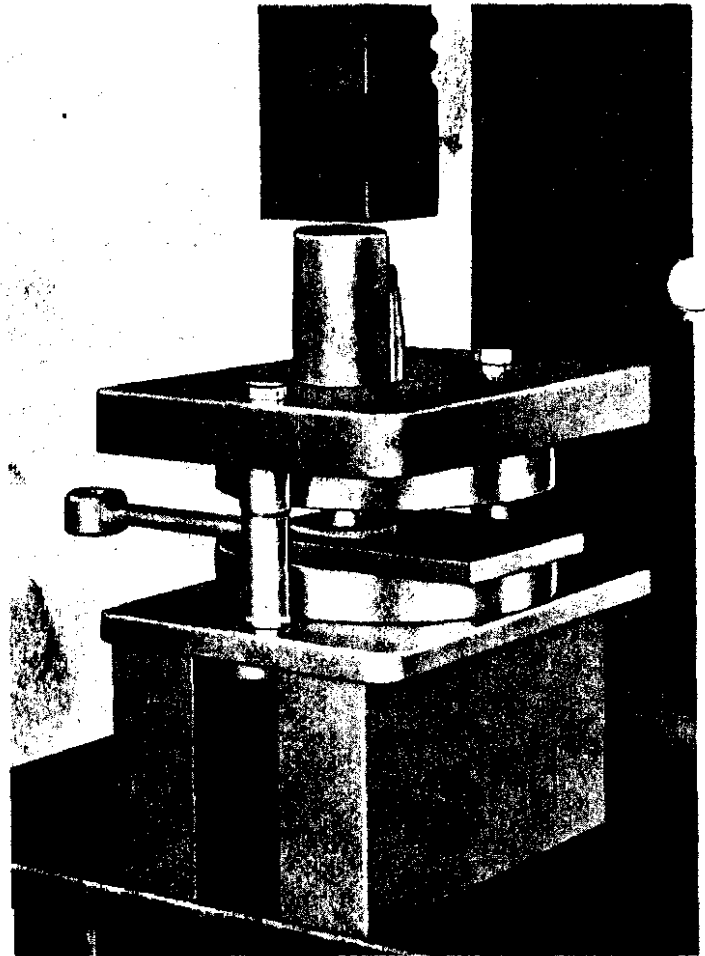


ILLUSTRATION 2

#### PRESSING FLYWHEELS TOGETHER:

Insert "Crank Pin Support Plug" (4) into crank pin pilot hole in the "Armature Shaft Installing Plate" (B), shown on page 1 of Shop Dope 295. Place flywheel that has crank pin and connecting rod installed, on armature shaft installing plate and bring the

end of crank pin (in flywheel) into contact with the crank pin support plug.

NOTE: "Sprocket Shaft Installing Plate" (C), shown on page 1 of Shop Dope No. 295, is marked on one side (THIS SIDE UP). On the opposite side of plate install the sprocket shaft through sprocket shaft pilot hole and bring the flywheel to rest against plate. Holding left flywheel against plate, start the plate and flywheel on guide pins attached to the armature shaft installing plate and at the same time guide crank pin pilot through flywheel, then through hole in sprocket shaft installing plate which corresponds with crank pin hole in flywheel.

Push sprocket shaft installing plate and left flywheel downward, by hand, until left flywheel contacts end of crank pin.

Place "Flywheel Spacer Gauge" (5) between flywheels with the U-section of gauge placed around the bearing end of connecting rod. The correct position of spacer gauge and connecting rod is shown in Illustration 2. Place "Press Block" (F), as shown on page 1 of Shop Dope No. 295, and described on page 7, over protruding end of crank pin aligning pilot. Press down sprocket shaft installing plate until flywheel bottoms against the flywheel spacer gauge.

Remove crank pin aligning pilot and flywheel spacer gauge.

Check flywheel alignment in flywheel truing stand.

96125-49  
96124-55

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