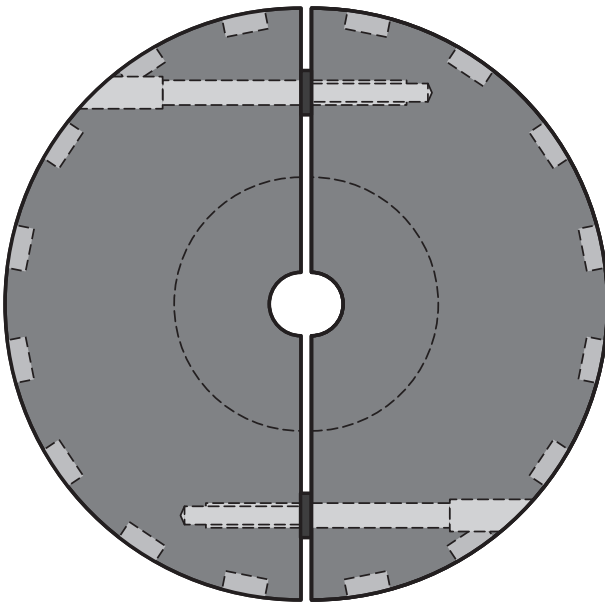


A Pulser Wrap is made by cutting the material (typically PVC or Aluminum) to the correct width and approximate diameter, and then turning the material down on a lathe to the desired Outside Diameter. The Inside Diameter of the wrap is then bored to the exact diameter of the shaft that the wrap will be mounted on. Magnet holes are drilled, bolt holes are drilled and tapped, and the wrap is split in half with a band saw.

Because 0.045 inches of material is removed when the band saw cut is made, the bolts are able to pull the wrap halves tight around the shaft when it is re-assembled. Another result of removing the material is that the center hole of the wrap is no longer round when the wrap halves are assembled off the shaft. When enlarging the Inside Diameter of a wrap the missing material must be compensated for or the wrap will be difficult to machine and will not fit the shaft properly.



Use the following procedure when enlarging the Inside Diameter of a wrap:

1. Install 0.045" shims (see diagram at left)
2. Tighten bolts securely, but do not over tighten (5 ft. lb. max.).
3. Check the roundness of the Inside Diameter with a dial caliper. The I.D. must be within 0.005" all around.

The roundness of the bore (I.D.) can be changed by tightening or loosening the bolts. If roundness within 0.005" cannot be obtained try repositioning the shims.

4. Machine the material to the desired Inside Diameter