**Standard blower pulley to Delta shaft adapter**

Aluminum bar stock requirement and Lathe Operations



**Aluminum 3 ½” Bar Stock – Order on e-bay (cut to size)**

* Back piece - .437 + .150 = .587 + about 1/8 excess when cut = .71. Order 5/8”. Note: 1/8 excess required to hold on lathe. This is standard excess from supplier.
* Front piece – 1.100 + .15 = 1.250 + about 1/8 excess when cut by supplier = 1.375. Order 1 ¼”.

**Back Piece**

* Find square end – chuck on this end.
* Indicate OD at end furthest from chuck to minimize runout +/- .002.
* Face to cleanup.
* Turn OD to minimum cleanup down to jaw.
* Chamfer 45 degree.
* C-drill for 1.373 center hole.
* Drill 5/8” through for 1 5/16” hole.
* Drill 1 5/16” as deep as possible to clear chuck jaws. Use 1 5/16” Deming drill (shank reduced to ½”).
* Turn part around.
* Indicate OD to +/- .001.
* Face to .587 (.437 + .150).
* Cut .150 step x 2.001 +/-.001 (Check 2” hole in pulley for proper fit).
* Chamfer all sharp edges.
* Bore center hole to 1.377 +/\_.001 and chamfer. Check with 1.373 locator for easy fit.

**Front Piece**

* Find square end – chuck on this end.
* Indicate OD at end furthest from chuck to minimize runout +/- .002.
* Face to cleanup.
* Turn OD to minimum cleanup down to jaw.
* Chamfer 45 degree.
* C-drill for 1.373 center hole.
* Drill 5/8” through for 1 5/16” hole.
* Drill 1 5/16” as deep as possible to clear chuck jaws. Use 1 5/16” Deming drill (shank reduced to ½”).
* Turn part around.
* Indicate OD to +/- .001.
* Face to 1.250 (1.100 + .150).
* Cut .150 step x 2.001 +/-.001 (Check 2” hole in pulley for proper fit).
* Chamfer all sharp edges.
* Bore center hole to 1.377 +/\_.001 and chamfer. Check with 1.373 diameter aluminum locator for snug fit.

Bridgeport milling operation next.