

Bearing Adapter

Part No.

AL-WA-2

NOTE: Adapts late-model impeller side bearing AL-N-1 to earlier applications.

Allison® 1000/2000/2400, Early



Impeller Hub Modifications

- Chuck the impeller onto a lathe. Using an indicator, adjust the hub bearing mating surface run-out and bearing pilot wall run-out to zero or as close as possible to zero.
- Increase the diameter of the bearing pocket to 98.43–98.17mm (3.875–3.865").
- Do not remove more than 0.13mm (.005") material from the hub's bearing surface.
- Leave a surface finish of 1.6 micrometers (63 microinches) or better.
- Undercut the inside corner as illustrated above.
- Reduce the bearing pilot wall to new bearing mating surface to 5.59–5.33mm (.220–.210") as illustrated.
- Remove all burrs and break sharp edges.

