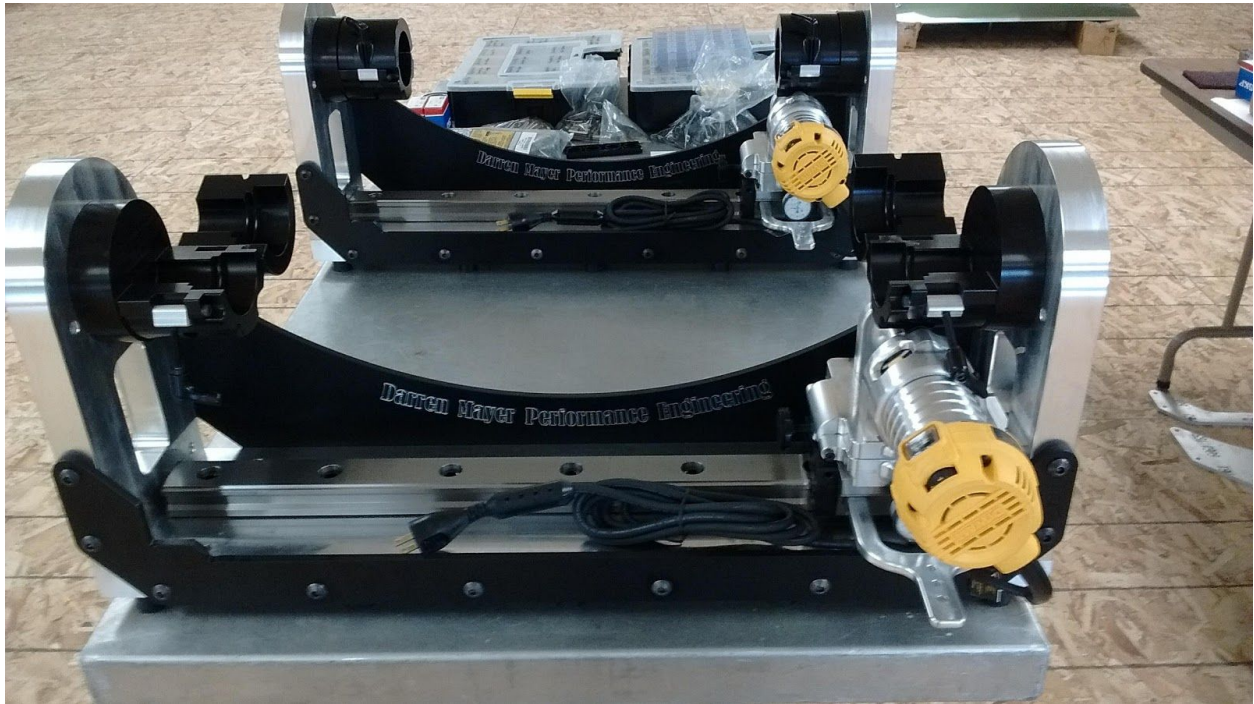


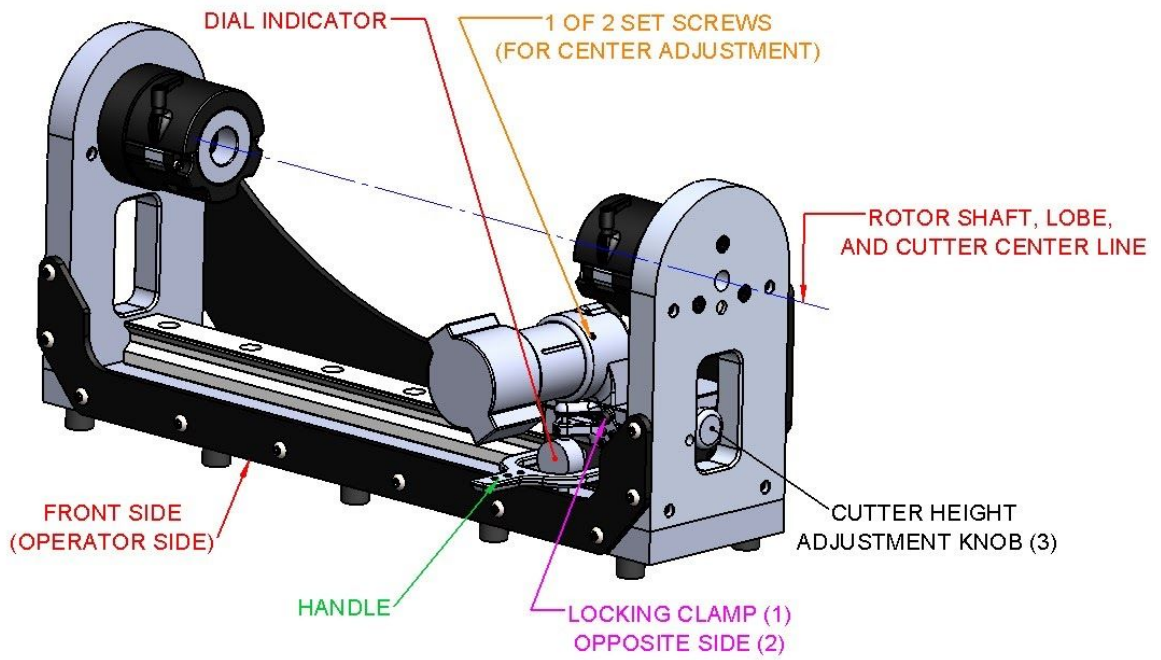


T/F Rotor Seal Trimmer

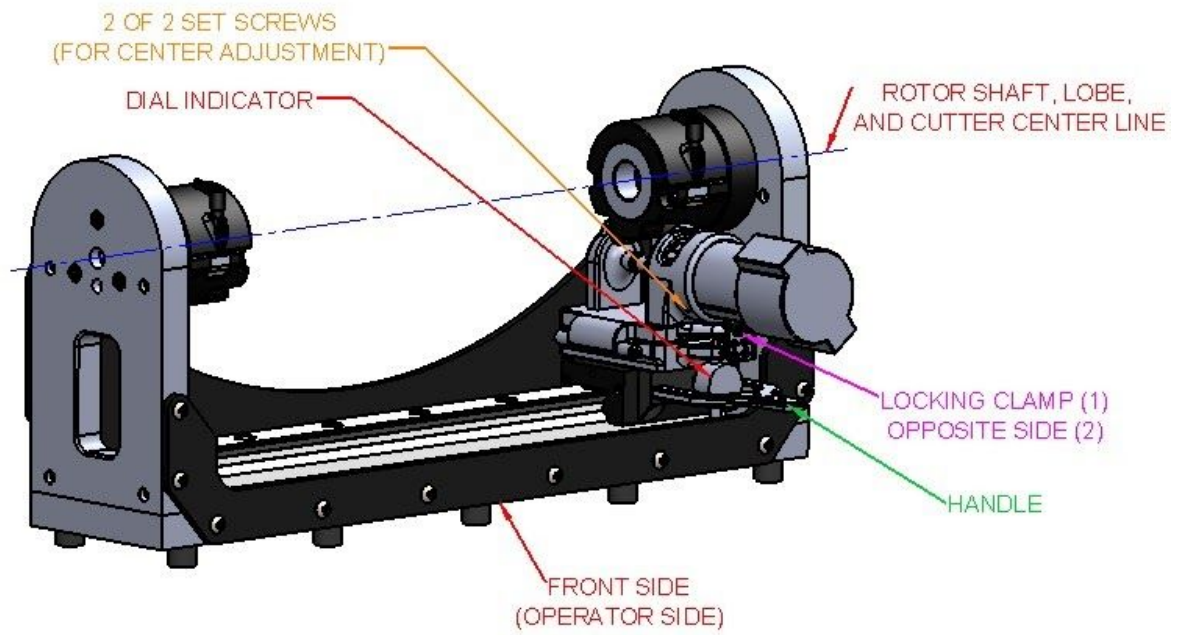


The Rotor Seal Trimmer is a tool used to maintain a consistent clearance between the rotor seal and the inside of the supercharger case. The seal is trimmed to the desired clearance using a carbide cutter powered by a router.

- the trimmer is portable
- the cutter height is easily adjustable
- the cutter follows the contour of the lobe
- each lobes seal is trimmed individually
- the seal can be trimmed flat or with a contour
- precision Thomson shafting and bearing carriage
- rotor bearing supports are hard anodized
- optional alcohol rotor adapter kit available

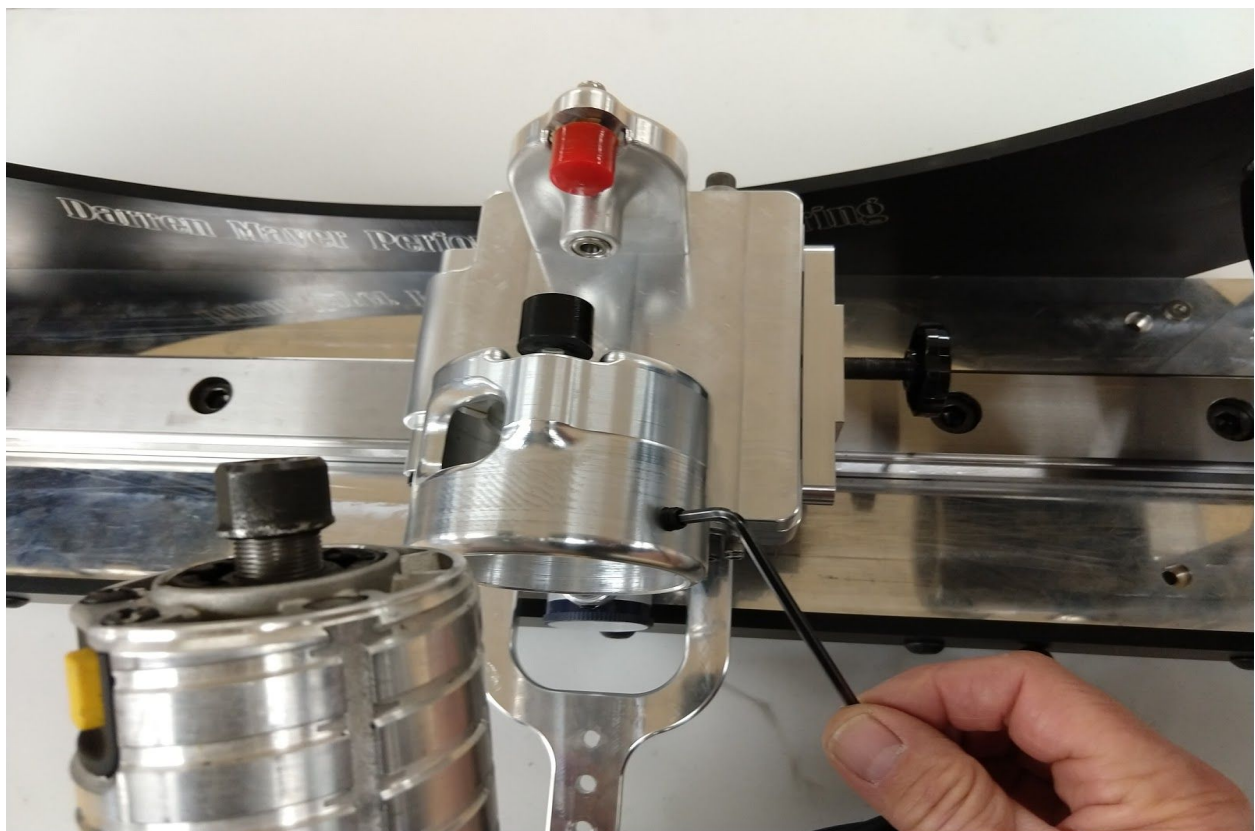


DO NOT use the router as a handle. Use the handle underneath the router to move the router/cutter back and forth (left to right).

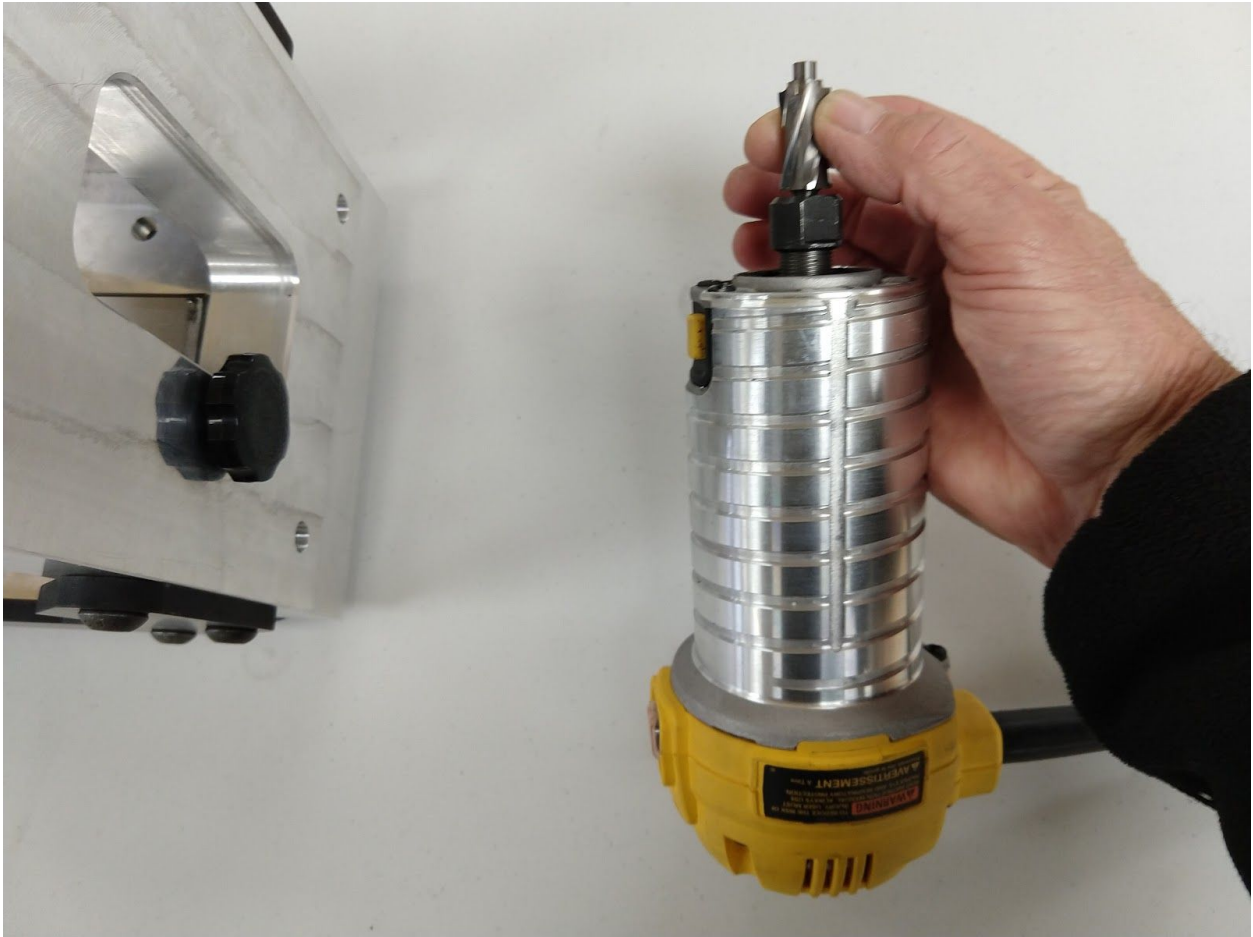


To properly install the cutter to cut on the centerline of the rotor lobe, the cutter must bottom out on the bearing. Center the cutter as follows:

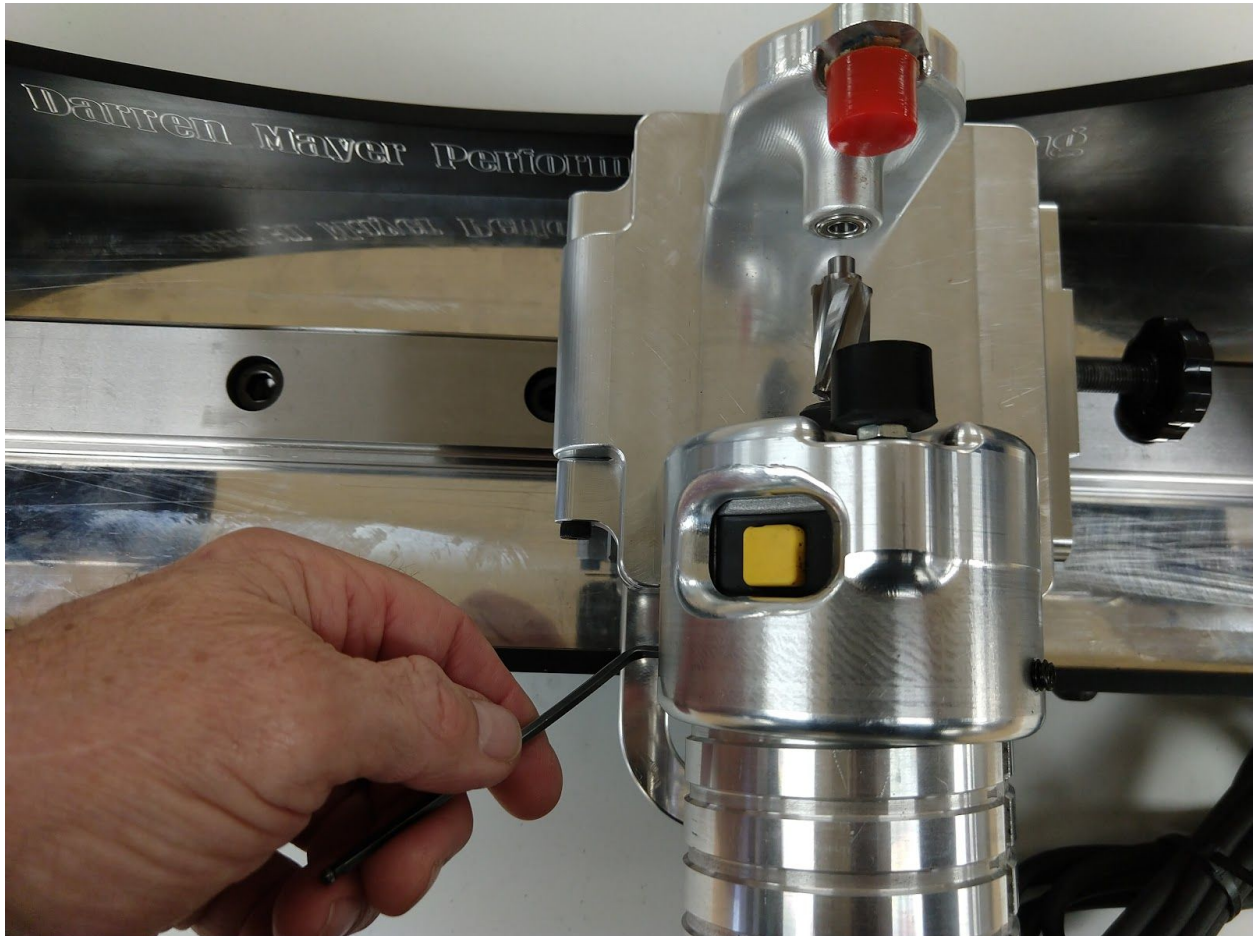
- ❑ use a 1/8" allen wrench to loosen two 1/4"-20 set screws and remove the router



□ insert the cutter into the router collet



- ❑ reinstall the router keeping it about 1/16" from bottoming out on the router housing
- ❑ use a 1/8" allen wrench to tighten the two 1/4"-20 set screws a quarter turn after making contact with the router housing



- insert the cutter into the bearing until it bottoms out



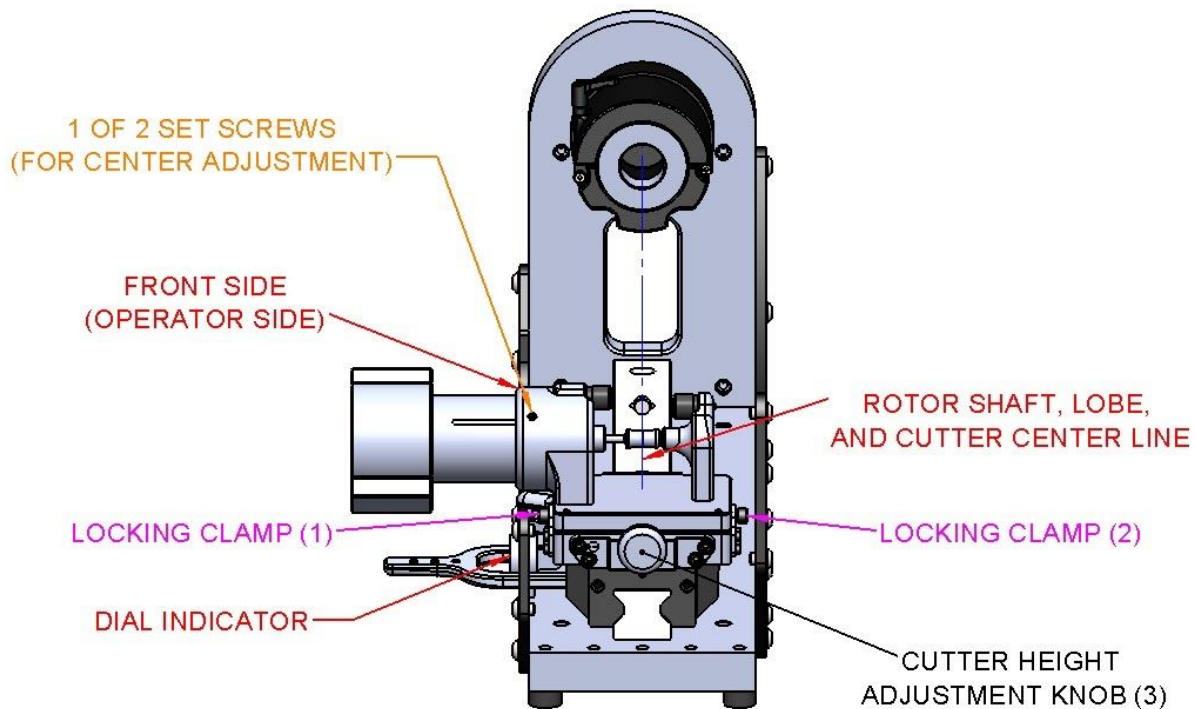
- ❑ use the supplied 17mm wrench to tighten the collet ½ turn after the nut makes contact (this will draw the cutter away from the bearing)



- ❑ use a 1/8" allen wrench to loosen the 1/4"-20 set screws and push the router inward until the cutter bottoms out on the bearing
- ❑ use a 1/8" allen wrench to tighten the 1/4"-20 set screws a quarter turn after making contact with the router housing



- ❑ the cutter is now centered with the rotor shaft and lobe



Adjust the cutter height as follows:

- move the saddle all the way to the right
- use a ¼" allen wrench to loosen clamps 1 and 2
- adjust the cutter height using knob 3 to the predetermined dial indicator reading
- use a ¼" allen wrench to tighten clamps 1 and 2 to a maximum of 90 in-oz
- If the dial indicator reading changes, unclamp and re-adjust the height so the predetermined dial indicator reading is correct after re-tightening the clamps
- repeat until correct
- DO NOT over tighten clamps

Note: It is wise to first cut the Teflon strip small to the supercharger case bore. This will allow you to get a measured clearance from the rotor tip plastic strip to the bore of the supercharger. Once you know this, you can go back to the Rotor Seal Trimmer and adjust accordingly. We recommend .0015" clearance between the rotor strip to bore at the bottom of the bore (6 o'clock position).

OPTIONAL: ALCOHOL ROTOR TOOLING AND ADJUSTMENTS

The following are the differences between the T/F and Alcohol rotors requiring additional tooling and adjustments.

- ❑ shaft diameter
- ❑ lobe cross-section profile

To compensate for the differences in shaft diameter between the T/F rotors and Alcohol rotors a set of bearings with adapter bushings pressed-in are required.

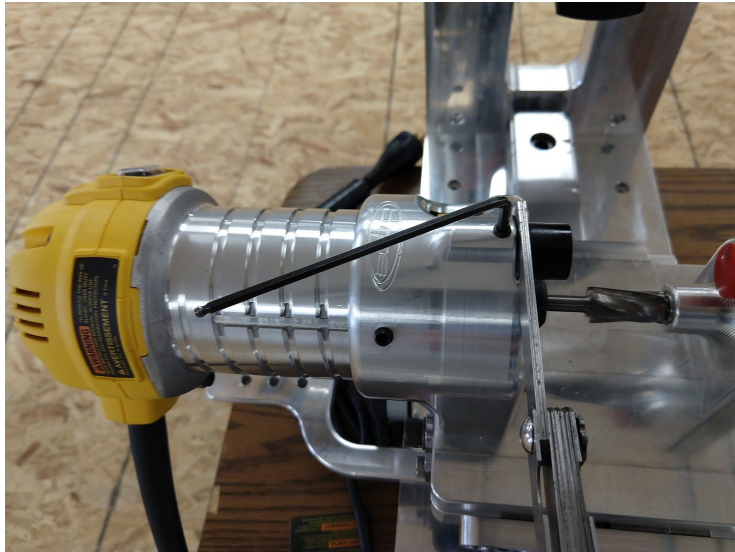
T/F



Alcohol

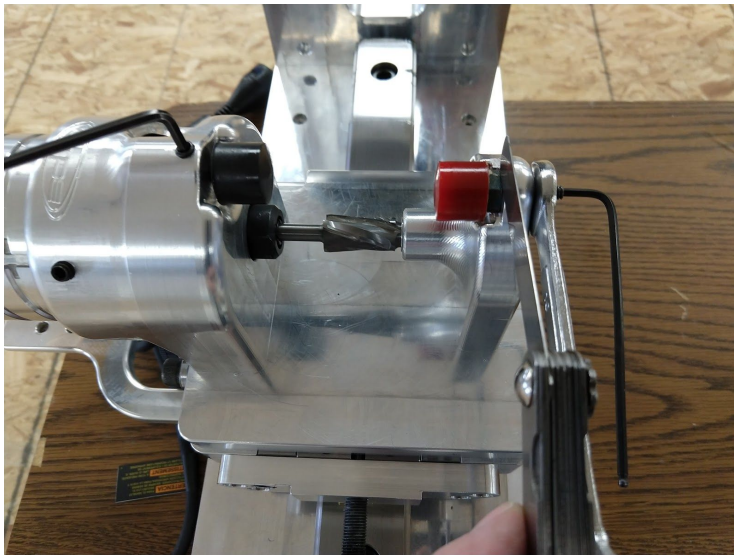


To compensate for the difference in the lobe cross-section profile between the T/F rotors and Alcohol rotors an adjustment is required to the lobe followers. The following are the settings.



Front (black) follower feeler gauge thickness: T/F: _____
Alcohol: _____

- using a $\frac{1}{8}$ " allen wrench loosen the nylon tipped set screw
- using a feeler gauge, adjust the black follower to the corresponding dimension
- tighten the nylon tipped set screw $\frac{1}{8}$ turn after it makes contact



Rear (red) follower feeler gauge thickness: T/F: _____
Alcohol: _____

- using a 3/8" wrench loosen the Nylock nut
- using a 3/32" allen wrench and feeler gauge adjust the red follower to the corresponding dimension
- tighten the Nylock nut

Spare Parts List

Description	Per Unit	Part #
T/F Bearing	2	3207A/C3
Alcohol Bearing (front) w/adapter bushing	1	500-049-99-1387
Alcohol Bearing (rear) w/adapter bushing	1	500-049-99-1388
Front (black) lobe follower	1	8926T21
Rear (red) lobe follower	1	9546K94
Carbide cutter	1	500-049-99-1340
Dial indicator	1	93279990
Nylon tip set screw	3	67280727