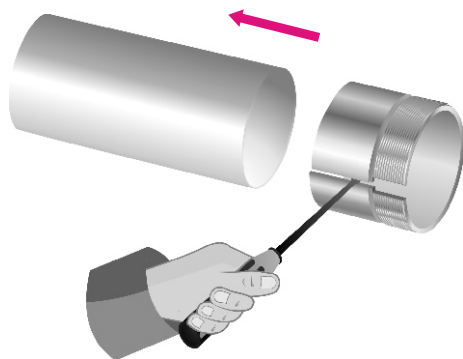


Adapter Sleeves Assembling with Self-aligning Ball Bearing with tapered bore.

- 1** Remove the sleeve protection oil using solvent.
Spread a thin oil layer over the sleeve inner and outer surface (It helps while disassembling).

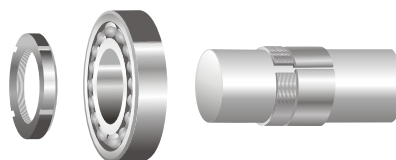
- 2** In order to easily place the sleeve on the shaft, it is allowed to open it, if necessary, inserting a screwdriver at the tear and then move it to its correct position in the shaft.



- 3** Remove the protection oil from the bore and from the bearing outer diameter and place it over the sleeve.

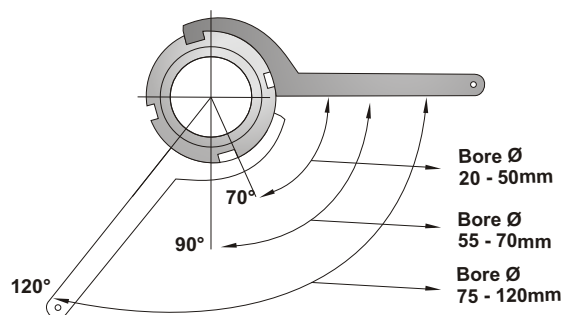
- 4** Lubricate the thread and the nut chamfered face which will have contact with the bearing using EP grease or any other molybdenum bi-sulfide based lubricant.

- 5** Tap the nut on the sleeve (without the washer) until realized the bearing is properly placed.

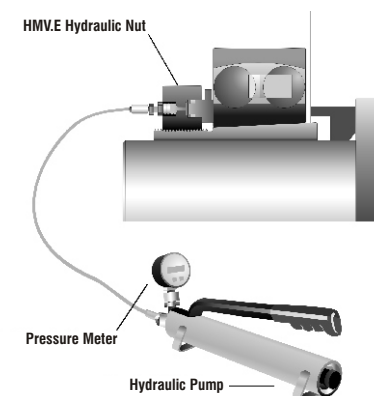


- 6** Use the 6.1 or 6.2 method for assembling.

- 6.1** Tighten the nut using a proper Hook Spanner (never a hammer and a chisel), according to the bearing bore proper angle, as shown in the picture. Assure that the sleeve do not spin over the shaft during tightening.



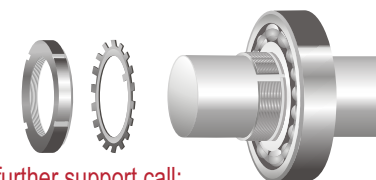
- 6.2** Tighten the nut with a Hydraulic Nut and a comparison clock (never a hammer and a chisel), according to the proper axial displacement, as shown in the picture. Assure that the sleeve do not spin over the shaft during tightening.



Axial Displacement	
d. bearing bor diameter	Axial Displacement
mm	mm
20 a 30	0,22
35 a 40	0,30
45 a 50	0,35
55 a 70	0,40
75 a 80	0,45
85 a 100	0,60
110 a 120	0,70

- 7** Untap the nut and only then place the lock washer and tighten the nut again.

- 8** Lock one of the washer catches at the nut tear aided by a punch.



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