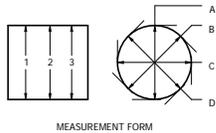


REVISION HISTORY				
REV	ECN	DESCRIPTION	DATE	APPROVED
A	K050006	RELEASE	3/4/2005	rwultrich
B	K070157	UPDATED	9/11/2007	dmjohson
C	K090104	ADD 4X K200-06893	4/8/2009	dmjohson



**BEARING MOUNTING & DISMOUNTING INSTRUCTIONS:**

**1. PRECAUTIONS:**

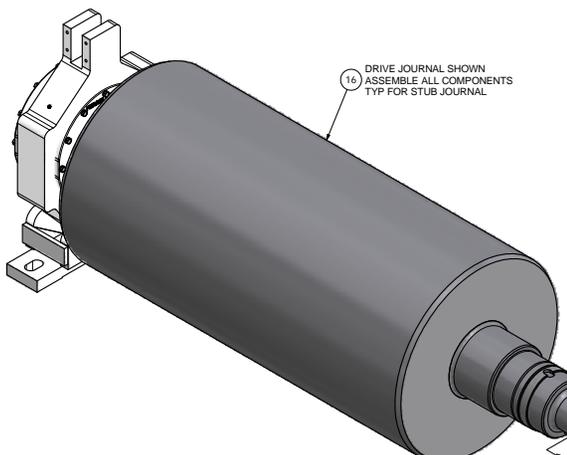
- MOUNT THE BEARINGS IN A CLEAN ENVIRONMENT. HOUSINGS, SHAFTS AND OTHER COMPONENTS OF THE BEARING ARRANGEMENT SHOULD BE CHECKED FOR CLEANLINESS.
- THE BEARINGS SHOULD BE LEFT IN THEIR ORIGINAL PACKAGES UNTIL IMMEDIATELY BEFORE MOUNTING, SO THAT THEY DO NOT BECOME DIRTY.
- THE DIMENSIONAL AND FORM ACCURACY ALL COMPONENTS WHICH WILL BE IN CONTACT WITH THE BEARING SHOULD BE CHECKED.
- CHECK THE DIAMETER OF THE ROLL JOURNAL BEARING MOUNT SURFACE USING A MICROMETER AT FOUR POSITIONS IN THREE PLANES. 9.093 +/-0.001 (228.676 +/-0.025).
- CHECK THE DIAMETER OF THE BEARING HOUSING BEARING MOUNT SURFACE USING AN INTERNAL GAUGE AT FOUR POSITIONS IN THREE PLANES. 15.748 +/-0.011-0 (400.000 +/-0.025/-0).
- USE LIFTING EQUIPMENT TO FACILITATE THE HANDLING OF THE BEARING. SPRING SUSPENSION CAN SIMPLIFY BEARING POSITIONS.
- DO NOT COOL JOURNAL TO MOUNT BEARINGS AS THIS WILL CAUSE CONDENSATION AND CREATE A RISK OF CORROSION.
- DO NOT ALLOW BEARINGS TO COOL BEFORE INTALLING.

**2. MOUNTING PROCEDURE:**

- WIPE THE PRESERVATIVE FROM THE BORE AND OUTSIDE DIAMETER OF THE BEARING.
- LIGHTLY OIL THE BORE AND OTHER RACE OF THE BEARING WITH A THIN MINERAL OIL.
- USE SKF INDUCTION HEATER AND HEAT BEARING TO 80 TO 90C (180 TO 200F) ABOVE THE TEMPERATURE OF THE JOURNAL BEFORE INSTALLING ON JOURNAL.
- GENTLY DRIVE THE BEARING INTO THE BEARING HOUSING UNTIL THE BEARING BOTTOMS ON JOURNAL SHOULDER. GENTLY STRIKE AROUND THE BEARING OUTER RACE EQUALLY WITH A RUBBER MALLOT.
- POSITION THE ROLL ON SADDLE BLOCKS AND SLIDE THE DUST SEALS OVER THE ROLL JOURNALS, ON TO THE ROLL COLLARS.
- GENTLY DRIVE THE INNER OIL SEAL INTO THE BEARING HOUSING BY TAPPING EQUALLY AROUND THE SEAL WITH A RUBBER MALLET UNTIL FLUSH WITH THE HOUSING.
- SCREW ON THE BEARING LOCK NUT WITH ITS CHAMFER FACING OPPOSITE THE BEARING, BUT DO NOT FASTEN THE LOCK PLATE.
- REMOVE THE SADDLE BLOCKS FROM THE ASSEMBLY END OF THE ROLL SO THAT THE BASE OF THE BEARING HOUSING IS SETTING ON THE FLOOR.
- CHECK THAT THE ROLL JOURNAL ROTATES WITHOUT ANY DISTURBANCES.
- GENTLY DRIVE THE OUTER OIL SEAL INTO THE BEARING COVER BY TAPPING EQUALLY AROUND THE SEAL WITH A RUBBER MALLET UNTIL FLUSH WITH THE COVER.
- SLIDE THE COVER OVER THE ROLL JOURNAL AND FASTEN TO THE BEARING HOUSING.
- FILL BEARING HOUSING WITH GREASE. SEE NOTES.
- REPEAT PROCEDURE FOR OPPOSITE BEARING HOUSING.

**3. DISMOUNTING PROCEDURE:**

- RELEASE THE BEARING COVER PLATES AND SLIDE THE BEARING HOUSING OFF OF THE BEARINGS.
- UN-FASTEN THE LOCK NUT PLATE AND REMOVE THE BEARING LOCK NUT. LOOSEN (TURN COUNTERCLOCKWISE) THE LOCK NUT WITH A SPANNER WRENCH OR SOFT STEEL BAR AND HAMMER.
- PROCEED TO PULL BEARING FROM SHAFT. A SPECIAL BEARING PULLING DEVICE IS NECESSARY FOR THIS JOB. SEE MANUAL FOR DIAGRAM IF NEEDED.



SLIDE DUST SEAL ON JOURNAL BEFORE SWEATING BEARING ON JOURNAL

SLIDE COVER ON JOURNAL BEFORE SWEATING BEARING ON JOURNAL. COVER K200-06875 ON STUB JOURNAL SIDE.

USE SKF INDUCTION HEATER AND HEAT BEARING TO 80 TO 90-C (180 TO 200-F) ABOVE THE TEMPERATURE OF THE JOURNAL BEFORE INSTALLING ON JOURNAL.

INSTALL SEAL IN COVER BEFORE SLIDING COVER ON JOURNAL

ALLOW BEARING TO COOL COMPLETELY BEFORE PRESSING BEARING HOUSING OVER BEARING. PRESS TWO RACES (F902-07121) INTO BEARING HOUSING BEFORE PINNING BASE TO BEARING HOUSING (SEE PRINT K200-06876).

PRESS TWO RACES (F902-07121) INTO BASE BEFORE PINNING BASE TO BEARING HOUSING (SEE PRINT K200-06876).

7 PLCS DRIVE COVER  
12 PLCS STUB COVER

7 PLCS DRIVE COVER  
12 PLCS STUB COVER

INSTALL SEAL IN COVER BEFORE SLIDING COVER ON JOURNAL

ITEM	PART NUMBER	QTY	DESCRIPTION
22	K914-06031	2	SEAL OIL 417571
21	K914-06011	1	SEAL NATIONAL 415090
20	K910-06221	2	FITTING, RELIEF-ALEMITE 317-400 1/8-27 NPT
19	K902-14851	2	Spherical Roller 23148 CC/W33
18	K902-07701	2	PLATE, LOCK, BEARING P-48
17	K902-06701	2	NUT, LOCK, BEARING N-048
16	K201-05326	1	ROLL, FIN DUAL DRIVE 32 X 68"
15	K200-07229	2	SEAL, DUST 11 025" JOURNAL, D DRV 32" FL
14	K200-06893	4	WASHER, PIVOT PIN, BEARING HOUSING, 32"
13	K200-06876	2	BASE ASSY, PIVOT BRG HSG 32 X 68
12	K200-06875	1	COVER, INNER FLOAT, BEARING HSG 32"
11	K200-06874	1	COVER, OUTER FLOAT, BEARING HSG 32"
10	K200-06873	1	COVER, INNER FIXED, BEARING HSG 32"
9	K200-06872	1	COVER, OUTER FIXED, BEARING HSG 32"
8	K200-06871	2	BEARING HOUSING, PIVOT 32 X 68"
7	K200-03659	2	PIN, PIVOT BEARING HOUSING, 28"
6	F80800002	4	FITTING, GREASE STRAIGHT, 1/8" PTF
5	70012050	4	CPLG, ELBOW 90 1/8-27M NPT X 1/4" TBG
4	70006510	4	RING, 2.31 X .08" TRIARC 5100-250
3	66445200	48	WASHER, LOCK HELICAL 1/2"
2	62585246	24	HNCS, 1/2-13 X 3.50"
1	62585230	24	HNCS, 1/2-13 X 1.75"

- NOTES:**
- DO NOT SCALE FROM DRAWING.
  - ONE PIECE REQUIRED PER K000-06802: ROLLER MILL ASSEMBLY, DUAL DRIVE FL, 32 X 68".
  - RIGHT HAND DRIVE ASSY SHOWN, ASSEMBLE ROLL AND ROLL COVERS SYMMETRICALLY OPPOSITE FOR LEFT HAND DRIVE, SEE SALES ORDER.
  - INSTALL GREASE ZERKS (F80800002) IN ROLL JOURNALS BEFORE FASTENING COVERS TO BEARING HOUSING.
  - FILL BEARING HOUSING WITH NLGI NO 2 GRADE LITHIUM BASED GREASE WITH AT LEAST 1000 SSU @ 100° F UNTIL GREASE RELIEFS OPEN, APPROXIMATELY 112 FL OZ (8, 14 OZ TUBES), AFTER ASSEMBLY COMPLETE.

<p>This drawing is the property of the A.T. Ferrell Company, Inc. and must be returned immediately upon request. No part of this drawing may be reproduced, stored in a retrieval system or transmitted in any form or by any means, without prior written consent of the A.T. Ferrell Company, Inc.</p>		<p><b>CAD</b></p> <p>NO MANUAL CHANGES</p> <p>NO CHANGES</p> <p>EXCEPT AS NOTED</p> <p>ISSUED BY: dmjohson</p> <p>DATE: 2/8/2005</p> <p>SCALE: 1:1</p> <p>DESCRIPTION: ROLL &amp; BEARING HOUSING ASSY, PIVOT, 32 X 68"</p> <p>DRAWN BY: dmjohson</p> <p>DATE: 2/8/2005</p> <p>SCALE: 1:1</p> <p>DESCRIPTION: ROLL &amp; BEARING HOUSING ASSY, PIVOT, 32 X 68"</p>		<p>INJECTION MOLDING UNIT</p> <p>DMU</p> <p>K100-03239</p> <p>2 of 2</p>	
--	--	--	--	--	--