

## Bearing Mounting Procedure

**WARNING:** These instructions should be read entirely and followed carefully before attempting to install or remove Rex roller bearings. Failure to do so can result in improper installation which could cause bearing performance problems as well as serious personal injury.

### ALL UNITS

1. Inspect shaft size (see shaft tolerance table, Page 2). Shaft must be to correct size. Clean shaft and mounting surface as needed.
2. Position bearings on the shaft, applying all driving pressure to the face of the inner ring. Do NOT strike or exert pressure on housing or seals.
3. Align the bearing housing to its mounting base by measuring from the face of the inner ring to the face of the threaded cover. Measure at the 12, 3, 6 & 9 o'clock positions. All four measurements must be within .060" of one another. Where shimming is required – use full shims across the housing base – not just at the bolt holes.
4. Position and loosely bolt housing to mounting base.
5. Lock bearing to the shaft. If one unit is an expansion type, lock the fixed bearing first.

### Set Screw Lock Units (2000 & 5000 Series)

Tighten the collar set screws on the bearing (Figure 3) to the proper tightening torque which can be found in the SET SCREW TORQUE TABLE on page 2. Alternate torquing the screws to prevent unequal loading. See comment 8 in Additional Installation Comments.

### Eccentric Cam Lock Units (3000 Series)

Slide collar over the shaft until it rests over the cam of the inner ring.

**Rotate the collar in the direction of normal shaft rotation until snug.**

Utilizing a hammer and punch, rotate the collar until tight. Tighten set screws securely. Utilize torque values from SET SCREW TORQUE TABLE on page 2. See comment 8 in Additional Installation Comments.

### Adapter Mount Units (9000 Series)

**Zero Shaft Fit**-Take a large flat blade screw driver to wedge between the bearing's face and lockwasher. Use the screwdriver to draw the bearing's sleeve through the inner ring until you achieve a snug fit and then finger tighten the locknut (See Figure 2 below). Tighten locknut ½ to ¾ rotations and bend one of the lock washer tangs into one of the slots on the outside diameter of locknut.

6. Fully Tighten down housing bolts.
  7. Rotate the shaft a few revolutions to locate remaining bearings position on the shaft.
  8. **Set Screw & Eccentric Cam Lock Units**- Torque down set screws in remaining bearings using procedure in Step 5.
- Adapter Mount Units** - Secure remaining bearing using procedure in step 5. Operate bearing under full load for several days to permit seating of bearing and sleeve on the shaft. Then shut down the system and retighten locknuts on all bearings.

### EXPANSION UNITS ONLY

1. Center cartridge in outer housing. If maximum expansion capability is required, place cartridge in extreme position of housing to permit full movement of the cartridge in direction of expansion.
2. The remainder of the installation is the same as Fixed units.

### ADDITIONAL INSTALLATION COMMENTS

1. Position housings for:
  - a. Accessibility of grease fittings.
  - b. If thrust is present – direct thrust force through internal housing shoulder, not through back side of threaded cover side.
2. Spot drill or mill flats on shaft for increased holding power of set screws or ease of removal.
3. When an eccentric load condition exists, position set screws directly opposite from eccentric weight.
4. Shaft shoulders are recommended to support vertical shafts and high thrust loads. The shoulder diameter should not exceed the outside diameter of the inner ring.
5. When pillow blocks are mounted on an inclined plane or the work force is parallel with the base, either lateral bolts or welded stop blocks should be used to prevent shifting.
6. Avoid direct hammer blows to the bearing and its components by using a soft drift or block.
7. New seals should be used whenever a bearing is rebuilt.
8. If an Allen wrench is used as a torque wrench, place a length of pipe over the long end and pull until the wrench begins to twist.
9. **For Auxiliary Cap Installation, See Page 4.**

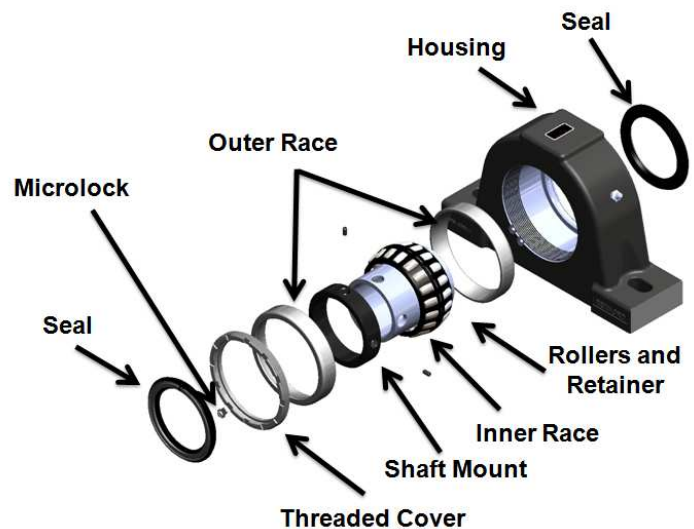


Figure 1) Exploded View of 2000 Series Bearing

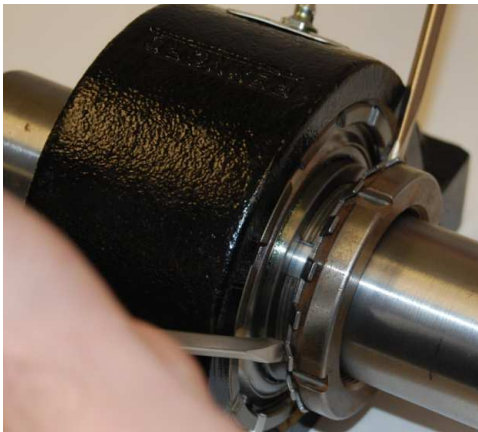


Figure 2) Zero Shaft Fit – Pry against housing to draw adapter sleeve through bearing. Sleeve should not be protruding out the backside of the inner ring.

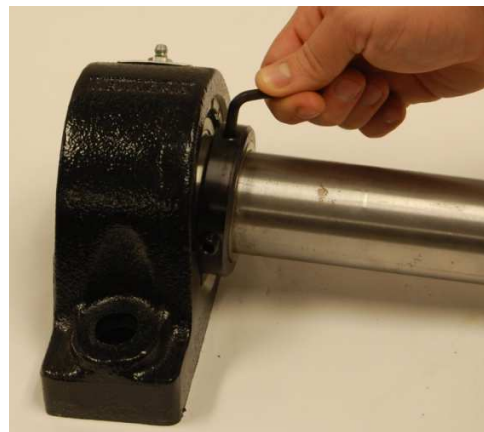


Figure 3) Alternate tightening down set screws to proper torque value. Be sure to tighten all set screws.

# Rex<sup>®</sup> Mounted Roller Bearings

## INSTALLATION INSTRUCTIONS 2000, 3000, 5000, & 9000 SERIES

| SET SCREW TORQUE TABLE  |                         |                        |                |                                  |
|-------------------------|-------------------------|------------------------|----------------|----------------------------------|
| Normal Duty 2000 Series | Normal Duty 3000 Series | Heavy Duty 5000 Series | Set Screw Size | Tightening Torque (Inch- Pounds) |
| 2012 – 2104             | 3107                    | -                      | 5/16           | 185                              |
| 2107 – 2200             | 3111 - 3115             | 5107 - 5115            | 3/8            | 325                              |
| 2203 – 2204             | 3203 - 3315             | 5200 - 5203            | 7/16           | 460                              |
| 2206 - 2308             | -                       | 5207 - 5307            | 1/2            | 680                              |
| 2311 - 2400             | -                       | 5311 - 5507            | 5/8            | 1350                             |
| -                       | -                       | 5515 - 5700            | 3/4            | 1600                             |

For more detailed instructions refer to latest REXNORD Catalog

| SHAFT TOLERANCE TABLE – INCHES |       |   |                               |                  |                    |
|--------------------------------|-------|---|-------------------------------|------------------|--------------------|
| Nominal Shaft sizes (inches)   |       | Commercial Shaft Tolerance* (Cold Finished Steel, Low Carbon) | RECOMMENDED SHAFT TOLERANCES* |                  | Press Fit Mounting |
|                                |       |   | Set Collar & Cam Mounting     | Adapter Mounting |                    |
| Over                           | Incl. |   | Severe Loading or High Speed  |                  |                    |
| 1                              | 2     | +0.000 -0.003   | +0.000 -0.001                 | +0.000 -0.003    | Consult Rexnord    |
| 2                              | 4     | +0.000 -0.004   | +0.000 -0.001                 | +0.000 -0.004    |                    |
| 4                              | 6     | +0.000 -0.005   | +0.000 -0.0015                | +0.000 -0.005    |                    |
| 6                              | 7     | +0.000 -0.006   | +0.000 -0.0015                | +0.000 -0.006    |                    |

\*Recommended shaft tolerances are generally satisfactory for loads up to 15% of C (see load ratings in catalog). High load applications will require a press fit to the shaft.

### DISASSEMBLY OF BEARING INSERT

1. Remove shaft locking device (collar or adapter assembly).
2. Remove seals. Z, K, and G are held in with snap ring. M is pressed in so it must be pried out with screwdriver.
3. Remove MICROLOCK screw and key. (Do not lose nylon washer).
4. Remove threaded cover by turning counter clockwise.
5. Place housing threaded cover side down on arbor press with spacer blocks under housing.
6. Place a soft metal bar or wood block on face of inner ring and press bottom outer ring and inner ring assembly from housing.
7. To remove the back outer ring, large bore bearings 4 7/16" thru 7" have drive pin holes. The back outer ring of smaller size units may be removed with a bearing puller or hammer and drift.

### REASSEMBLY OF BEARING INSERT

1. Place housing threaded cover side up on arbor press with spacer blocks under housing.
2. Remove shaft locking Device (collar or adapter assembly)
3. Press in back outer ring and seat against housing shoulder.
4. Insert inner ring – roller assembly and rotate to seat rollers against back outer ring.
5. Press in front outer ring. Do not bottom out outer race on rollers.
6. Install threaded cover, turning clockwise until inner ring resists rotation or misalignment.
7. Back off threaded cover the required degrees per the **CLEARANCE ADJUSTMENT TABLES (PAGE 3)** – align cover slot with the nearest counter bored hole in housing. Note 2 holes in housing are 15° apart and slots in threaded cover are 30° apart.
8. Install microlock key with nylon washer under the head of the screw. NOTE: Expansion style units that utilize the microlock key incorporate a nylon patch setscrew so the nylon washer is not included.
9. **Using arbor press, press on inner ring face on the side opposite the threaded cover to seat front outer ring against threaded cover face. Alternate method, turn housing over and provide support so inner race on threaded cover side sits above table. Remove seal opposite threaded cover. Place a soft piece of steel or block of wood that just fits over the face of the inner ring. Using a hammer, strike the block with several sharp blows. Inner ring assembly should rotate and misalign freely.**
10. Install seals. **Z-Seal** – Place centering spring in seal groove with fingers facing up. Place U-shaped element on fingers. Place centering ring on element with raised tab face up. Install snap ring so the tab on centering ring is between ends of snap ring. **K & G-Seal** – Place seal into the seal groove with the raised tab sticking up. Install snap ring so that the tab is between the snap ring ends. **M-Seal** – Place seal into seal groove with spring facing out. A hammer and flat punch will be required. See illustration to right. Go around seal face with punch until completely seated. Make sure seal is seated firmly. No snap ring is required with **M-Seal**.
11. Install shaft locking device (collar or adapter assembly).
12. Lubricate bearing with amount of grease shown in LUBRICATION TABLE on page 3. Rotate inner ring assembly during lubrication to distribute grease in bearing.

### LUBRICATION INFORMATION

Standard bearings come pre-lubricated from the factory with Exxon Ronex MP grease. Exxon Ronex MP is an NLGI Grade 2 EP (extreme pressure) grease with a lithium complex thickener. It can be used for high loads, and in some cases at temperatures as low as -40°F or as high as +225°F. For high speeds, other special service conditions, or for inquires on other acceptable greases, please consult your local Rexnord representative or the Rexnord Bearing Engineering Department. When rebuilding Rexnord bearings for use in average operating conditions, the bearing should be lubricated with the amount of grease by weight as shown in the LUBRICATION TABLE on page 3. Oil lubrication is not recommended.

### RELUBRICATION

Bearings should be re-lubricated at regular intervals. The frequency and amount of lubricant will be determined by the type of service. General guidelines for re-lubrication frequency and amount are based upon average application conditions. See LUBRICATION TABLE on page 3. Oil lubrication is not recommended.

At High temperatures, greases tend to degrade more rapidly and thus require fresh grease more frequently. In general, small amounts of grease added frequently provide better lubrication. When equipment will not be in operation for some time, grease should be added to provide corrosion protection. This is particularly important for equipment exposed to severe weather.

### AUTOMATIC LUBRICATION SYSTEMS

A variety of automatic re-lubrication systems are available for use with roller bearings. Key considerations are:

1. NLGI grade of grease used, consistent with system layout
2. An amount/frequency combination necessary to replenish the grease

### MIXING OF GREASES

Mixing of any 2 greases should be checked with the lubricant manufacturer. If the grease bases are different they should never be mixed.

### CLEARANCE ADJUSTMENT

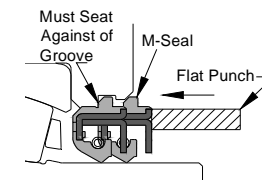
To increase the clearance for high speed use:

1. Remove microlock assembly.
2. With soft steel drift pin/punch and hammer, rotate the threaded cover counter-clockwise the additional amount listed in the CLEARANCE ADJUSTMENT TABLE on page 3.

NOTE: Each screw hole is separated by 15° and every threaded cover slot is separated by 30°.

3. Install microlock assembly with nylon washer (if included) under head of screw. CAUTION: If increase in degrees does not match up to listed change, always go to the higher setting that is possible.

4. Using arbor press, press on inner ring face on the side opposite the threaded cover to seat front outer ring against threaded cover face. Alternate method, turn housing over and provide support so inner race on threaded cover side sits above table. Remove seal opposite threaded cover. Place a soft piece of steel or block of wood that just fits over the face of the inner ring on inner ring face. Using a hammer, strike the block with several sharp blows. Inner ring assembly should rotate and misalign freely.



### LUBRICATION TABLE

| SHAFT SIZE - INCHES             |                           |                     | GREASE WT. REQUIRED (OZ)   |                      | RECOMMENDED NUMBER OF MONTHS BETWEEN RELUBRICATION* (BASED ON 24/7 OPERATION) |          |          |         |         |
|---------------------------------|---------------------------|---------------------|----------------------------|----------------------|---|----------|----------|---------|---------|
| Single Collar 2000, 3000 Series | Double Collar 5000 Series | Adapter 9000 Series | To Lubricate Rebuilt Units | To Relubricate Units | Relube Interval   |          |          |         |         |
|                                 |                           |                     |                            |                      | 6 Months  | 4 Months | 2 Months | 1 Month | 2 weeks |
| 3/4 - 1                         | .....                     | .....               | 0.4                        | 0.20                 | 1400  | 2200     | 3400     | 5000    | 6500    |
| 1 1/8 - 1 1/4                   | .....                     | .....               | 0.5                        | 0.25                 | 1150  | 1800     | 2800     | 4500    | 5750    |
| 1 7/16 - 1 1/2                  | 1 7/16                    | .....               | 0.6                        | 0.30                 | 1000  | 1550     | 2400     | 3800    | 5250    |
| 1 11/16 - 1 3/4                 | 1 1/2 - 1 11/16           | .....               | 0.8                        | 0.40                 | 870   | 1350     | 2100     | 3300    | 4450    |
| 1 15/16 - 2                     | 1 15/16                   | .....               | 0.9                        | 0.45                 | 700   | 1100     | 1700     | 2700    | 4050    |
| 2 3/16 - 2 1/4                  | 2 - 2 3/16                | 1 15/16 - 2         | 1.1                        | 0.55                 | 630   | 1000     | 1500     | 2400    | 3650    |
| 2 3/8 - 2 1/2                   | 2 7/16                    | 2 3/16              | 1.5                        | 0.65                 | 580   | 910      | 1400     | 2250    | 3300    |
| 2 11/16 - 3                     | 2 1/2 - 2 15/16           | 2 7/16 - 2 1/2      | 2.8                        | 1.20                 | 460   | 730      | 1100     | 1800    | 2800    |
| 3 3/16 - 3 1/2                  | 3 3/16 - 3 7/16           | 2 11/16 - 3         | 3.7                        | 2.00                 | 410   | 640      | 1000     | 1550    | 2400    |
| 3 11/16 - 4                     | 3 11/16 - 4               | 3 3/16 - 3 7/16     | 6.9                        | 2.90                 | 350   | 550      | 850      | 1150    | 1850    |
| .....                           | 4 3/16 - 4 1/2            | 3 11/16 - 4         | 8.4                        | 3.25                 | 280   | 440      | 740      | 1050    | 1600    |
| .....                           | 4 15/16 - 5               | 4 3/16 - 4 7/16     | 14.3                       | 5.00                 | 50  | 100      | 300      | 500     | 1000    |
| .....                           | 5 7/16                    | 4 15/16 - 5         | 22.1                       | 8.40                 | 50  | 100      | 300      | 500     | 1000    |
| .....                           | 5 15/16 - 6               | 5 3/16 - 5 7/16     | 25.3                       | 13.50                | 50  | 100      | 300      | 500     | 1000    |
| .....                           | 6 7/16 - 7                | 5 15/16 - 6 7/16    | 30.0                       | 15.00                | 50  | 100      | 300      | 500     | 1000    |

Shaft Speed in RPM

\*Relubrication amounts and frequencies shown in the table are based on standard clearance, moderate loads, etc., which yield housing temperatures of 150°F or less. Lubrication practices indicate that the relubrication frequency should be doubled for every 20°F above that level

### ADJUSTMENT TABLE (AXIAL AND RADIAL CLEARANCES) 2000, 3000, 5000 SERIES

| Size Code | SHAFT SIZE (INCHES) |                 |               | STANDARD FACTORY ADJUSTMENT (Average Speed and Temperature) |                           |                          | RECOMMENDED ADJUSTMENT HIGH SPEEDS |                            |                             |                            | CLEARANCE ADJUSTMENT INCHES PER 15 DEGREES |       |
|-----------|---------------------|-----------------|---------------|---|---------------------------|--------------------------|------------------------------------|----------------------------|-----------------------------|----------------------------|--|-------|
|           | 2000 SERIES         | 3000 SERIES     | 5000 SERIES   | STANDARD DEGREES ADJUST.                                    | STANDARD RADIAL CLEARANCE | STANDARD AXIAL CLEARANCE | SPEED OVER                         | HIGH SPEED DEGREES ADJUST. | HIGH SPEED RADIAL CLEARANCE | HIGH SPEED AXIAL CLEARANCE | RADIAL                                     | AXIAL |
| 2         | 3/4-1               |                 |               | 45  | .0022-.0028               | .0068-.0086              | 2000                               | 55 (+10°)                  | .0028-.0034                 | .0086-.0105                | .0008                                      | .0026 |
| 3         | 1 1/8-1 1/4         |                 |               | 50  | .0024-.0030               | .0078-.0098              | 2000                               | 60 (+10°)                  | .0030-.0036                 | .0098-.0117                | .0008                                      | .0026 |
| 4         | 1 7/16-1 1/2        | 1 7/16          | 1 7/16        | 55  | .0025-.0031               | .0088-.0109              | 2000                               | 65 (+10°)                  | .0031-.0037                 | .0110-.0130                | .0008                                      | .0027 |
| 5         | 1 11/16-1 3/4       | 1 11/16         | 1 1/2-1 11/16 | 60  | .0029-.0037               | .0101-.0128              | 1500                               | 70 (+10°)                  | .0037-.0045                 | .0128-.0156                | .0008                                      | .0029 |
| 6         | 1 15/16-2           | 1 15/16         | 1 15/16       | 85  | .0033-.0041               | .0127-.0157              | 1500                               | 105 (+20°)                 | .0041-.0049                 | .0157-.0188                | .0007                                      | .0025 |
| 7         | 2 3/16-2 1/4        | 2 3/16          | 2-2 3/16      | 60  | .0031-.0039               | .0119-.0149              | 1250                               | 75 (+15°)                  | .0039-.0047                 | .0150-.0180                | .0009                                      | .0034 |
| 8         | 2 3/8-2 1/2         | 2 7/16-2 1/2    | 2 7/16        | 65  | .0032-.0040               | .0131-.0163              | 1250                               | 80 (+15°)                  | .0040-.0048                 | .0163-.0196                | .0008                                      | .0034 |
| 9         | 2 11/16-3           | 2 11/16-2 15/16 | 2 1/2-2 15/16 | 80  | .0040-.0052               | .0163-.0211              | 1250                               | 100 (+20°)                 | .0052-.0064                 | .0211-.0259                | .0009                                      | .0035 |
| 10        | 3 3/16-3 1/2        | 3 7/16-3 1/2    | 3 3/16-3 7/16 | 100   | .0050-.0064               | .0201-.0257              | 1000                               | 125 (+25°)                 | .0064-.0076                 | .0257-.0304                | .0009                                      | .0034 |
| 11        | 3 11/16-4           | 3 15/16         | 3 11/16-4     | 120   | .0056-.0072               | .0239-.0306              | 1000                               | 150 (+30°)                 | .0072-.0088                 | .0306-.0373                | .0008                                      | .0034 |
| 12        |                     |                 | 4 3/16-4 1/2  | 80  | .0059-.0075               | .0241-.0306              | 750                                | 100 (+20°)                 | .0075-.0091                 | .0306-.0371                | .0013                                      | .0051 |
| 13        |                     |                 | 4 15/16-5     | 90  | .0069-.0087               | .0288-.0362              | 750                                | 115 (+25°)                 | .0087-.0105                 | .0362-.0436                | .0013                                      | .0054 |
| 14        |                     |                 | 5 7/16        | 90  | .0075-.0094               | .0305-.0381              | 500                                | 120 (+30°)                 | .0094-.0113                 | .0381-.0457                | .0014                                      | .0057 |
| 15        |                     |                 | 5 15/16-6     | 120   | .0087-.0110               | .0380-.0479              | 500                                | 150 (+30°)                 | .0110-.0133                 | .0480-.0578                | .0012                                      | .0054 |
| 16        |                     |                 | 6 7/16-7      | 150   | .0094-.0122               | .0439-.0568              | 500                                | 180 (+30°)                 | .0122-.0150                 | .0569-.0697                | .0011                                      | .0050 |

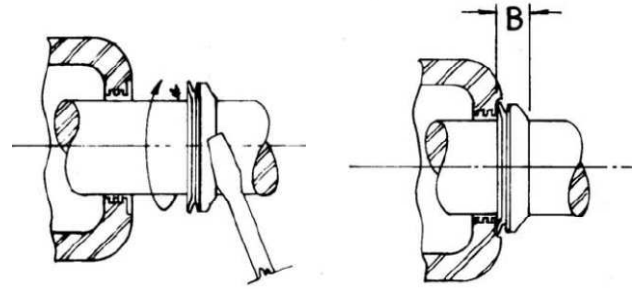
### ADJUSTMENT TABLE (AXIAL AND RADIAL CLEARANCES) 9000 SERIES TAPERED ADAPTER

| Size Code   | SHAFT SIZE (INCHES) | STANDARD FACTORY ADJUSTMENT (Average Speed and Temperature) |                                    |                                    |                                   |             | RECOMMENDED ADJUSTMENT HIGH SPEEDS                      |                                       |                                      |                                      |                                     |             | CLEARANCE ADJUSTMENT INCHES PER 15 DEGREES |       |
|-------------|---------------------|---|------------------------------------|------------------------------------|-----------------------------------|-------------|---|---------------------------------------|--------------------------------------|--------------------------------------|-------------------------------------|-------------|--|-------|
|             |                     | *MOUNTED CLEARANCE RESULT OF TIGHTENING TAPERED ADAPTER     |                                    |                                    |                                   |             | *MOUNTED CLEARANCE RESULT OF TIGHTENING TAPERED ADAPTER |                                       |                                      |                                      |                                     |             | RADIAL                                     | AXIAL |
| 9000 SERIES | STD. DEG. ADJ.      | UNMOUNTED STANDARD RADIAL CLEARANCE                         | *MOUNTED STANDARD RADIAL CLEARANCE | UNMOUNTED STANDARD AXIAL CLEARANCE | *MOUNTED STANDARD AXIAL CLEARANCE | SPEED OVER  | HIGH SPEED DEG. ADJ.                                    | UNMOUNTED HIGH SPEED RADIAL CLEARANCE | *MOUNTED HIGH SPEED RADIAL CLEARANCE | UNMOUNTED HIGH SPEED AXIAL CLEARANCE | *MOUNTED HIGH SPEED AXIAL CLEARANCE |             |  |       |
| 7           | 1 15/16-2           | 75  | .0039-.0047                        | .0031-.0039                        | .0150-.0180                       | .0119-.0149 | 1250  | 85 (+10°)                             | .0047-.0055                          | .0039-.0047                          | .0180-.0210                         | .0150-.0180 | .0009                                      | .0034 |
| 8           | 2 3/16              | 80  | .0040-.0048                        | .0032-.0040                        | .0163-.0196                       | .0131-.0163 | 1250  | 95 (+15°)                             | .0048-.0056                          | .0040-.0048                          | .0196-.0228                         | .0163-.0196 | .0008                                      | .0034 |
| 9           | 2 7/16-2 1/2        | 100   | .0052-.0064                        | .0040-.0052                        | .0211-.0259                       | .0163-.0211 | 1250  | 120 (+20°)                            | .0064-.0076                          | .0052-.0064                          | .0260-.0307                         | .0211-.0259 | .0009                                      | .0035 |
| 10          | 2 11/16-2 15/16     | 125   | .0064-.0076                        | .0050-.0064                        | .0257-.0304                       | .0201-.0257 | 1000  | 140 (+15°)                            | .0076-.0088                          | .0064-.0076                          | .0304-.0352                         | .0257-.0304 | .0009                                      | .0034 |
| 11          | 3 3/16-3 7/16       | 150   | .0072-.0088                        | .0056-.0072                        | .0306-.0373                       | .0239-.0306 | 1000  | 170 (+20°)                            | .0084-.0100                          | .0072-.0088                          | .0357-.0423                         | .0306-.0373 | .0008                                      | .0034 |
| 12          | 3 11/16-4           | 100   | .0075-.0091                        | .0059-.0075                        | .0306-.0371                       | .0241-.0306 | 750   | 115 (+15°)                            | .0091-.0107                          | .0075-.0091                          | .0371-.0435                         | .0306-.0371 | .0013                                      | .0051 |
| 13          | 4 3/16-4 7/16       | 115   | .0087-.0105                        | .0069-.0087                        | .0362-.0436                       | .0288-.0362 | 750   | 135 (+20°)                            | .0105-.0123                          | .0087-.0105                          | .0436-.0510                         | .0362-.0436 | .0013                                      | .0054 |
| 14          | 4 15/16-5           | 120   | .0094-.0113                        | .0075-.0094                        | .0381-.0457                       | .0305-.0381 | 500   | 145 (+25°)                            | .0113-.0132                          | .0094-.0113                          | .0457-.0533                         | .0381-.0457 | .0014                                      | .0057 |
| 15          | 5 3/16-5 7/16       | 150   | .0110-.0133                        | .0087-.0110                        | .0480-.0578                       | .0380-.0479 | 500   | 180 (+30°)                            | .0133-.0156                          | .0110-.0133                          | .0579-.0677                         | .0480-.0578 | .0012                                      | .0054 |
| 16          | 5 15/16-6 7/16      | 180   | .0122-.0150                        | .0094-.0122                        | .0569-.0697                       | .0439-.0568 | 500   | 220 (+40°)                            | .0150-.0178                          | .0122-.0150                          | .0697-.0825                         | .0569-.0697 | .0011                                      | .0050 |

### Auxiliary Cap Installation

#### SEAT V-RING AND LUBRICATE

- Position open caps such that the grease fitting will be in the most convenient location. Line up cap, gasket and housing holes and bolt the cap in place.  
**Note:** For closed caps ("B" suffix or prefix) no special alignment is required, simply line up the holes with those in gasket and housing and tighten bolts.
- The shaft should be lightly sanded and cleaned in the V-ring seal location to remove any loose dirt or rust
- Slide V-ring along the shaft by applying pressure and rotating shaft slowly, preferably by hand, in a direction away from point of tool. Tool should be lubricated to protect V-ring.
- Adjust to obtain "B" dimension for optimum lip pressure – See Table No. 1 to the right.
- After the seal has been properly positioned it is recommended that SCOTCH-GRIP 847 be used to more effectively retain this position. A 1/16" to 1/8" bead of glue should be applied at the mating surface of the shaft and the seal (opposite the contacting lip side). Once this has been wiped to insure glue contact with both surfaces do not attempt to move the seal
- Care should be taken to keep the glue away from the contact lip of the seal at all times. Cleanup can be accomplished with methyl ethyl ketone or acetone. Scotch-Grip 847 is a fast drying adhesive that will more securely retain the correct position of the V-ring seal. The machinery can be started within minutes of the glue application
- Once the caps are installed the caps can be filled with grease to provide a grease seal. The open cap should be purged with grease as often as practical keeping in mind that the cap cavity is unrelated to the bearing internal cavity. See the bearing installation instructions for bearing lubrication procedures



| Shaft Size        | "B"   | Tolerance |
|-------------------|-------|-----------|
| Thru 1 1/2"       | 11/32 | ± 1/32    |
| 1 9/16" – 2 5/8"  | 7/16  | ± 1/32    |
| 2 11/16" – 4 1/8" | 17/32 | ± 1/32    |
| 4 3/16" – 6"      | 5/8   | ± 1/16    |
| 6 1/8" – 7"       | 23/32 | ± 1/16    |

### Drilling and Tapping holes for Auxiliary Caps

Standard units do not come pre drilled to accept auxiliary caps. The following is the housing drilling and tapping specifications and locations for auxiliary cap mounting holes.

#### LOCATION OF HOLES

The holes are to be equally spaced and located at true position within a 0.010" diameter tolerance zone. The number of holes and angle between the holes are given in the table below.

The holes should be oriented so that one hole is 45° in the clockwise direction, based on the side of the housing being drilled, from the grease fitting hole except in the following cases:

- The minimum distance between centerline of the cap mounting holes and the centerline of the microlock holes shall be: 9/16" for size codes 4 through 8; 11/16" for size codes 9 through 10; and 7/8" for size codes 11 through 16. The minimum centerline distance between G-lock holes and cap mounting holes shall be 1/2". In cases where this occurs, the cap holes can be rotated in either direction to achieve minimum distance.
- Housings where the drawing specifies mounting hole location.

| Size Code | Tap Drill | Thread UNC-2B | FIXED HOUSINGS                |                            |                         | EXPANSION HOUSINGS            |                            |                         | No. of Holes | Angle Between Holes |
|-----------|-----------|---------------|-------------------------------|----------------------------|-------------------------|-------------------------------|----------------------------|-------------------------|--------------|---------------------|
|           |           |               | Drill Depth<br>+.125<br>-.000 | Total Thread<br>Depth Min. | Hole Location<br>Radius | Drill Depth<br>+.125<br>-.000 | Total Thread<br>Depth Min. | Hole Location<br>Radius |              |                     |
| 4         | #22       | 10-24         | .88                           | .56                        | 1.594                   | .81                           | .50                        | 1.969                   | 3            | 120                 |
| 5         | #22       | 10-24         | .88                           | .56                        | 1.906                   | .81                           | .50                        | 2.188                   | 3            | 120                 |
| 6         | #22       | 10-24         | .94                           | .62                        | 1.969                   | .81                           | .50                        | 2.313                   | 3            | 120                 |
| 7         | #22       | 10-24         | .75                           | .44                        | 2.188                   | .81                           | .50                        | 2.500                   | 3            | 120                 |
| 8         | #22       | 10-24         | .88                           | .56                        | 2.375                   | .81                           | .50                        | 2.750                   | 3            | 120                 |
| 9         | #7        | 1/4 - 20      | 1.00                          | .75                        | 2.813                   | 1.00                          | .62                        | 3.250                   | 3            | 120                 |
| 10        | #7        | 1/4 - 20      | 1.00                          | .62                        | 3.250                   | 1.00                          | .62                        | 3.688                   | 3            | 120                 |
| 11        | #7        | 1/4 - 20      | 1.00                          | .62                        | 3.813                   | 1.00                          | .75                        | 4.406                   | 3            | 120                 |
| 12        | F         | 5/16 - 20     | 1.00                          | .62                        | 4.234                   | 1.00                          | .62                        | 4.750                   | 4            | 90                  |
| 13        | F         | 5/16 - 20     | 1.00                          | .62                        | 4.938                   | 1.00                          | .62                        | 5.750                   | 6            | 60                  |
| 14        | F         | 5/16 - 20     | 1.12                          | .75                        | 5.750                   | 1.00                          | .62                        | 6.188                   | 6            | 60                  |
| 15        | F         | 5/16 - 20     | 1.00                          | .62                        | 6.188                   | 1.00                          | .62                        | 6.562                   | 6            | 60                  |
| 16        | 5/16      | 3/8-16        | 1.12                          | .75                        | 6.813                   | 1.12                          | .75                        | 7.281                   | 6            | 60                  |

## LIMITED WARRANTY – LIABILITY

A. IT IS EXPRESSLY AGREED THAT THE FOLLOWING WARRANTY IS GIVEN IN LIEU OF ALL OTHER WARRANTIES, WHETHER EXPRESSLY IMPLIED OF STATUTORY. INCLUDING THOSE OF MERCHANTABILITY AND FITNESS FOR A PARTICULAR PURPOSE, AND OF ANY OTHER OBLIGATION OR LIABILITY ON OR PART OF ANY KIND OR NATURE WHATSOEVER.

No representative of ours has any authority to waive, alter, vary, or add to the terms hereof without prior approval in writing, to our customer, signed by an officer of our company. It is expressly agreed that the entire warranty given to the customer is embodied in this writing. This writing constitutes the final expression of the parties agreement with respect to warranties, and that it is a complete and exclusive statement of the terms of the warranty.

We warrant to our customers that all Products manufactured by us will be free from defects in material and workmanship at the time of shipment to our customer for a period of one (1) year from the date of shipment. All warranty claims must be submitted to us within ten days of discovery of defects within the warranty period, or shall be deemed waived. As to Products or parts thereof that are proven to have been defective at the time of shipment, and that were not damaged in shipment, the sole and exclusive remedy shall be repair or replacement of the defective parts or repayment of the proportionate purchase price for such Products or part, at our option. Replacement parts shall be shipped free of charge f.o.b. from our factory.

This warranty shall not apply to any Product which has been subject to misuse; misapplication, neglect (including but not limited to improper maintenance and storage); accident, improper installation, modification (including but not limited to use of unauthorized parts or attachments), adjustment, repair or lubrication. Misuse also includes, without implied limitation, deterioration in the Product or part caused by chemical reaction, wear caused by the presence of abrasive materials, and improper lubrication. Identifiable items manufactured by others but installed in or affixed to our Products are not warranted by use but, bear only those warranties, express or implied, given by the manufacturer of that item, if any. Responsibility for system design to insure proper use and application of Link-Belt Products within their published specifications and ratings rests solely with customer. This includes without implied limitation analysis of loads created by torsional vibrations within the entire system regardless of how induced.

B. It is expressly agreed that our liability for any damage arising out of or related to this transaction, or the use of our Products, whether in contract or in tort, is limited to the repair or replacement of the Products, or the parts thereof by use, or to a refund of the proportionate purchase price. We will not be liable for any other injury, loss, damage, or expense, whether direct or consequential, including but not limited to use, income, profit, production, or increased cost of operation, or spoilage of or damage to material, arising in connection with the sale, installation, use of, inability to use, or the replacement of, or late delivery of, our Products.



Rexnord Industries Corp.  
Bearing Group

For Tech Support, Phone: 317-273-5781  
For Tech Support, Email:  
Bearing.tech.support@rexnord.com

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