

SERVICE BULLETIN.

DATE: 17 March 2010

TITLE: Sealmaster Skwezloc Bearing Fitment Instructions

Spherical OD

Replacement Sealmaster bearing inserts are intended for use in Sealmaster housings. Housings should be thoroughly inspected for damage such as cracks, excessive wear or galling of spherical seat and obstruction of grease port (clean free of debris). Wet housing bearing seat with oil or grease. Secure housing in a vise.

For Spherical OD.

- a) Place bearing insert into housing load slot, positioning the insert outer race dimple and lube hole inline with the casting lube port.
- b) Using a bar slipped into the insert bore as a lever, swing insert into place within the casting. Insert should have a snug fit in housing bore. **Do not hammer** (Note: If insert can be made to swivel by hand in the housing bore, fit is too loose - **Replace Entire Unit**. If heavy force is required, fit is too tight - **Replace Entire Unit**).
- c) Ensure alignment of housing grease port hole, bearing dimple and lube hole.
- d) Place locking pin into lube port and thread lubrication fitting into threaded lube port hole. Grease fitting adjustment is critical (overtightening or undertightening can result in poor bearing performance), snug fit with wrench, then loosen 1/4 turn.

Bearing in Bolt-on Housing

- 1) **Check area** - Clean and organise bearing installation area. Make sure mounting surfaces are clean and flat.
- 2) **Check shaft** - Shaft should be within tolerance range shown in Table # 1, clean and free of nicks and burrs. Apply Loctite 635 to the roller shafts. Mount bearing on unused section of shafting or repair / replace shafting as required.
- 3) **Install Unit** - Slide unit onto shaft. If its difficult to mount the bearing on the shaft, use a piece of emery cloth to reduce any high spots on the shaft. **Do no hammer on any components of the bearing!**
- 4) **Fasten Unit in Place** - Apply Loctite 243 to the housing mounting bolts, check and align bearing and tighten mounting bolts to recommended fastener torques. **Exercise extreme caution and safely rotate the shaft slowly to centre bearing.**
- 5) **Skwezloc inserts** - Make sure the skwezloc collar is fitted square and snug against the shoulder on the inner ring. Torque tighten the skwezloc collar cap screw to recommended setting shown in Table # 2.
- 6) **Monitor installed bearing** - After bearing has been run for several minutes, and again after several hours, check bearing for excessive noise or vibration. Check housing temp: typical applications operate at 100°F - 150°F (38 °C - 66°C). Tighten all locking devices after 500 hours or 3 months, which ever comes first.

Table # 1

SHAFTING

Shaft Diameter	Shaft Tolerance
1/2 - 1 15/16	+0 to .0005"
2 - 3 3-16	+0 to .0010"
3 1/4 - 4 15/16	+0 to .0015"

Table # 2

SKWEZLOC TIGHTENING

Screw Size	Torx Size	Torque	
		(in lbs)	(N-m)
#8 - 32	T - 25	65 - 70	7 - 8
#10 - 24	T - 27	90 - 100	10 - 11

Table # 3

CONTAMINATION LEVEL - MEDIUM

Bearing Temp	0 - 500 RPM	500 RPM - 75% Max Cat Speed	75% Max Cat Max Cat Speed
- 50°F to 120°F	1 Week - 1 Month	1 Week - 1 Month	1 Week - 1 Month
120°F to 250°F	Daily - 2 Weeks	Daily - 2 Weeks	Daily - 2 Weeks

CONTAMINATION LEVEL - HIGH

Bearing Temp	0 - 500 RPM	500 RPM - 75% Max Cat Speed	75% Max Cat Max Cat Speed
- 50°F to 120°F	Daily - 2 Weeks	Daily - 2 Weeks	Daily - 2 Weeks