

QTY	PC NO	DESCRIPTION	PART NO	WTL SPEC	ENG PT OR PC NO
1	01	FEED SCREW AND BEARING ASSEMBLY, L.H.			
1	02	FEED SCREW AND BEARING ASSEMBLY, R.H.			
1	03	FEED SCREW, L.H. FLIGHT, CW ROTATION			D48710002
1	04	FEED SCREW, R.H. FLIGHT, CW ROTATION			D48710001
1	05	STUFFING BOX, MACHINING			D487164
1	06	SEAL HELDER			C485762
1	07	SEAL HELDER, TOP			C485763
1	08	BEARING RETAINER			C485765
1	09	BEARING CAP, BOTTOM			C485761
1	10				
1	11	Q LEVEE			B485765
1	12	GASKET			B11098005
1	13				
1	14	SPHERICAL ROLLER BEARING, SKF 23024			3110000140
1	15	SPHERICAL ROLLER BEARING, SKF 22310C			3110000119
1	16	GASKET			A487189
2	17	SEAL, PLAIN, 1/2 X 5 X 6, J-H CLIPPER			S3350017005
3	18	SEAL, PLAIN, 1/2 X 4-1/2 X 5-1/2, J-H CLIPPER			S3350017004
1	19	SEAL, PLAIN, 1/2 X 3 X 4, J-H CLIPPER			S3350017070
1	20	SEAL, PLAIN, 1/2 X 3 X 4, J-H CLIPPER			MA02943
6	21	CAPSCREW, 500 HD, 1/2-13 UNC X 1-1/2 LG			MA02839
6	22	CAPSCREW, 500 HD, 1/2-13 UNC X 4-1/2 LG			
23	23				
1	24	LOCKWASHER, BEARING HEAVY SECTION WID			3110010118
1	25	WASHER, 1/4 SECT X 12-1/2 I.D.			MA43078
1	26	STUFFING BOX MOUNTING FLANGE			C487175
12	27	CAPSCREW, 500 HD, 3/8-16 UNC X 1-1/2 LG			MA01740
12	28	WASHER, FLAT, 3/8", CASE HARDENED BIL			MA07063
30	29				
31	30				
32	31				

ASSEMBLY PROCEDURES:

- ON FEED SCREW (PC 03 OR 04) (SHAFT END) HEAT SLEEVE (PC 11) TO 250° F AND SHRINK ON SHAFT UNTIL IT BOTTOMS ON SHAFT SHOULDER. LET COOL TO ROOM TEMPERATURE.
- CAREFULLY GUIDE SEAL HELDER (PC 12) AND STUFFING BOX (PC 05) OVER THE SLEEVE.
- CAREFULLY GUIDE SEAL HELDER (PC 12) AND STUFFING BOX (PC 05) OVER THE SLEEVE.
- AND BOLT TOGETHER USING (12) 3/8 500 HD CAPSCREWS AND NUTS (PCS 28 & 29).
- INSTALL GASKET PC. 17 LOOSE OVER SHAFT SLEEVE.

ASSEMBLY PROCEDURES:

- ASSEMBLE (1) SEAL (PC 18) LIP DOWN (1) SEAL (PC 18) LIP UP IN SEAL HELDER (PC 06).
- CAREFULLY GUIDE SEAL HELDER (PC 06) ON SHAFT, GUIDING LIPS OVER THE SLEEVE.
- HEAT BEARING (PC 15) TO 250° F AND BRINK ON SHAFT UNTIL IT BOTTOMS OUT ON THE SHOULDER.
- ON BEARING CAP, BOTTOM (PC 09), ASSEMBLE SEAL (PC 19) LIP DOWN WHEN ASSEMBLING. LIP UP WHEN CAP IS ASSEMBLED OVER THE BEARING. COAT SEAL WITH GREASE AND CAREFULLY ASSEMBLE ON (PC 22).
- ON BEARING CAP, TOP (PC 07), ASSEMBLE (1) SEAL (PC 18) LIP DOWN. (1) SEAL LIP UP, COAT SEAL WITH GREASE AND CAREFULLY GUIDE BEARING CAP ON TO SHAFT.
- HEAT BEARING (PC 16) TO 250° F AND SHRINK ON SHAFT UNTIL IT BOTTOMS OUT ON THE SHOULDER.
- SECURELY FASTEN BEARING IN PLACE WITH LOCKWASHER (PC 24) AND WASHER (PC 25).
- ON BEARING RETAINER (PC 08) ASSEMBLE (1) SEAL (PC 20) LIP DOWN WHEN ASSEMBLING. LIP UP WHEN RETAINER IS INSTALLED OVER SHAFT.
- COAT SEALS WITH GREASE AND CAREFULLY GUIDE BEARING RETAINER (PC 08) ON TO SHAFT.
- CAREFULLY GUIDE BEARING CAP OVER BEARING UNTIL IT BOTTOMS ON BEARING RETAINER (PC 08) AND FASTEN WITH (6) 1/2" BOLTS (PC 31).
- AFTER ASSEMBLY HAS COOLED TO ROOM TEMPERATURE GREASE GUN BOTH BEARINGS WITH 2-3 OUNCES OF MOBILITH AN2 350° F GREASE.
- BEARINGS SHOULD BE GREASED EVERY 3 MONTHS WITH MOBILITH AN2 1-2 OUNCES EACH.