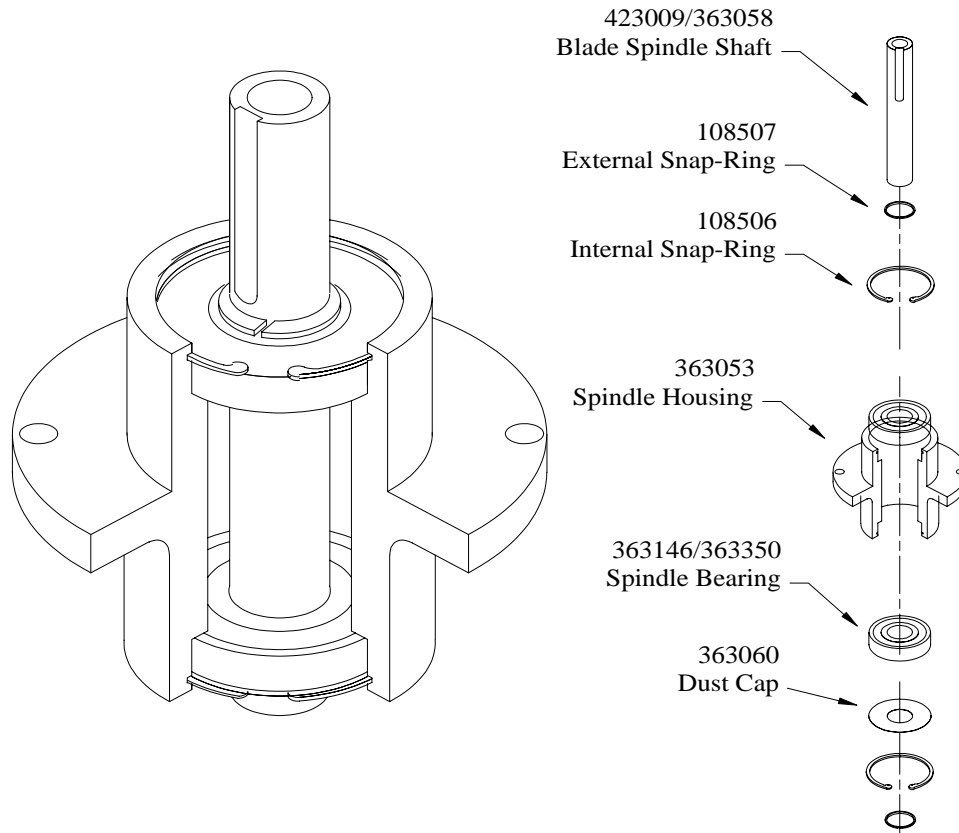




Bearing Installation Instructions

for
Part # 's 363146 & 363350



Caution: Grease bearing two pumps every 250-300 hours. Over-greasing will force seals out of the spindle housing.

When installing new bearings into an existing cutter housing, begin by removing all internal & external snap-rings. Before pushing shafts from the bearings, buff any rough edges on the shaft so it will slide through the bearing. When pushing the bearing and shaft from the housing, take care so that you do not damage the snap-ring grooves in the housing. After the bearings are removed, clean the cutter housing of grease and debris. Make sure that all debris is removed from the snap-ring groove. After cleaning the housing, the new bearing can be installed. Prep bearing by putting a line of RC 609 loctite around the center of the outer race of the bearing. Push the bearings back into the housing and install the internal 2" snap-rings making sure that they seat into the snap-ring groove. Replace the 1" snap ring on the keyed side of the shaft and press it back into the housing. Make certain that when pressing the shaft into the housing, the grease zerk is up. Press the shaft into the housing until the 1" snap-ring touches the inner race of the top bearing.

Before replacing the dust cap, place three spots of some type of silicone on the face of the bearing seal. This will keep the dust cover from moving and help preserve the condition of the seal. You may now replace the 1" external snap-ring. At this point, spin the bearing to check for any type of **pre-load**. If there is any type of **pre-load**, rap the bottom of the bearing with a brass or dead blow hammer to relieve the pre-load. When spinning the housing in your hands, the roll of the bearings should feel smooth.