



METHOD WITH HOOK SPANNER

01 Inspect the size of the axis. h10 maximum tolerance and IT5/2 roundness in 4 positions and 3 plans.

02 Unpack and remove the sleeve protective oil. Spread a thin layer of oil on the inner and outer surface.

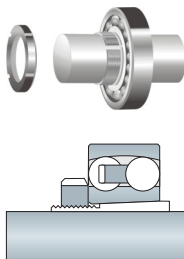
03 Place the sleeve on the axis. If necessary, open it by inserting a screwdriver into the slot.



04 Remove the package bearing. Remove the protective oil from the bore and outer diameter and place it on the sleeve.

05 Lubricate the thread and nut notched face that will be in contact the bearing.

06 Thread the nut onto the sleeve, without the washer, with your hands or a HN hook spanner, tightening until the bearing is fully seated and the nut stops. This is the starting point before the bearing clearance reduction.



07 Tighten the nut on the sleeve with a HN hook spanner, according to the bore of bearing and tightening angle shown in the table aside.

08 Remove the nut used for assembly.

09 Place the MB lock washer and thread the locknut firmly using the HN hook spanner.

10 10- Align the nearest nut slot with the washer external tooth and bend it with the help of a punch or puller pin.

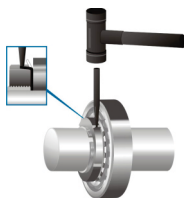


Table for Tightening Angle and Axial Displacement

Bearing bore diameter d (mm)	Tightening Angle of the Nut KM α (°) *	Axial Displacement s (mm)
20	80	0.22
25 and 30	55	0.22
35 and 40	70	0.30
45 and 50	80	0.35
55 - 65	95 Thread pitch 1.5 BGL	0.40
70	75	0.40
75 and 80	85	0.45
85 - 100	110	0.60
110 and 120	125	0.70

* The tightening angles may vary with the bearing series, with the thread pitch of the adapter sleeve and also according to the bearing manufacturer.

Source: Traditional manufacturers of bearings.

NOTE

The axial displacement values in the table aside are usually used in the assembly of adapter Sleeves with Self-aligning Ball Bearings with Hydraulic Nut and Dial indicator.

11 Finally, make sure that the bearing can be easily rotated with your hands.



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