



**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.

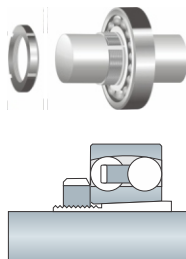
**03** Place the sleeve on the axis. If necessary, open it by inserting a screwdriver into the slot.



**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.

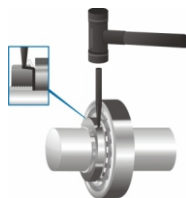


**07** Tighten the nut on the sleeve with a HN hook spanner, according to the bore of bearing and tightening angle shown in the table aside.

**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 <b>d ( mm )</b>	Tightening Angle of the Nut KM <b>α ( ° ) *</b>	Axial Displacement <b>s ( mm )</b>
20	<b>80</b>	0,22
25 and 30	<b>55</b>	0,22
35 and 40	<b>70</b>	0,30
45 and 50	<b>80</b>	0,35
55 - 65	<b>95</b> Thread pitch 1,5 BGL	0,40
70	<b>75</b>	0,40
75 and 80	<b>85</b>	0,45
85 - 100	<b>110</b>	0,60
110 and 120	<b>125</b>	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.



+55 19 3451.8210

info@bgl.com.br

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