



PARTS and SERVICE

ROTOR BEARING REPLACEMENT



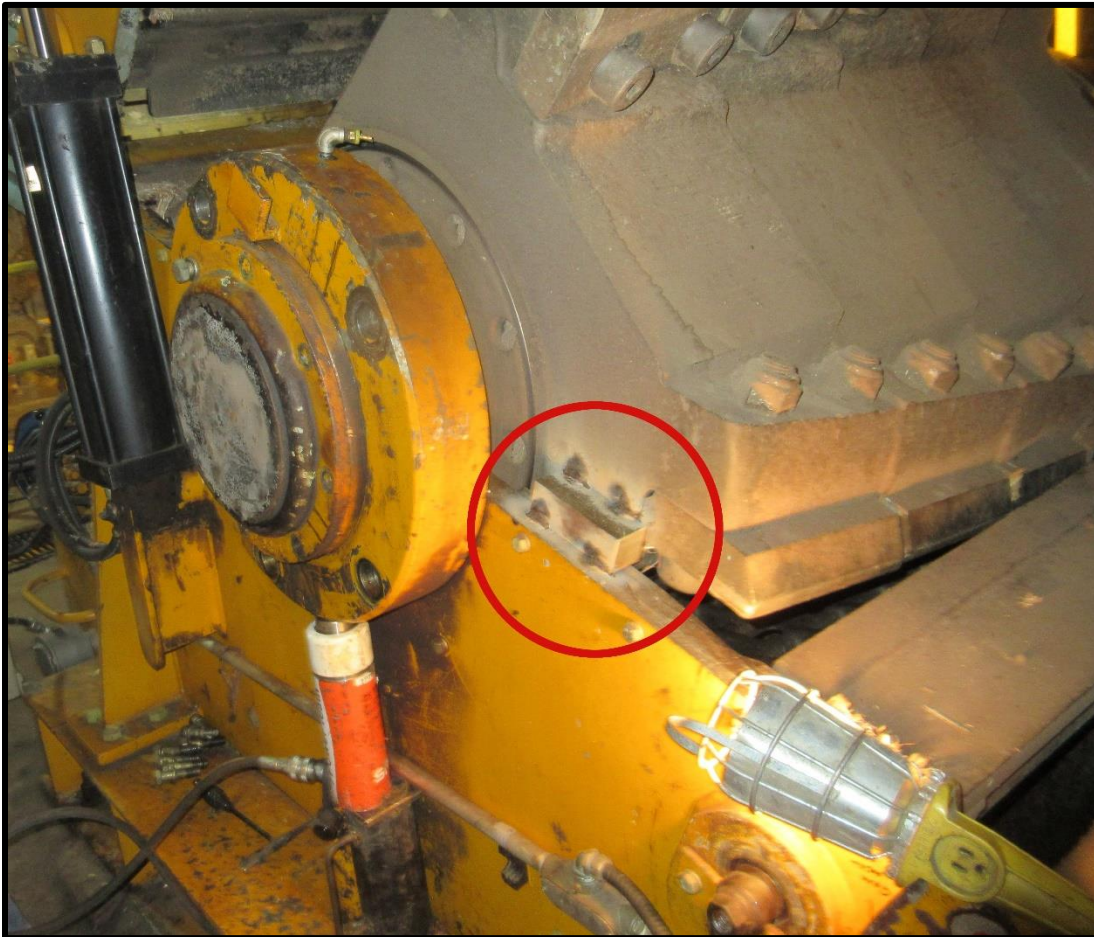


ROTOR BEARING REPLACEMENT

Brunette Machinery has preassembled bearing kits with all components required to complete a full replacement. They should be on site prior to beginning the service. If required, they can be transported to your location ASAP should an incident occur.

REMOVING ROTOR BEARINGS

- Remove bearing housing bolts.
- Raise the rotor up at each side by 1/16" so the bearing housing rotates freely.
- Block rotor in position by welding temporary steel brackets, (flat bar or key stock) to side of rotor and bottom frame.





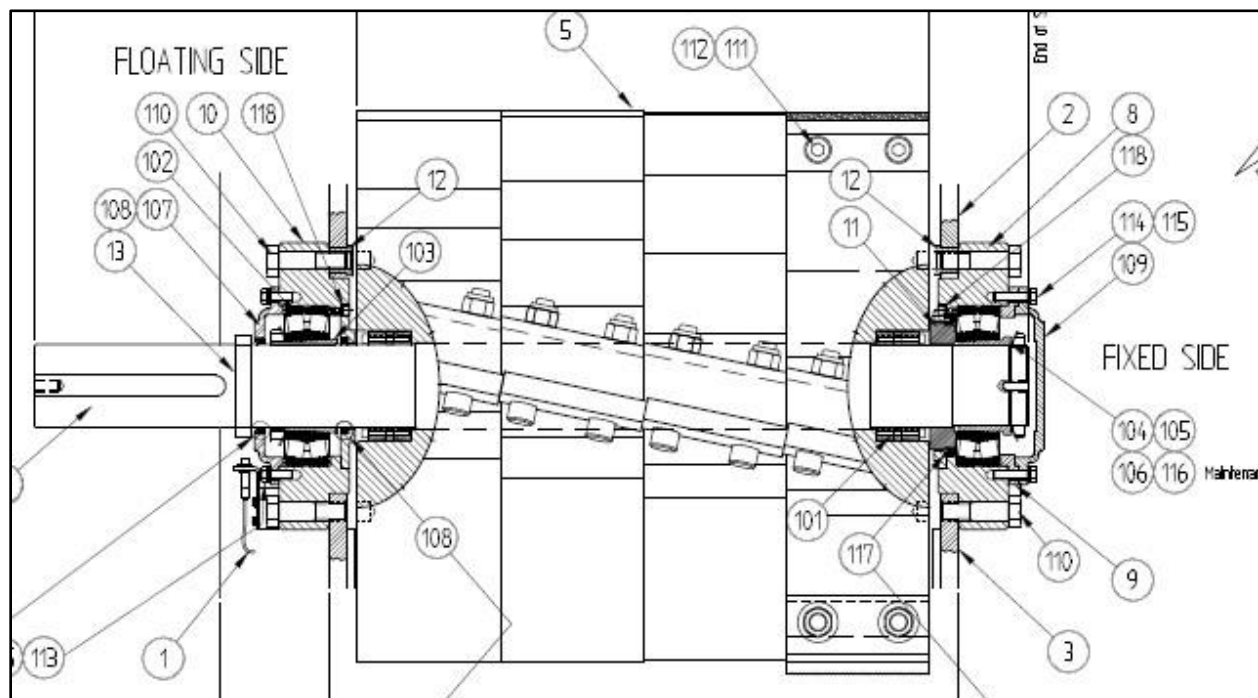
REMOVING ROTOR BEARINGS (continued)

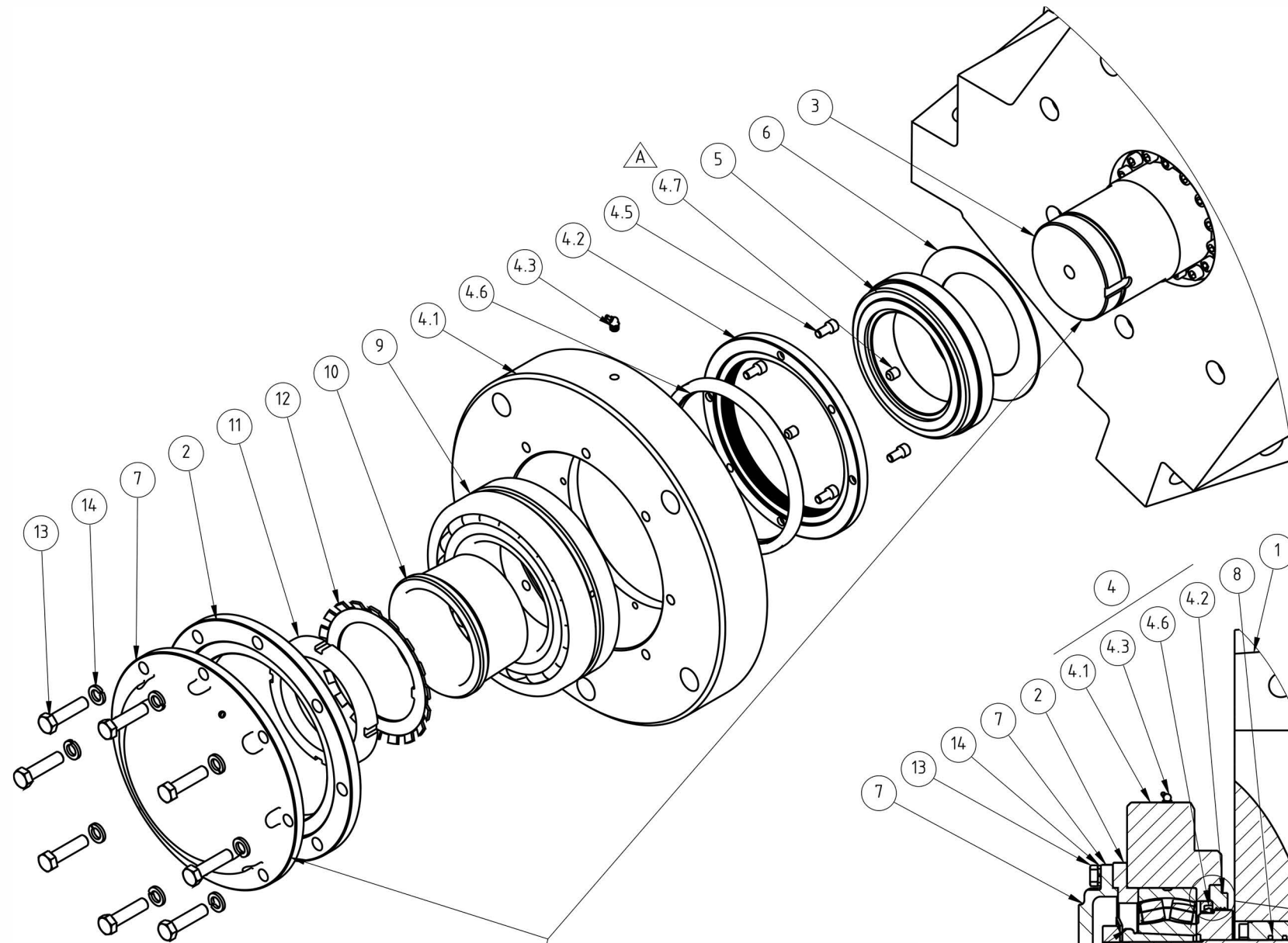
FIXED BEARING – see Drawing #C-20110632 Rev A on Page 4

- Remove bearing cap, clean off all grease residue.
- Remove locknut holding withdrawal sleeve.
- Use RN-38 withdrawal nut to loosen the withdrawal sleeve.
- Remove bearing housing with bearing and withdrawal sleeve from shaft.
- Push bearing out of housing using jacking holes in back of housing.
- Clean bearing housing and check for wear, replace with new as needed.

FLOATING BEARING - see Drawing C-20110633 Rev A on Page 5

- Remove bearing cap, clean off all grease residue.
- Loosen tapered sleeve nut and press tapered sleeve inwards.
- If unsuccessful use a cutting torch to cut bearing rollers out. This will allow inner race to expand and free up tapered sleeve.
- Remove bearing housing with bearing and tapered sleeve from shaft.
- Push bearing out of housing using jacking holes in back of housing.
- Clean bearing housing and check for wear, replace with new as needed.





ITEM	DESCRIPTION	QTY	COMMENT
1	ROTOR WELDMENT, Continuous Spiral	1	
2	ROTOR FIXED BEARING CAP SPACER	1	40110509
3	ROTOR SHAFT	1	
4	BEARING HOUSING, FIXED, SEAL	1	40110713
4.1	ROTOR BEARING HOUSING for INSERT SEALS	1	40110747
4.2	INSERT for FIXED BEARING with SEAL	1	40110748
4.3	ALEMITE #1629-B GREASE FITTING 1/4NPTM 65 Deg	1	
4.4	ANSI #1/2 NPT HEX SOCKET PIPE PLUG	1	50011106
4.5	ANSI #1/2-13NC x 1"Lg Skt Hd Hex Capscrew, Gr5-ZNC	4	50011107
4.6	CLIPPER #JM-1025-16566-LUP SEAL	1	JM1025.16566
4.7	ANSI #5/8-11NC x 3/4" Lg Soc Hd SETSCREW, CUP PT, BLK	2	50011109
5	ROTOR FIXING SPACER for Model #4800	1	40110715
6	ROTOR SPACER SHIM	2	40110751
7	MEITHER #KS-538-CL Bearing Cap with Closed End	1	KS-538-CL (7001-3501)
8	B-LOC #B152615 LOCKING ASSEMBLY, B115 x 6 15/16" Dia	1	7001-0012
9	SKF #22238CCKW33 C3 SPHERICAL ROLLER BEARING	1	7001-3104-C3
10	SKF #SK38 x 170mm Dia WITHDRAWAL SLEEVE	1	7001-3117
11	SKF #AN 34 LOCKNUT	1	AN-34 (7001-3118)
12	SKF #W 34 LOCKWASHER	1	W34 (7001-3119)
13	ANSI #3/4NC x 3"Lg HEX BOLT, Gr5-ZNC	8	50010195
14	ANSI #3/4 Dia LOCKWASHER, Helical Spring, Gr5-ZNC	8	50010395

Shaft End & Cap may not be as shown

use RN-38 for removal
Shaft Ends & Caps may not be as shown refer to original drawings

NOTE ORIENTATION to allow grease to purge

FIXED END BEARING

note:
ITEM 6's are to center rotor
MEASURE EXISTING SPACER WIDTH then
SUBTRACT 2.25" [new spacer width]
divide total by .06" to to DETERMINE
how many SHIMS are required

Wgh't: 17134.64 lbs

UNLESS OTHERWISE SPECIFIED
DIMENSIONS ARE IN INCHES.
MACHINED TOLERANCE:
DECIMAL DIMENSIONS: ±0.005
FRACTIONAL DIMENSIONS: ±0.015
BREAK ALL SHARP EDGES.

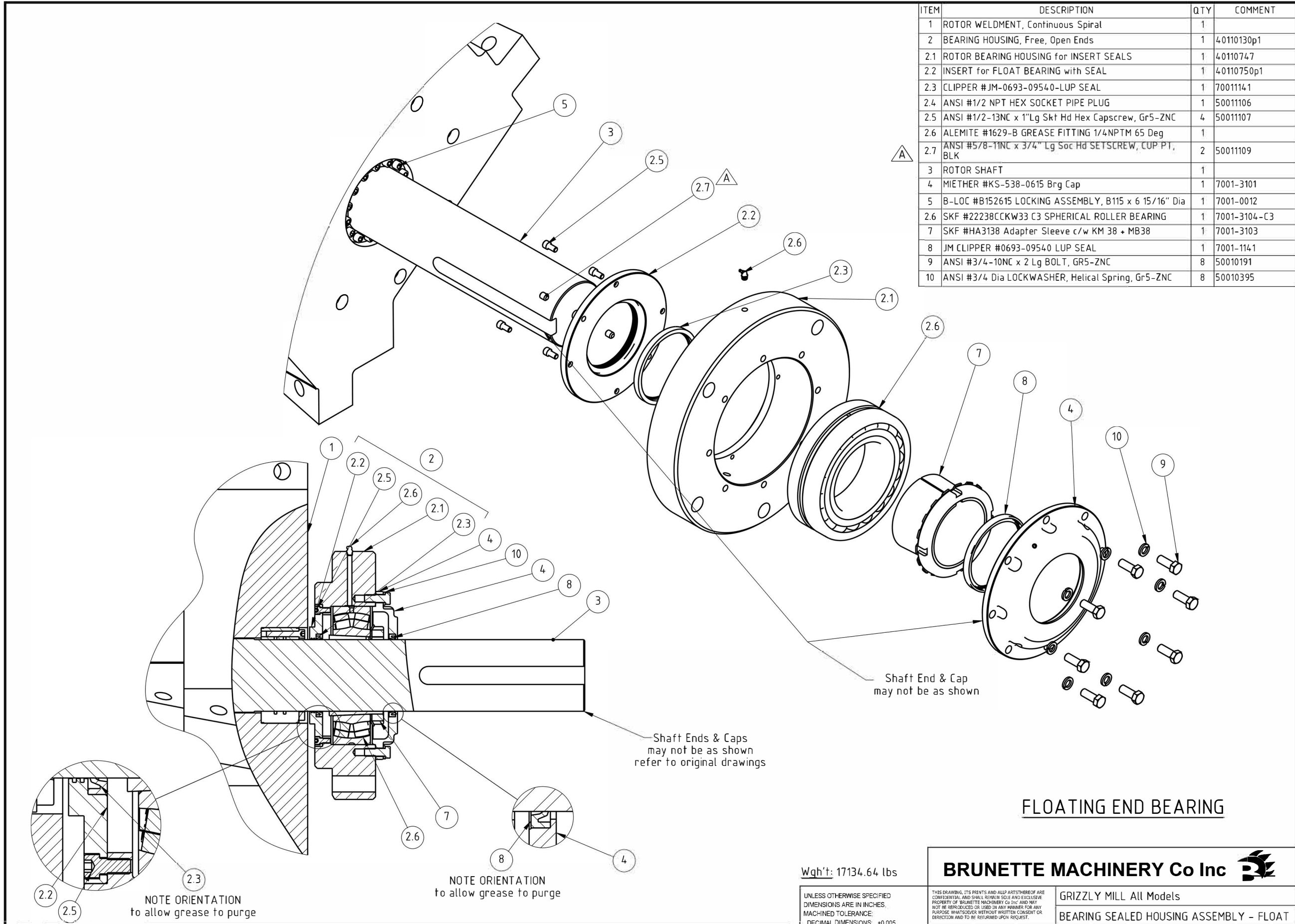
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GRIZZLY MILL All Models
BEARING SEALED HOUSING ASSEMBLY - FIXED

BRUNETTE MACHINERY Co Inc


REV	BY	DATE	DESCRIPTION
A	Tegart	18-01-19	ADDED PUSHER SCREWS

DRAWN BY	CHECKED BY	DATE	SCALE	SHEET	DWG No	SHEET	REV
tegart		17-10-11	1:6	C	20110632	1 of 1	A



ITEM	DESCRIPTION	QTY	COMMENT
1	ROTOR WELDMENT, Continuous Spiral	1	
2	BEARING HOUSING, Free, Open Ends	1	40110130p1
2.1	ROTOR BEARING HOUSING for INSERT SEALS	1	40110747
2.2	INSERT for FLOAT BEARING with SEAL	1	40110750p1
2.3	CLIPPER #JM-0693-09540-LUP SEAL	1	70011141
2.4	ANSI #1/2 NPT HEX SOCKET PIPE PLUG	1	50011106
2.5	ANSI #1/2-13NC x 1"Lg Skt Hd Hex Capscrew, Gr5-ZNC	4	50011107
2.6	ALEMITE #1629-B GREASE FITTING 1/4NPTM 65 Deg	1	
2.7	ANSI #5/8-11NC x 3/4" Lg Soc Hd SETSCREW, CUP PT, BLK	2	50011109
3	ROTOR SHAFT	1	
4	MIETHER #KS-538-0615 Brg Cap	1	7001-3101
5	B-LOC #B152615 LOCKING ASSEMBLY, B115 x 6 15/16" Dia	1	7001-0012
2.6	SKF #22238CCKW33 C3 SPHERICAL ROLLER BEARING	1	7001-3104-C3
7	SKF #HA3138 Adapter Sleeve c/w KM 38 + MB38	1	7001-3103
8	JM CLIPPER #0693-09540 LUP SEAL	1	7001-1141
9	ANSI #3/4-10NC x 2 Lg BOLT, GR5-ZNC	8	50010191
10	ANSI #3/4 Dia LOCKWASHER, Helical Spring, Gr5-ZNC	8	50010395

Wght: 17134.64 lbs

BRUNETTE MACHINERY Co Inc 

GRIZZLY MILL All Models
BEARING SEALED HOUSING ASSEMBLY - FLOAT

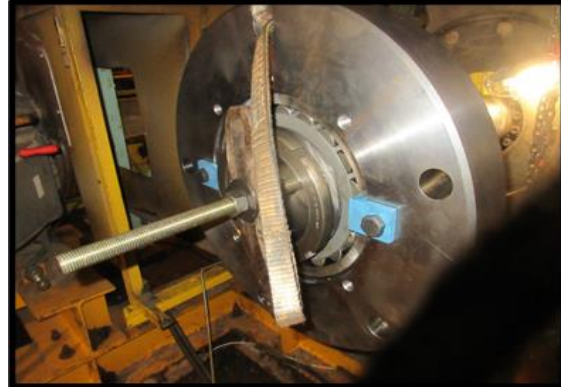
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REV	BY	DATE	DESCRIPTION
A	Tegart	18-01-19	ADDED PUSHER SCREWS



INSTALLATION OF FIXED AND FLOATING BEARINGS

Install new bearing in housing with tapered sleeve facing out, add two bolts & flat washers in the threaded cap holes. This will prevent bearing from moving out during handling.



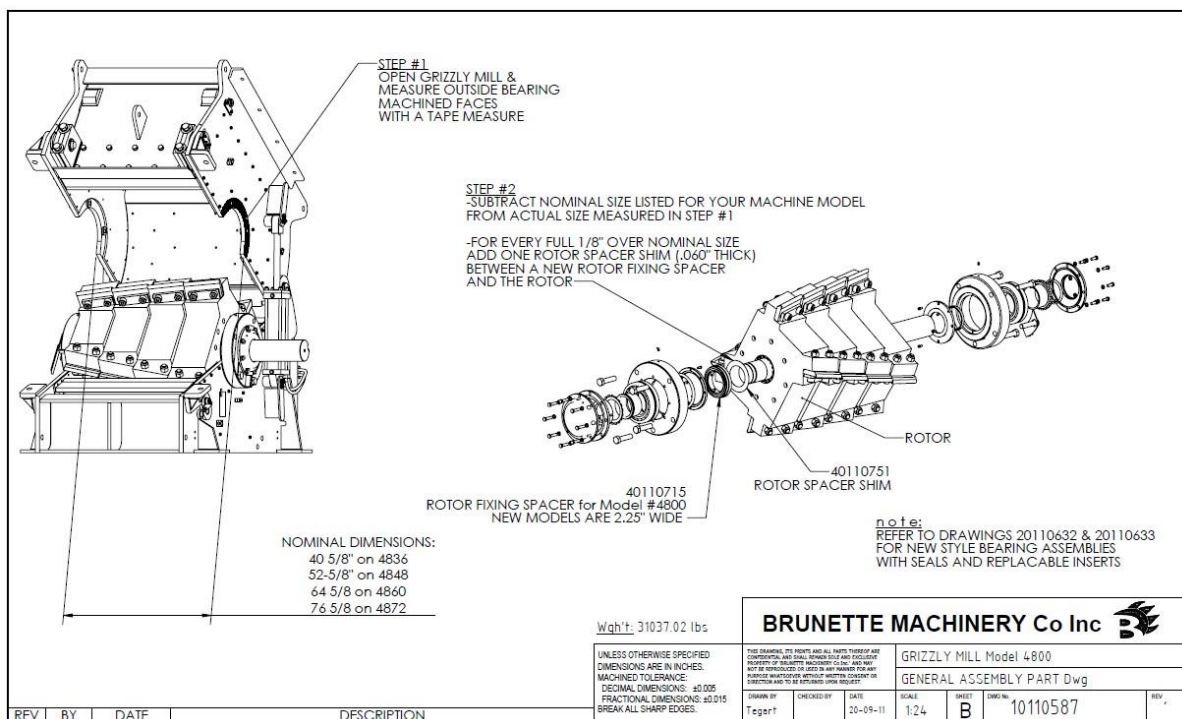
- Center rotor position in lower frame, calculate fixing spacer position, add, or remove adjustment shims as required.
- Install new bearing in housing with removal sleeve installed from the outside.
- Slide complete unit onto shaft and move up against side frame and fixing spacer.
- Install caps to prevent contamination then support rotor and remove welded steel brackets. Grind off all weld residual, which may prevent the top box from closing fully.
- With the rotor raised up, remove caps and slide bearing housing into position.
- Lower rotor and position lower bolt holes. Install three bolts in fixed bearing first then move to the floating side.
- Confirm total bearing clearance. Check manufacturers recommendation for clearance reduction and remaining internal clearance.
- Recommended **clearance reduction** value is **[0.0035" to 0.0040"]**.
- See installation and maintenance manual. Rule of thumb: the last two digits of the bearing number (**22238CCK/W33 = .0038"**) is the clearance reduction value.
- Bearing radial **internal clearance** after mounting should be **(0.005" to 0.006")**.
- Rotate rotor multiple times to ensure bearing rollers have assume their correct position.
- Tighten locknuts and install lock washer tabs.





INFORMATION

- Fixed Bearing = installed removal sleeve by tightening nut on shaft. Sleeve and bearing should fully contact fixing spacer between shaft and rotor.
- Fixing spacer is supplied with adjustment shims, these are used to center the rotor in the main frame, adding shims moves the rotor away from fixed side.
- Floating Bearing = measure distance from face of housing to bearing outer race, this dimension needs to be 1/2" ± 0.032"



Preventative measures

- Most bearing failures are from lack of lubrication or excessive greasing. Over greasing or filling the bearing housing is just as bad as no grease.
- Impacts from foreign material can damage rotor bearings = Overheating may occur.
- Welding on rotor with ground wire attached to mainframe. With current traveling through bearing rollers. = Failure is immediate.
- Installing RTD's or temperature sensors are recommended by the OEM.
- See Parts and Service Manual for recommended grease.



BRUNETTE PARTS AND SERVICE

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- Service 24/7

Service

Our on-site service visit provides:

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- Detailed Follow-up Reports
- Preventative Maintenance Recommendations

Contact us for Parts and Onsite Service and Training

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