



How to Replace the Rotor Bearings in a Grizzly Mill Hog

Bearings

The rotor of the Grizzly Mill turns on two heavy-duty spherical roller bearings. The bearings can be replaced with the rotor in position.

Note: Install the fixed bearing [non-drive side] first to ensure the correct location of the free [floating] bearing

Removal of floating [drive side] bearing

1. Raise the rotor on each side [$\pm 1/32$ "] so the bearing housings rotate freely. Block the rotor in position by welding temporary steel to the side of rotor and the bottom frame side plate.
2. Remove locknut holding withdrawal sleeve.
3. Use RN-38 withdrawal nut to loosen the withdrawal sleeve.
4. Remove bearing housing with bearing and withdrawal sleeve from the shaft.
5. Push bearing out of housing using jacking holes in housing.

Installation of floating [drive side] bearing

1. Rotor is welded to bottom frame by temporary steel angles or square bars and blocked.
2. Mount bearing on withdrawal sleeve in housing and install onto shaft.
3. Recommended **clearance reduction value** is [0.0035" to 0.004"]. See SKF Bearing Installation and Maintenance Guide. Rule of thumb: the last two digits of the bearing number [ie: 222**38**CCK/W33 = .0038"] is the **clearance reduction value**.
4. Bearing radial internal clearance after mounting is [0.005" to 0.006"]. Tighten locknut to suit.
5. Pack bearing with grease, using an injector needle from the inside to the outside. Fill 100% of the bearing raceway cavity only. Rotate the bearing as grease is being filled.
6. Fill the bearing housing free space with 20 to 30% grease.

Removal of fixed [non-drive side] bearing

1. Raise rotor [$\pm 1/32$ "] by jacking up the bearing housing and block in position. Weld temporary steel to the side of rotor and the bottom frame side plate to secure in position.
2. Loosen the adapter sleeve locknut and drive the sleeve towards the rotor.
3. Remove bearing housing with bearing and adapter sleeve from the shaft
4. Push bearing out of housing using jacking holes in housing.

Installation of fixed [non-drive side] bearing

1. Rotor is welded to bottom frame by temporary steel angles or bars and blocked.
2. Mount bearing on adapter sleeve in housing and install onto shaft.
3. Maintain $\frac{1}{2}$ " step between the face of the bearing housing and the outer race of the bearing. This will allow for float in the housing on both sides of the bearing.
4. Tighten taper adapter sleeve locknut and **set bearing clearance as noted above**.
5. Pack bearing with grease, using an injector needle from the inside to the outside. Fill 100% of the bearing raceway cavity only. Rotate the bearing as grease is being filled.
6. Fill the bearing housing free space with 20 to 30% grease.