

# R0015287 Bench Assemble Shafts, Bearings and Pinions

Instructions to prepare parts for fitting to main frame

 Difficulty **Medium**

 Duration **1 hour(s)**

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Comments

## Introduction

### Tools Required

Compressed air line  
180 grit emery tape  
Fe10 solvent  
Cleaning cloth  
Standard Hex key set  
Standard spanner set  
Grease gun

### Parts Required

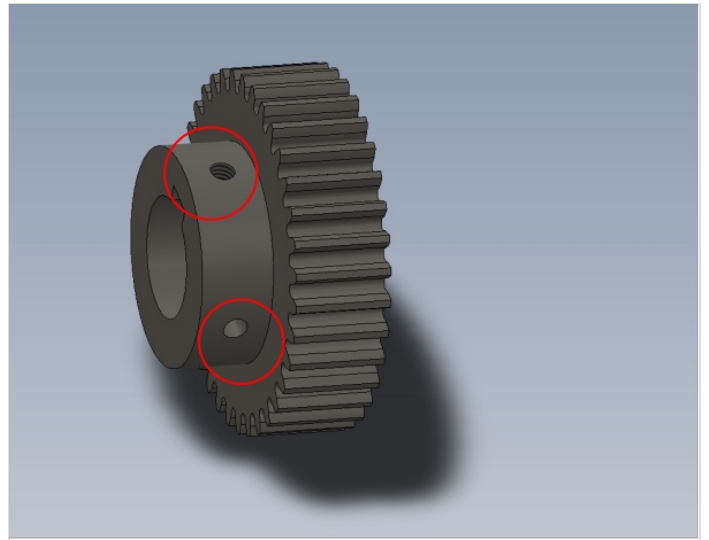
D0015556 x 1  
D0015555 x 1  
B0001094 x 9  
B0000228 x 9

## Step 1 - Quality check

That that indicated 2 of M6 tapped holes are taped through

To check wind M6 grubscrew through hole and make sure it exits the other side

9 off to check



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## Step 2 - Clean shafts

Ensure shafts D0015556 and D0015555 are clean before trial fitting .

1 check for any burrs or damage to shafts . Remove with File/emery tape 180 grit if present

2 Use compressed air to clean debris from all keyways on shafts .

3 Use Fe10 solvent to remove contaminants on shafts



## Step 3 - Clean and prepare bearings

Ensure bearings B0000228 9 off are clean before trial fitting

- 1 Check for any internal burrs especially around grub screw point .  
If present remove with emery tape 180 grit
- 2 Use compressed air to remove and debris
- 3 Use Fe10 solvent to remove any contamination



## Step 4 - Clean and prepare Pinions

Ensure B0001094 Pinions 9 off are clean before trial fitting

- 1 Check for any internal burrs especially around grub screw point .  
If present remove with emery tape 180 grit
- 2 Use compressed air to remove and debris
- 3 Use Fe10 solvent to remove any contamination



## Step 5 - Check fitment of prepared parts.

Check the following

- 1 Every B0000228 bearing passes freely over each shaft
- 2 Every B0001094 pinion passes freely over each shaft

If tight spots are found, these steps should be followed

- If all pinions/bearings pass freely on a shaft but one is tight, polish out individual pinion to achieve correct fitment
- If all pinions ( Or most off) are tight , polish main shaft down with emery tape 180 to remove high spot

**⚠** ...When performing any adjustments using emery tape., parts must be thoroughly cleaned before trial fitting again as grit residue can caused components to bind together on assembly

## Step 6 - Fit grease points

1 Attach supplied grease points and covers to B0000228 bearings (18 off)

2 Use grease gun to grease bearings to aid assembly

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