

# R0015296 Bench Assemble Bearing Assemblies

bench assembly instructions for bearing blocks

 Difficulty **Medium**

 Duration **1 hour(s)**

## Contents

Introduction

Step 1 - Unless otherwise stated

Step 2 - Degrease

Step 3 -

Step 4 - Heat bearing blocks D0006023

Step 5 - Heat second bearing blocks

Step 6 - Fit bearings

Step 7 - Fit bearings

Step 8 - Cooling

Comments

## Introduction

### Tools Required

Heat Gun  
Standard Hex key set  
Fe10 solvent

### Parts Required

B0000109 Linear Bearing (IKO) 40 D x 62 D x 80 L x 8  
D0003236 Nut Block (25 x 10 pitch) x 1  
D0006003 Horizontal Linear Block x 3  
D0006023 Vertical Linear Block x 4

## Step 1 - Unless otherwise stated

Use Loctite 243 on all fasteners

Use Loctite 572 on all threaded pneumatic connection

Pen mark all fasteners to show finalised



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## Step 2 - Degrease

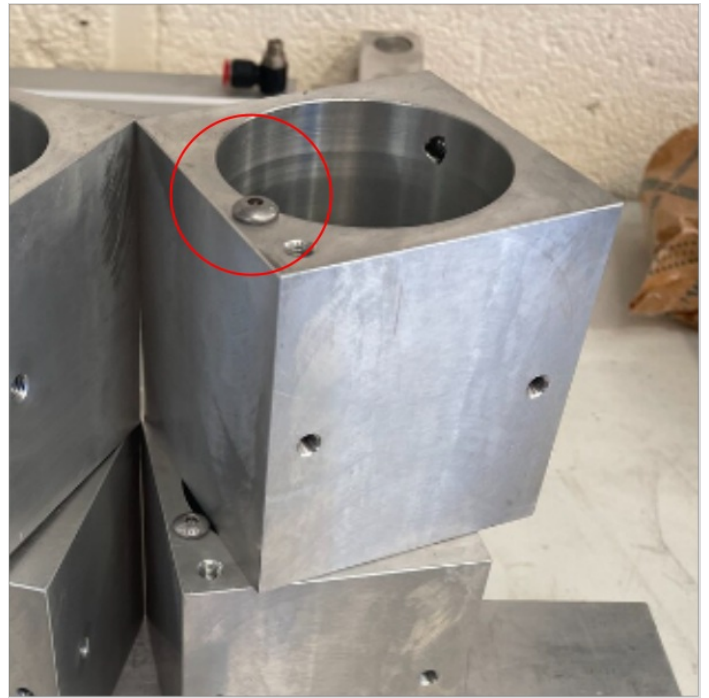
Thoroughly degrease all parts

- B0000109 Linear Bearing (IKO) 40 D x 62 D x 80 L x 8
- D0003236 Nut Block (25 x 10 pitch) x 1
- D0006003 Horizontal Linear Block x 3
- D0006023 Vertical Linear Block x 4



## Step 3 -

Add 1 off M5 x10 button head to each D0006023 Vertical Linear Block as shown



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## Step 4 - Heat bearing blocks D0006023

Apply heat to bearings to swell bores



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## Step 5 - Heat second bearing blocks

Start heating bearing blocks

D0003236 Nut Block (25 x 10 pitch) x 1  
D0006003 Horizontal Linear Block x 3

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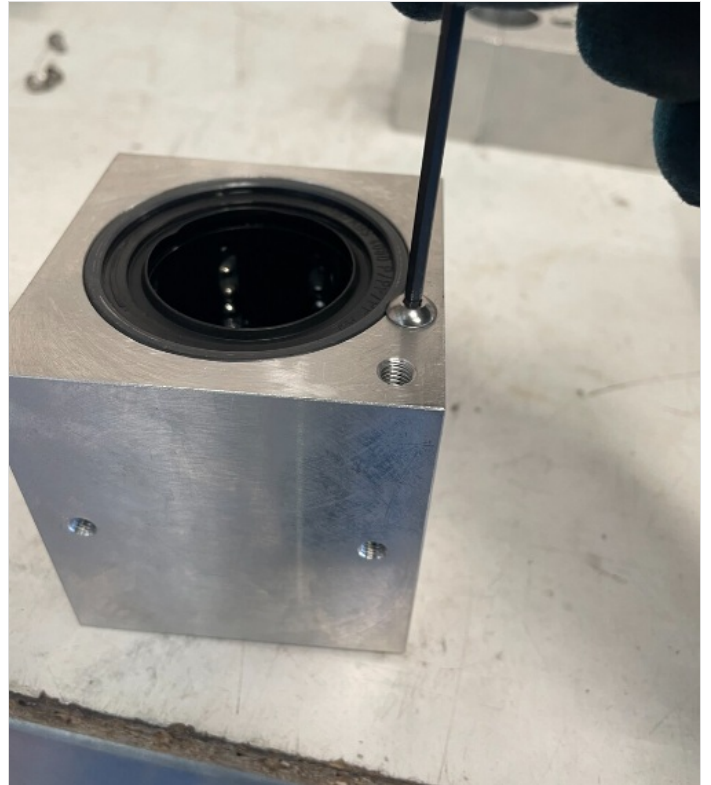
## Step 6 - Fit bearings

4 off

Apply Loctite 641 to bearing as shown

Insert bearing into hot block D0006023 and captivate with a M5 x 10 button head

Wipe of any excess 641 with rag



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## Step 7 - Fit bearings

Apply loctite 641 as shown to 4 off B0000109 bearings

Insert into hot blocks

D0003236 Nut Block (25 x 10 pitch) x 1

D0006003 Horizontal Linear Block x 3

Bearing should be centralised in bore . No retaining fasteners are used on these blocks

Remove any excessive 641 after installation of bearing







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## Step 8 - Cooling

Place all blocks aside to allow to cool

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