



Model/Serial Range: **Model Number:** **Serial Numbers:**
03450 00000-99999

As the roller bearings are adjusted to compensate for wear, the bearing cage may make contact with the roller housing. Contact between the bearing cage and the housing will prevent the roller from rotating freely and could cause the roller to skid during operation. Extended bearing performance and service life are possible, if a counter-bore is added as described below.

1. Secure roller housing in a vice and remove the roller shaft, seals, and bearings.
2. To simplify outer race removal, use an electric arc welder to shrink the bearing race. Only a small arc in one location on the race is required.
3. Use a die grinder to grind a counter-bore as shown in the illustration below. Counter-bore should be $1 \frac{5}{16}$ " (33 mm) diameter and $\frac{1}{16}$ - $\frac{1}{8}$ " (1.5 - 3.0 mm) deep.
4. Clean grinding dust and debris from the housing.
5. Assemble the roller using new replacement bearings, races, seals, and nuts. Use a press to seat the outer races into their bores.
6. Tighten nuts while rotating the roller to seat the bearing cone in position.
7. Loosen the nuts and then tighten again to provide 5 in-lb (5.8 KgCm) rolling torque.

