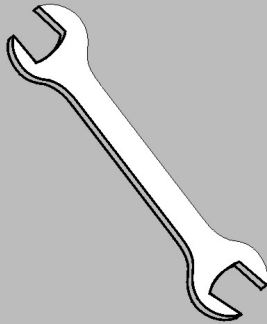


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Kit Instruction— K13 0002



Please Read

About the Manual Identifying Information on the Cover

The front cover displays pertinent identifying information for this manual. Most important, are the published manual number (part number) /ECN (date code). Generally, when a replacement manual is furnished, it will have the same published manual number, but the latest available ECN. This provides the user with the latest information applicable to his machine. Similarly all documents comprising the manual will be the latest available as of the date the manual was printed, **even though older ECN dates for those documents may be listed in the table of contents.**

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References to Yellow Troubleshooting Pages

This manual may contain references to "yellow pages." Although the pages containing troubleshooting procedures are no longer printed on yellow paper, troubleshooting instructions, if any, will be contained in the easily located "Troubleshooting" chapter or section. See the table of contents.

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GUIDELINES FOR CHANGING 36" & 42" QWE REMANUFACTURED BEARING HOUSINGS

In addition to the usual procedure for changing a 36" & 42" QWE bearing housing, the guidelines below should be followed. These guidelines are primarily to prevent stripping the threads in the bearing housing mounting holes.

1. Rear bearing housing support plate must be removed first. Do Not merely remove rear bearing housing bolts & leave plate in machine bolted to the side and top. Remove it!
2. Remove bearing housing from machine.
3. Be sure all threaded holes in remanufactured bearing housing are clean. Blow out with air or run tap in holes to clean if necessary.
- *4. Try a bolt in each hole, by hand, before installing remanufactured bearing housing, to be sure bolts go in each hole easily, meaning threads are clean & in good condition.

***NOTE: This step may not be necessary as remanufactured bearing housings are shipped with bolts in all mounting holes.**

5. Install new bearing housing in machine without rear support.
6. Be sure holes in front flange of bearing housing line up with holes in shell back by first installing all bolts by hand.
7. Do not tighten any bolts until all front flange bolts have been started into the bearing housing about 3/4 of the way.
8. Tighten all front flange bolts in a diagonal pattern to draw housing into shell back evenly.
9. At this point all front flange bolts should now be torqued to proper specifications.

NOTE: Only after all above steps have been taken should you proceed with the following steps to install the rear bearing housing support plate.

10. Before installing rear support plate, drop a bolt into each hole to insure the bolts fit cleanly through the holes. Also, the head of the bolt fits "flush" against the support plate. If not, open the hole slightly with a drill and bit to insure the bolt head does fit flush against the support plate.
11. Install bearing housing rear support plate by installing bolts through center hole circle into bearing housing. Do Not install side or top support bolts at this time!
12. Install all rear bearing housing bolts into rear of bearing housing, through rear support plate by hand about 3/4 of the way.
13. Tighten all rear bearing housing support plate bolts in a diagonal pattern until all are tight.
14. At this point, all rear bearing housing support plate bolts on the center circle should now be torqued to proper specifications.
15. Install, tighten and torque all side and top, rear bearing housing support bolts to proper specifications.
16. Complete the remainder of the change as usual.

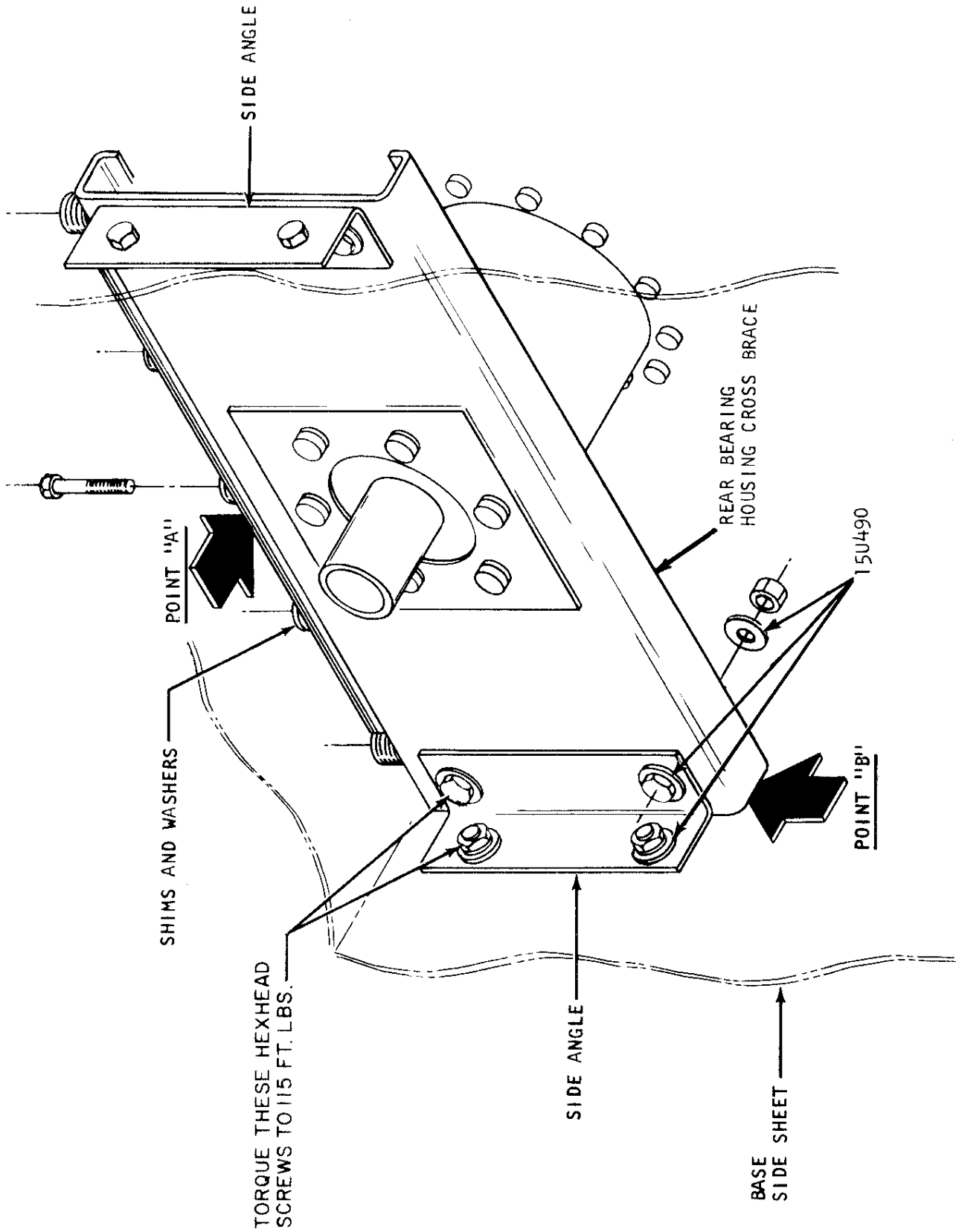
INSTRUCTIONS TO INSTALL QWE BEARING HOUSING

Refer to the drawing and instructions on page BMP750052-75492A.

1. Before installing the bearing housing in the machine, use the tube of Silastic sealant furnished with the kit and coat the rear side of the bearing housing flange which seats against the shell back. Coat this surface completely but sparingly--no thicker than 1/16". Do not use any other gasket material for this purpose!
2. Before installing the bearing housing in the shell back, use Locquic primer on the two surfaces indicated on the above drawing to clean it. Then apply the Loctite stud lock also mentioned in the drawing. Put grade 222 Loctite on the main bearing housing bolts. THESE BOLTS MUST BE PUT IN WITH A TORQUE WRENCH. Tighten the bolts to the torque foot pounds specified on the drawing. Do not over tighten the bolts--follow the instructions carefully. Do not use the old locking straps previously used to hold these bolts. Use instead the grade 9 flat washers furnished in the kit.
3. Before attaching the rear cross brace to the rear end of the main bearing housing, use the Locquic primer and the Loctite mentioned on the drawing on the surfaces indicated. Secure the rear cross brace to the rear end of the main bearing housing with the new socket head screws furnished.
4. Replace the shims and the washers on top of the cross brace as necessary and drop in the bolts, but do not tighten them at this time. It may be necessary to use a drift punch to line up the shims and washers with the holes in the top of the frame. Once this is accomplished, you can easily drop the bolts in the holes from the top. Do not tighten them up at this time. Refer to the drawing on the back side of this page which shows how to use wedges for proper cylinder alignment if necessary.
5. Attach the rear cross brace to the frame side of the machine with the two side angle irons. Use the new 1/4" thick flat washers furnished to cover up the slotted holes in the angle irons. Do not use the old thin washers which may collapse across the slots. After you have these bolts in place and loosely set, you are now ready to install the cylinder on the front of the main bearing housing. Before installing the cylinder, clean off any excessive Silastic which may have been squeezed out between the bearing housing flange and the shell back liner. If this is allowed to stay inside the machine, it could cause laundering problems when the machine is first put into use.
6. Once the cylinder is secured to the main shaft, install the shell front.
7. Check the opening of the shell front with the opening of the cylinder to see if they are in alignment. If the misalignment is excessive, it could cause the cylinder to strike the door. To align the cylinder, go to the rear of the machine and use wedges as shown on the drawing BMP740118R. If the cylinder is too low, drive in a wedge at point "A" shown on the drawing. If the cylinder is too far on the left, drive a wedge in between the cross brace and the base side sheet of the machine at point "B" shown on the drawing. Once the cylinder is in proper alignment, tighten up all 8 bolts, 1/4" thick flat washers and lock washers to secure the cross brace in the proper place. At the same time, you are now ready to tighten the 5 bolts in the top of the rear cross brace.
8. Be sure to follow the instructions with regard to the proper tightening by foot pounds of torque shown on the installation drawing. Do not deviate from any of these instructions.

(See Reverse)

SERVICE DEPARTMENT



REFER TO PAGE BMP750052 FOR ADDITIONAL TORQUE INFORMATION