

## INSTALLATION INSTRUCTIONS

### Mounting

When mounting, always clean shafting and bearing bore. Then, having coated the shaft with a light oil, slide the bearing unit on the shaft to its correct position. It may be necessary to use a soft mallet and/or pipe, on the inner ring only, to reach the correct position. Never pound on, or apply pressure to, the outside ring! Once the bearing unit is in position, precise alignment can be achieved by first fixing the housing in place, then simultaneously rotating and tapping the shaft with a soft mallet. This should be accomplished before any locking collar or set screw is tightened.

**IPTCI**  
**B E A R I N G S**

When mounting a locking collar bearing, use a spanner wrench or punch to lock the collar in place – always in the direction of shaft rotation. Then tighten set screw. Do not use locking collar bearings for bi-directional applications.

When mounting set screw locking bearings IPTCI recommends the following torque settings:

Standard steel set screws – for UC, NA, SB & SA inserts

Set screw Size	Max. Recommended Torque (In.lbs.)
10-32	28
¼-28	66
5/16-24	126
3/8-24	228
7/16-20	306
½-20	330

400 Series stainless set screws – for SUC, SUCX, SSB, SNA & CUC bearing inserts

Set screw Size	Max. Recommended Torque (In.lbs.)
¼-28	54
5/16-24	110
3/8-24	205

### Torquing of set screws - 3-Step alternating process:

It is strongly recommended that upon commencement of set screw torquing 1) the first set screw should not be tightened greater than 50% of the above Maximum Recommended Torque (MRT). 2) The second set screw may then be tightened to the MRT. 3) The process is completed by returning to the first set screw and tightening it to the MRT. Torque wrenches are recommended for accurate tightening.