Important general data:

Shaft	Direct mounting	Depends on the application
	Sleeve mounting	h9/IT5
Supporting	Flatness	IT7 - IT8
	Surface roughness	$R_a \leq 12{,}5$ µm
Cap bolts	Please note that the housings are supplied with the cap bolts partly unscrewed to make it more easy to remove cap when mounting bearing. After mounting it is most important to tighten the cap bolts to correct tightening torque, if not the bearing seating tolerance in housing will not remain within the specification.	
Painting system	Alkyd RAL 9005	Pigment black
	Thickness	80 µm
Coating	The colour is possible to coat. **Important to notice.** The colour is resistant to normally used low-alkalic detergents. Follow the recommendations from the detergent supplier.	

Mounting of bearing reference

SKF Bearing Maintenance Handbook (publication 4100) or SKF General Catalogue (publication 6000).

Table 1 **Housing**	**Cap bolts 8.8** **Tightening torque** Nm		**Attachment bolts 8.8** **Tightening torque** Nm	
SNL 3036, 3038, 3134, 3136	M 24×140	350	M 24	665
SNL 3040, 3138, 3234, 3236	M 24×150	350	M 24	665
SNL 3044, 3048, 3140, 3144, 3238, 3240	M 24×160	350	M 30	1 310
SNL 3052, 3148, 3244	M 30×80	400	M 30	1 310
SNL 3056, 3060, 3152, 3156, 3248	M 30×200	400	M 36	2 280
SNL 3064, 3068, 3072, 3160, 3164, 3252, 3256, 3260	M 30×220	400	M 36	2 280
SNL 3076, 3080, 3084	M 36×240	600	M 36	2 280
SNL 3168, 3172, 3176, 3264, 3268	M 36×240	600	M 36	2 280
SNL 3088, 3180, 3272	M 36×240	600	M 42	3 640
SNL 3092, 3096, 30/500, 3184, 3188, 3276, 3280	M 42×280	850	M 42	3 640
SNL 3192, 3284	M 42×300	850	M 42	3 640
SNL 30/530, 3196, 3288	M 42×320	850	M 48	5 450

Table 2 Recommended grease quantities for SNL plummer blocks housings of series 30, 31 and 32

Housing Designation	**Grease quantities First fill**		**Housing Designation**	**Grease quantities First fill**		**Housing Designation**	**Grease quantities First fill**	
	40 %	**20 %**		**40 %**	**20 %**		**40 %**	**20 %**
-	kg		-	kg				
SNL 3036	1,2	0,7	SNL 3134	1,1	0,7	SNL 3234	1,9	1,2
SNL 3038	1,5	0,9	SNL 3136	1,4	0,9	SNL 3236	1,9	1,2
SNL 3040	2,0	1,2	SNL 3138	1,8	1,2	SNL 3238	2,2	1,4
SNL 3044	2,7	1,6	SNL 3140	2,3	1,5	SNL 3240	2,5	1,7
SNL 3048	3,0	1,8	SNL 3144	2,7	1,7	SNL 3244	3,0	2,1
SNL 3052	3,9	2,3	SNL 3148	3,4	2,2	SNL 3248	3,8	2,7
SNL 3056	4,9	2,8	SNL 3152	4,3	2,8	SNL 3252	5,6	3,8
SNL 3060	5,2	3,1	SNL 3156	4,4	2,9	SNL 3256	5,6	3,9
SNL 3064	7,0	4,1	SNL 3160	6,2	4,0	SNL 3260	6,9	4,8
SNL 3068	8,7	5,1	SNL 3164	7,7	5,0	SNL 3264	8,6	6,0
SNL 3072	10,9	6,2	SNL 3168	9,4	6,2	SNL 3268	8,4	6,3
SNL 3076	10,9	6,3	SNL 3172	9,7	6,4	SNL 3272	10,7	7,8
SNL 3080	11,7	6,7	SNL 3176	9,6	6,4	SNL 3276	12,3	8,9
SNL 3084	11,8	7,0	SNL 3180	12,2	8,0	SNL 3280	14,6	10,6
SNL 3088	14,4	8,5	SNL 3184	14,9	10,0	SNL 3284	15,2	11,5
SNL 3092	18,8	10,9	SNL 3188	16,2	10,7	SNL 3288	15,1	11,8
SNL 3096	18,5	10,8	SNL 3192	17,4	11,8			
SNL 30/500	20,0	11,6	SNL 3196	17,2	12,1			
SNL 30/530	21,5	12,9						

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Mounting instruction for SNL 30, SNL 31 and SNL 32 housings with taconite seals





Mounting SNL housings with taconite seals

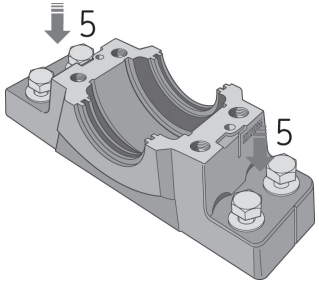
Before starting installation work, the following instructions should be read carefully.

1. Make sure that the work area is clean. Check the dimensional and form accuracy of the shaft seat. The shaft should be machined to a tolerance of h9/IT5 for adapter sleeve mounting.

2. Check that the roughness of the support surface is $R_a \leq 12{,}5$ µm. The flatness (planicity) tolerance should be to IT7.
Make sure that the mounting surface is clean. If shims are used, the whole surface must be covered by shims. The mounting surface (frame) must be designed to accomodate actual loads, vibrations and settings.

3. Mount any components that are on the shaft between the two SNL housings.

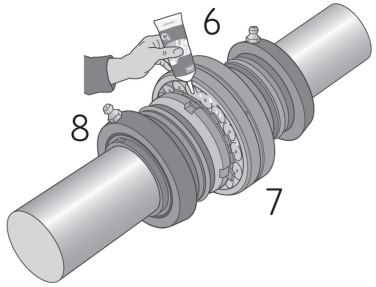
4. If the bearing is mounted on an adapter sleeve, determine its position relative to the housing. For spherical roller bearings with a lubrication groove and three holes in the outer ring, SKF recommends using the relubrication hole in the centre of the housing. When relubrication from the side of the bearing is required, e.g. for CARB toroidal roller bearings, the housing must be positioned so that the grease fitting is on the opposite side of the nut. When a housing is located at the end of a shaft, grease should be applied at the end cover side.



5. Position the housing base on the support surface. Fit the attachment bolts, but do not tighten them.

6. Slide the parts for the first seal to the correct position on the shaft. The lip of the V-ring should point towards the bearing. Do not tighten the grub screws.

7. Mount the bearing on the shaft – either directly on a stepped shaft or using an adapter sleeve. Completely fill the bearing with grease. The remainder of the recommended grease quantity should be put in the housing base at the sides (see **table 2**).

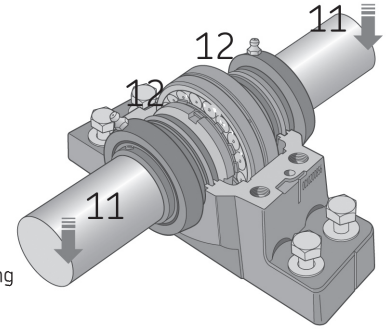


8. Mount the second seal according to point 6 (if a stepped shaft is used, first mount the distance ring). If the housing is to be used at the end of a shaft, the second seal is omitted and an end cover inserted in the housing base instead.

9. Check that the O-ring is in the correct position on the outside diameter of the seal.

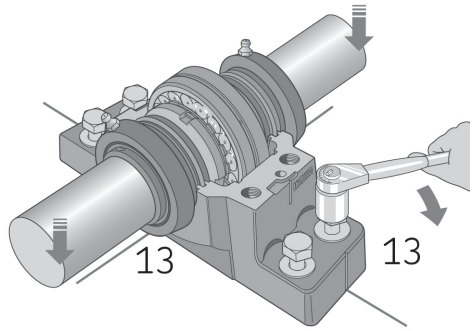
10. Mount the second bearing and housing, following steps 4 to 9.

11. Lay the shaft with the two bearings and seals in the two housing bases, taking care that the O-rings are not damaged.



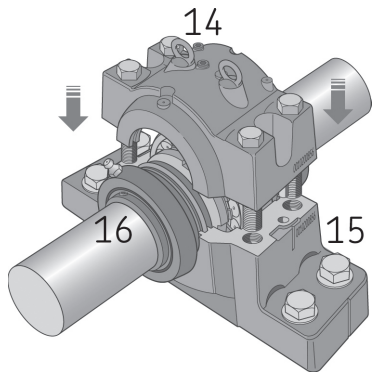
12. For locating bearing arrangements and arrangements with CARB toroidal roller bearings, put the appropriate number of locating rings on each side of the bearing (see product tables). Note that the product tables indicate the total number of locating rings needed. For sizes 3076, SNL 3168 and SNL 3264, the housings have an F or L design and locating rings are not needed.

13. Carefully align the two housing bases. Vertical markings at the middle of the side faces and ends of the housing bases can facilitate this. Then, lightly tighten the attachment bolts on both housings.



14. Place the two housing caps over each base, taking care that the O-rings are not damaged, then tighten the cap bolts (to join cap and base) to the torque specified in **table 1**. The cap and base of one housing are not interchangeable with those of other housings. The cap and base of each housing should be checked to make sure that they bear the same serial number.

15. Check the alignment of the two housings to minimize misalignment, and fully tighten the attachment bolts in the two housing bases. Recommended tightening torques are provided in **table 1**.



16. Adjust the flingers to the correct position and tighten the grub screws. The clearance in the seal must exceed the axial movement of the bearing.

17. Finally, before the first test run, rotate the shaft and supply grease via the fitting until it exudes from the labyrinth rings. The same grease as that used for the bearing should also be used to lubricate the labyrinth rings.

18. One day after tightening the cap and attachment bolts, check to make sure that the appropriate torque was maintained.

