Important general data:

Shaft	Direct mounting	Depends on the application
	Sleeve mounting	Preferably g7/IT5 but h9/IT5 possible
Supporting	Flatness	IT7 - IT8
	Surface roughness	$R_a \leq 12{,}5$ µm
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**		**Attachment bolts 8.8 Tightening torque**	
		Nm		Nm
SNL 211, 511-609	M 12×60	80	M 16	200
SNL 212, 512-610	M 12×60	80	M 16	200
SNL 213, 513-611	M 12×65	80	M 16	200
SNL 215, 515-612	M 12×65	80	M 16	200
SNL 216, 516-613	M 12×70	80	M 20	385
SNL 217, 517	M 12×80	80	M 20	385
SNL 218, 518-615	M 16×90	150	M 20	385
SNL 519-616	M 16×90	150	M 20	385
SNL 520-617	M 20×100	200	M 24	665
SNL 522-619	M 20×100	200	M 24	665
SNL 524-620	M 20×110	200	M 24	665
SNL 526	M 24×130	350	M 24	665
SNL 528	M 24×130	350	M 30	1 310
SNL 530	M 24×130	350	M 30	1 310
SNL 532	M 24×130	350	M 30	1 310

Table 2 Recommended oil levels for SNL ..TURU plummer blocks of series 5

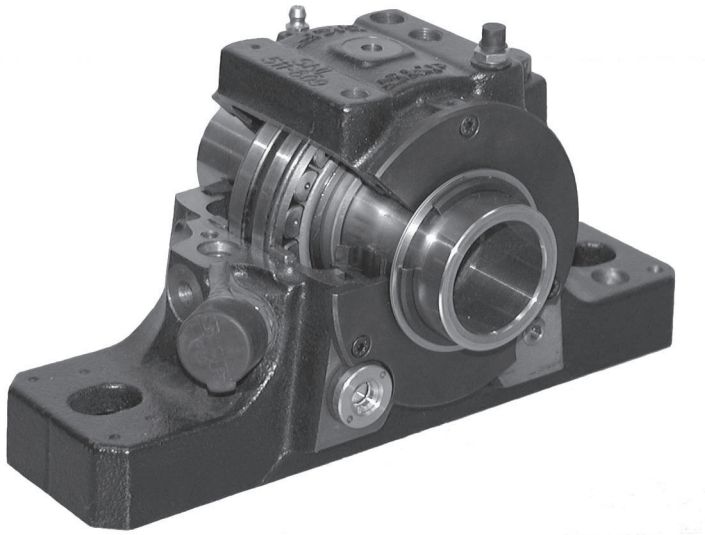
For housings in the 3 and 6 series, consult SKF.

Housing	**Oil level for bearing series**									
Designation	**12**		**22**		**232**		**222**		**C 22**	
	min	max	min	max	min	max	min	max	min	max
SNL 511 TURU	27	31	27	32			27	31	28	32
SNL 512 TURU	23	27	22	28			23	27	23	26
SNL 513 TURU	29	33	28	34			28	33	29	34
SNL 515 TURU	24	29	23	29			23	28	24	29
SNL 516 TURU	34	39	33	40			33	39	34	39
SNL 517 TURU	30	36	30	36			29	35	30	36
SNL 518 TURU	31	38	31	38	33	37	30	37	30	36
SNL 519 TURU	38	45	38	46			38	45		
SNL 520 TURU	34	42	34	42	37	42	33	41	35	43
SNL 522 TURU	39	47	38	48	42	47	37	46	39	48
SNL 524 TURU	47	57			50	55	46	55		
SNL 546 TURU					54	59	50	59	52	62
SNL 528 TURU					46	52	44	52	40	51
SNL 530 TURU					48	54	45	54	44	57
SNL 532 TURU					50	57	47	57		

The oil level is measured from the base of the housing. Mark the min and max level on the sight glass.

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Mounting instruction for oil lubricated SNL housings



SKF®

Mounting SNL housings with oil seals

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

1. Be sure that the work area is clean. Check the dimensional and form accuracy of the shaft seat. The shaft should be machined to a g7/IT5 tolerance for adapter sleeve mounting, and performed with a lead-in chamfer of about 3 mm × 15°.

2. Check that the 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 the mounting surface is painted, the paint has to be removed. If shims are used, the whole surface must be covered by the shims. The mounting surface (frame) must be designed to accommodate actual load, 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.

5. Make sure the attachment surface of the housing is cleaned from paint and contamination. Positioning the housing base on the support surface. Fit the attachment bolts, but do not tighten them.

6. Assemble the seals. Check if the O-ring and hollow O-ring cord of synthetic rubber are at the right positions in their respective grooves (**fig 1**). The dimensions of the hollow O-ring cord of synthetic rubber are 1×3 mm.

7. Coat the shaft lightly with a thin oil. Slide the first seal to its right position, some millimetres outside its working position.

8. Mount the bearing on the shaft – either directly on a stepped shaft or using an adapter sleeve.

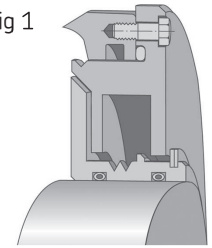
9. Slide the second seal to the right position on the shaft, as described in point 7 (If a stepped shaft is used, first mount the distance ring). If the housing is to be used at the end of a shaft, the second seal is omitted and the inner part of the end cover is inserted in the housing base seal groove.

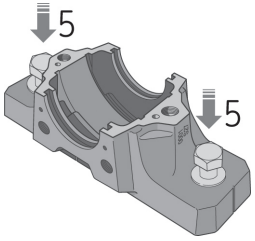
10. Mount the second bearing and housing, following steps 4 to 9.

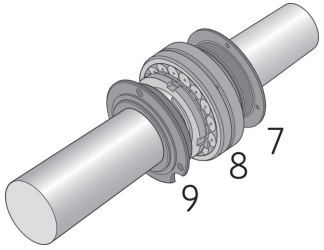
11. Lay the shaft with the two bearings and seal assemblies in the two housing bases.

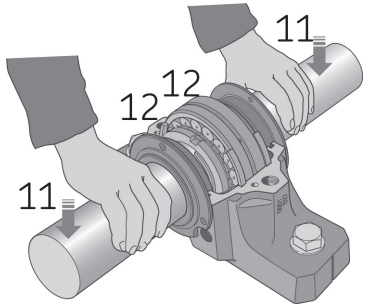
12. For locating bearing arrangements and arrangements with CARB toroidal roller bearings, put in one locating ring at each side of the bearing.

fig 1









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. Apply a string of oil-resistant sealant, of type Blue Silicone or equal, along the outer contour-line and around the holes, on the housing split surfaces. Then place the two housing caps over each base and 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 see 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. Slide the seals against the housing side surfaces. Mount the seal mounting screws and tighten them. If an end cover has been mounted fully tighten the screw on the external part of the end cover.

17. Mount the supplied ventilating plugs on the top of the housings and, when oil bath lubrication is used, mount the oil level sight glasses. When circulating oil lubrication is used, connect the oil inlet and outlet pipes to the housing.

Note: It is important that sealant, of type Loctite or equal, is applied on all threads on the supplied accessories.

18. When an oil bath lubrication is used, the maximum and minimum levels should be indicated on the sight glass. Recommended oil levels to be used for the mounted bearings can be found in **table 2**. The oil levels must be read while the application is not operating.

Important: For oil bath lubrication, it is important not to overfill the maximum level as this can cause oil leakage from the housing. For circulating oil, it is important that the outlet pipes can drain the housing in a proper way to avoid overfill of oil inside the housings.

19. Protect the housing assemblies from negative pressure from surrounding equipment.

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

