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
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 205, 505	M 10×40	50	M 12	80
SNL 206-305, 506-605	M 10×40	50	M 12	80
SNL 207, 507-606	M 10×50	50	M 12	80
SNL 208-307, 508-607	M 10×50	50	M 12	80
SNL 209, 509	M 10×50	50	M 12	80
SNL 210, 510-608	M 10×55	50	M 12	80
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

Please note: Cap bolt torques are general guidelines based on manufacturing requirements and normal mounting practice where external loads act into the pillow block base. For external stationary and/or rotating upward load situations, Consult SKF.

Table 2

Housing Size	**Grease quantities** First fill 40 %	20 %
-	g	g
SNL 205	25	15
SNL 206-305	40	25
SNL 207	50	30
SNL 208-307	60	35
SNL 209	65	40
SNL 210	75	45
SNL 211	100	60
SNL 212	150	90
SNL 213	180	110
SNL 215	230	140
SNL 216	280	170
SNL 217	330	200
SNL 218	430	260

Housing Size	**Grease quantities** First fill 40 %	20 %
-	g	g
SNL 505	25	15
SNL 506-605	40	25
SNL 507-606	50	30
SNL 508-607	60	35
SNL 509	65	40
SNL 510-608	75	45
SNL 511-609	100	60
SNL 512-610	150	90
SNL 513-611	180	110
SNL 515-612	230	140
SNL 516-613	280	170
SNL 517	330	200
SNL 518-615	430	260
SNL 519-616	480	300
SNL 520-617	630	390
SNL 522-619	850	530
SNL 524-620	1 000	630
SNL 526	1 100	700
SNL 528	1 400	900
SNL 530	1 700	1 100
SNL 532	2 000	1 300

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Mounting instruction for SNL housings with taconite seals





SKF

Mounting SNL housings with taconite seals

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

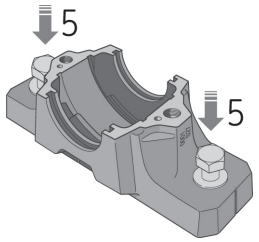
1. Be sure that the work area is clean. Check the dimensional and form accuracy of the shaft seat. The shaft should be machined to a h9/IT5 tolerance for adapter sleeve mounting.

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 accommodate actual load, vibrations and settings.

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

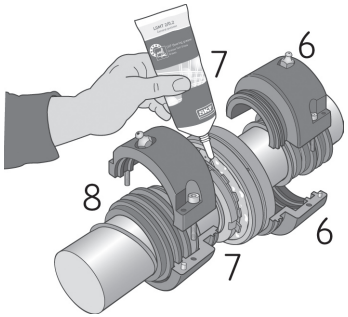
4. If the bearing is mounted on an adapter sleeve, determine its position relative to the housing. For spherical roller bearings with a lubrication groove and three holes in the outer ring, SKF recommends using the relubrication hole in the centre of the housing. When relubrication from the side of the bearing is required such as for CARB toroidal roller bearings or self-aligning ball bearings, the housing must be positioned so that the grease fitting is on the opposite side of the lock 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 on the support surface. Fit the attachment bolts, but do not tighten them.



6. Mount the first V-ring together with one labyrinth seal on the shaft in the correct position. The lip of the V-ring should point towards the bearing. Place the split ring over the V-ring and labyrinth ring and screw together. The two parts of this split ring are not interchangeable. They should be checked to see that they carry the same serial number.

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 should be put in the housing base at the sides see **table 2**.



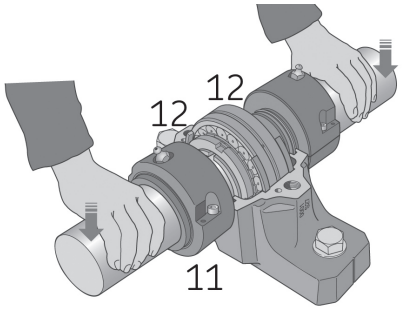
8. Mount the second seal according to point 6 (If a stepped shaft is used, first mount the distance ring). If the housing is to be used at the end of a shaft, the second seal is omitted and an end cover inserted in the housing base instead.

9. Use the hollow O-section cord to fix the labyrinth ring in position on the shaft. A screwdriver can be used to fit the cords whilst rotating the shaft. Mount the O-ring on the seal outer diameter.

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

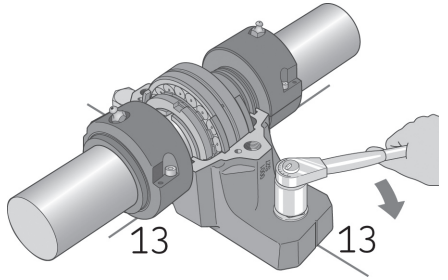
11. Lay the shaft with the two bearings and seals in the two housing bases taking care that the O-rings are not damaged.

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



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 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. 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 bearings should also be used to lubricate the labyrinth rings.

