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
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		Attachment bolts 8.8 Tightening torque	
		Nm		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 30×180	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 oil levels for SNL .. TURT and SNL .. TURA plummer blocks housings of series 30, 31 and 32

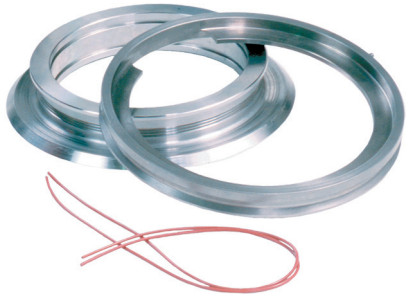
Housing	TURT Oil level for bearing series		TURA		Housing	TURT Oil level for bearing series		TURA		Housing	TURT Oil level for bearing series	
Designation	230		C30		Designation	231		C31		Designation	232	
-	min	max	min	max		min	max	min	max		min	max
SNL 3036	48	54	47	55	SNL 3134	50	57	48	58	SNL 3234	61	69
SNL 3038	52	59	49	57	SNL 3136	52	59	50	61	SNL 3236	56	64
SNL 3040	53	62	50	60	SNL 3138	54	62	48	61	SNL 3238	68	77
SNL 3044	59	69	57	68	SNL 3140	65	74	60	73	SNL 3240	70	79
SNL 3048	59	69	58	69	SNL 3144	62	71	56	70	SNL 3244	72	83
SNL 3052	62	74	59	72	SNL 3148	68	79	64	81	SNL 3248	74	87
SNL 3056	72	84	68	81	SNL 3152	72	84	65	83	SNL 3252	97	111
SNL 3060	75	89	74	88	SNL 3156	82	94	74	92	SNL 3256	87	101
SNL 3064	85	99	82	96	SNL 3160	85	99	78	97	SNL 3260	91	106
SNL 3068	88	104	81	99	SNL 3164	89	104	84	108	SNL 3264	94	116
SNL 3072	81	94	74	92	SNL 3168	93	108	84	110	SNL 3268	98	118
SNL 3076	88	104	87	105	SNL 3172	90	108	84	110	SNL 3272	105	124
SNL 3080	81	98	76	97	SNL 3176	91	108	87	110	SNL 3276	131	151
SNL 3084	81	98	77	99	SNL 3180	99	116	88	111	SNL 3280	115	135
SNL 3088	87	106	89	110	SNL 3184	108	128	103	129	SNL 3284	117	139
SNL 3092	104	124	100	119	SNL 3188	106	128	105	133	SNL 3288	123	147
SNL 3096	96	114	92	111	SNL 3192	109	133	103	131			
SNL 30/500	94	114	94	113	SNL 3196	116	141	112	139			
SNL 30/530	108	131	110	134								

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

K-nummer: 624 version 6
SKF Mekan AB 2008

Mounting instruction for oil lubricated SNL 30, SNL 31 and SNL 32 housings





SKF

Mounting SNL housings with oil 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 g7/IT5, but h9/IT5 is possible for adapter sleeve mounting, and performed with a lead-in chamfer of about 3 mm × 15º.

2. Check that the surface roughness of the support surface $R_a \leq 12{,}5$ 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.

5. Make sure that the attachment surface of the housing is cleaned of paint and contaminants. When oil bath lubrication is used, mount the oil level gauge on each housing. Position the housing base on the support surface. Fit the attachment bolts, but do not tighten them.

6. Make sure that the silicone tubes are at their right position in the grooves (**fig 1**) The dimension of the silicon tubes are 1×3 mm.

7. Coat the shaft lightly with a thin oil. Slide the parts for the first seal to the correct position on the shaft.

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

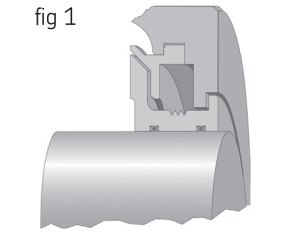
9. Slide the parts of the second seal to the correct position on the shaft. Keep the locating pin in the outer seal parts in a horizontal position. If the housing is to be used at the end of a shaft, the second seal is omitted and the inner part of the end cover inserted in the housing base seal groove.

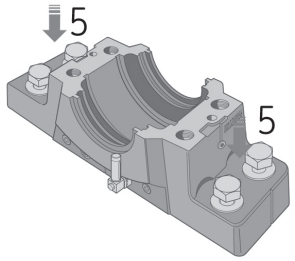
10. Mount the second bearing and housing, following steps 4 to 9.

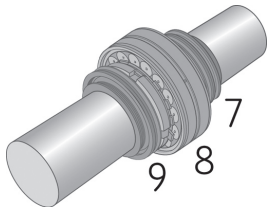
11. Lay the shaft with the two bearings and seal assemblies in the two housing bases.

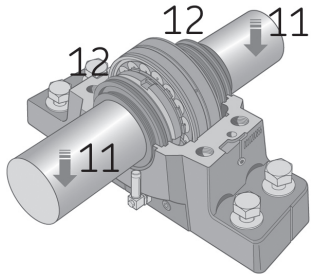
12. For locating bearing arrangements and arrangements with CARB toroidal roller bearings, put the appropriate number of locating rings on each side of the bearing (see product tables). Note that the product tables indicate the total number of locating rings needed. For sizes SNL 3076, SNL 3168 and SNL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

fig 1









13. Carefully align the two housing bases. Vertical markings at the middle of the side faces and ends of the housing base scan 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 make sure 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. Mount the supplied ventilating plugs on the top of the housings. 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 of the supplied accessories.

17. When an oil bath is used, the max and min level should be shown on the oil level gauge. 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.

NOTE: For oil bath lubrication, it is important not to exceed the max level as this can cause oil leakage from the housing. For circulating oil, it is important that the outlet pipes can properly drain the housing to avoid an overfill of oil.

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

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

