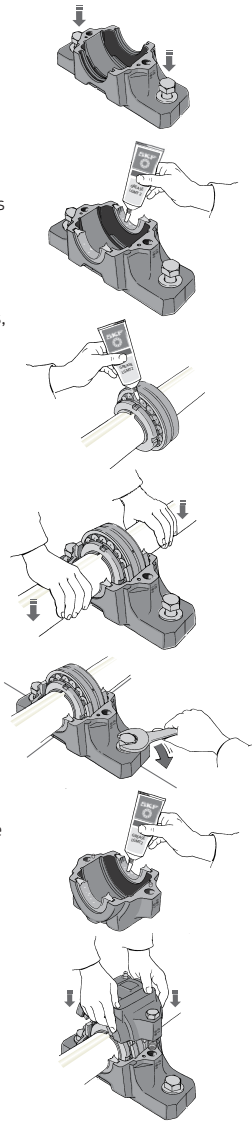
Mounting SNL housings with four-lip seals

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

1. Ensure that the environment is clean.
2. Check the dimensional and form accuracy of the shaft seating.
3. Check that the surface roughness of the support surface $R_a \leq 12{,}5$ µm. The flatness tolerance should be to IT7. For moderate demands IT8 may be satisfactory.
4. Position the housing on the support surface. Fit the attachment bolts but do not tighten them.

NB. For spherical roller bearings having a lubrication groove and three holes in the outer ring it is recommended to use the relubrication hole in the center of the housing. When relubrication from the side of the bearing is required e.g. for CARB or self-aligning ball bearings, the housing must be positioned with the grease nipple at the opposite side of the lock nut.

5. Insert one seal half in each of the grooves in the housing base. Fill the space between the two inner sealing lips with grease. If the housing is to be used at the end of a shaft, insert an end cover at one side instead of the seal half.
6. 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 (**table 1**).
7. Lay the shaft with bearing in the housing base.
8. For locating bearing arrangements and bearing arrangements with CARB bearings put one locating ring on each side of the bearing.
9. Carefully align the housing base. Vertical markings at the middle of the side faces and ends of the housing base can facilitate this. Then, lightly tighten the attachment bolts.
10. The remaining seal halves should be inserted in the seal grooves in the housing cap and the space between the inner sealing lips filled with grease.
11. The housing cap should be placed over the base and the cap bolts (to join cap and base) tightened to the torque specified in **table 2**. The cap and base of one housing are not interchangeable with those of another housing. The cap and base should be checked to see that they bear the same identification.
12. Fully tighten the attachment bolts in the housing base. Recommended tightening torques are given in **table 3**.



Important general data:

Shaft	Direct mounting	Depends on application
	Sleeve mounting	h9/IT5 – h10/IT7
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 notice:** The colour is resistant to low-alkaline detergents. Please follow the recommendations from the detergent supplier.	

Additional reference for bearing mounting

SKF Bearing Maintenance Handbook (publication 4100 EN), SKF General Catalogue (publication 6000 EN) or www.skf.com/mount.

Housing SNL	**Table 1 Grease Initial fill g**	**Table 2 Cap bolts 8.8 Tightening torque Nm**		**Table 3 Attachment bolts 8.8 Tightening torque Nm**	
505, 205	25	M10×40	50	M12	80
506-605, 206-305	40	M10×40	50	M12	80
507-606, 207	50	M10×50	50	M12	80
508-607, 208-307	60	M10×50	50	M12	80
509, 209	65	M10×50	50	M12	80
510-608, 208-307	75	M10×55	50	M12	80
511-609, 211	100	M12×60	80	M16	200
512-610, 212	150	M12×60	80	M16	200
513-611, 213	180	M12×65	80	M16	200
515-612, 215	230	M12×65	80	M16	200
516-613, 216	280	M12×70	80	M20	385
517, 217	330	M12×80	80	M20	385
518-615, 218	430	M16×19	150	M20	385
519-616	480	M16×19	150	M20	385
520-617	630	M20×100	200	M24	665
522-619	850	M20×100	200	M24	665
524-620	1 000	M20×110	200	M24	665
526	1 100	M24×130	350	M24	665
528	1 400	M24×130	350	M30	1 310
530	1 700	M24×130	350	M30	1 310
532	2 000	M24×130	350	M30	1 310

