Important general data:

Shaft	Direct mounting	Depends on the application
	Sleeve mounting	h9/IT5 - h10/IT7
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
SNLN 3024	M 20×100	200	M 24	665
SNLN 3026	M 20×100	200	M 24	665
SNLN 3028	M 20×110	200	M 24	665
SNLN 3030	M 24×130	350	M 24	665
SNLN 3032	M 24×130	350	M 24	665

Table 2 Recommended grease levels for SNLN plummer blocks housings.

Housing **Designation**	**Grease quantities** **First fill**[1] **40 %**	**20 %**
-	kg	
SNLN 3024	0,47	0,25
SNLN 3026	0,67	0,36
SNLN 3028	0,71	0,38
SNLN 3030	0,89	0,48
SNLN 3032	0,97	0,53

[1] Including bearing initial fill

Mounting instruction for SNLN housings with double-lip seals



K-number: 675 version 2
SKF Mekan AB 2008

Mounting SNLN housings with double-lip 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 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 load, vibrations and settings.

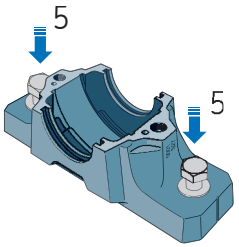
3. Mount any components that are on the shaft between the two SNLN housings.

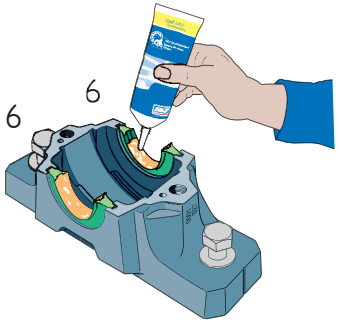
4. If the bearing is mounted on an adapter sleeve, determine its position relative to the housing. For spherical roller bearings with a lubrication groove and three holes in the outer ring, SKF recommends using the relubrication hole in the centre of the housing. When relubrication from the side of the 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.

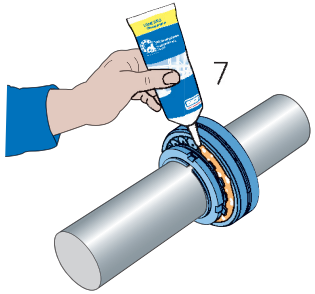
5. Position the housing on the support surface. Fit the attachment bolts, but do not tighten them.

6. Insert one seal half in each of the grooves in the housing base (If a stepped shaft is used, first mount the distance ring). Fill the space between the two sealing lips with grease. If the housing is to be used at the end of a shaft, insert an end cover instead of the seal half.

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 (**table 2**).







8. Mount the second bearing and housing, following steps 4 to 7.

9. Lay the shaft with the two bearings in the two housing bases.

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

11. 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.

12. The remaining seal halves should be inserted in the seal grooves in the two housing caps and the space between the sealing lips filled with grease.

13. 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.

14. 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**.

