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 < 12,5 µm
Painting system	Alkyd RAL 9005 Pigment black	
	Thickness	80µm
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 E) or SKF General Catalogue (publication 5000 E).

Table 1 **Housing**	**Cap bolts 8.8** **Tightening torque**	**Nm**	**Attachment bolts 8.8** **Tightening torque**	**Nm**
SNL 211, 511-609	M 12x60	80	M 16	200
SNL 212, 512-610	M 12x60	80	M 16	200
SNL 213, 513-611	M 12x65	80	M 16	200
SNL 215, 515-612	M 12x65	80	M 16	200
SNL 216, 516-613	M 12x70	80	M 20	385
SNL 217, 517	M 12x80	80	M 20	385
SNL 218, 518-615	M 16x90	150	M 20	385
SNL 519-616	M 16x90	150	M 20	385
SNL 520-617	M 20x100	200	M 24	665
SNL 522-619	M 20x100	200	M 24	665
SNL 524-620	M 20x110	200	M 24	665
SNL 526	M 24x130	350	M 24	665
SNL 528	M 24x130	350	M 30	1 310
SNL 530	M 24x130	350	M 30	1 310
SNL 532	M 24x130	350	M 30	1 310

Table 2 Recommended oil levels for SNL ..TURU plummer blocks of series 5. For series 3 & 6 please contact 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.

K-nummer: 616 version 2
SKF Mekan AB 2004

SKF

Mounting instruction for oil lubricated SNL housings



Mounting SNL housings with oil seals.

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

1. Ensure that the surface roughness of the support surface $R_a \leqq 12.5$ μm. The flatness (planicity) tolerance should be to IT7.
Check 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 in a proper way considering actual load, vibrations and settings.

2. Ensure that the environment is clean. Check the dimensional and form accuracy of the shaft seating. The shaft is preferably machined to tolerance g7, and performed with a lead-in chamfer of about 3mm x 15º.

3. If the bearing is mounted on an adapter sleeve, determine the position of the housing.

4. 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.

5. Assemble the seals. Check if the O-ring and silicon tubes are at their right positions in respective groove (**fig 1**) The dimension of the silicon tubes are 1x3 mm.

6. Cover the shaft with a thin layer of oil. Slide the first seal to its right mounting position, some millimetres outside its working position.

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

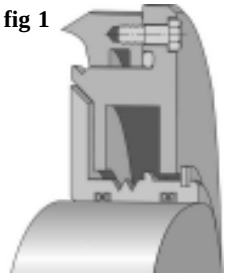
8. Slide the second seal to the right position on the shaft, as described in point 6. If the housing is to be used at a shaft end, the second seal is omitted and the inner part of the end cover is inserted in the housing base seal groove.

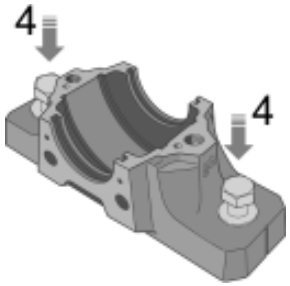
9. Lay the shaft with bearing and seal assemblies in the housing base.

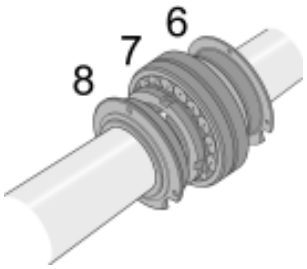
10. When locating bearing arrangements always one locating ring shall be placed at each side of the bearing. When non-locating bearing arrangements no locating rings are placed in the housing.

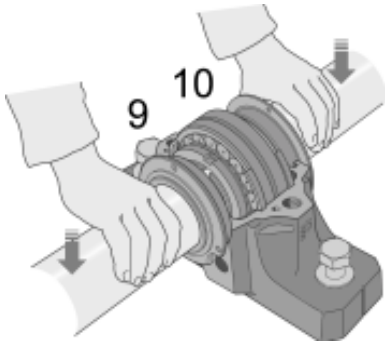
NB. CARB bearings as always are mounted with locating rings, although these are always non-locating.

fig 1

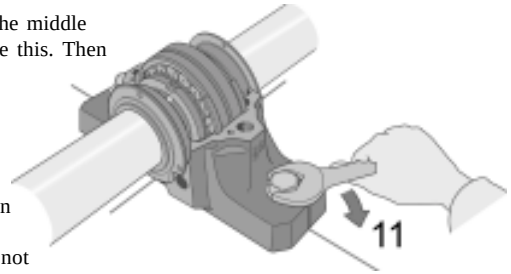






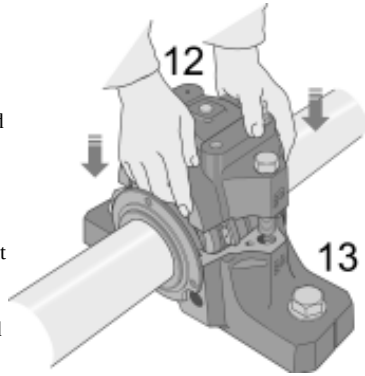


11. Carefully align the housing base. Vertical markings at the middle of the side faces and ends of the housing base can facilitate this. Then lightly tighten the attachment bolts.



12. Apply a string of oil-resistant sealant, of type Blue Silicon or equal, along the outer contour-line and around the holes on the housing split surfaces. Then place the housing cap over the base and tighten the cap bolts (to join cap and base), with help of a torque wrench, to the torque specified in **table 1**. 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.

13. Check the alignment, to minimise misalignment and fully tighten the attachment bolts in the housing base with help of a torque wrench. Recommended tightening torques are given in **table 1**.

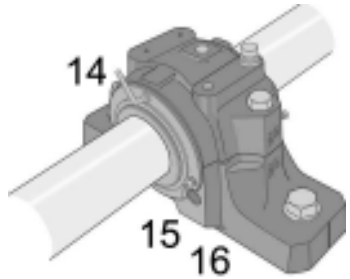


14. Slide the seals against the housing side surfaces. Mount the seal-mounting screws and tighten them. If an end cover has been mounted fully tighten the screw on the external part of the end cover.

15. Mount the supplied ventilating plug on the top of the housing and when oil bath shall be used, mount the oil level sight glass. When circulating oil lubrication shall be used connect the oil inlet and outlet pipes to the housing.

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

16. When oil bath is used, the max and min level should be indicated on the sight glass. Recommended oil level to be used for the mounted bearing can be found in **table 2**.
The oil level must be read off in application standstill.



NB. For oil bath it is important not to overfill the max level as this can cause oil leakage from the housing. For circulating oil it is important that the outlet pipe/pipes can drain the housing in a proper way to avoid overfill of oil inside the housing.

17. Protect the housing assembly from negative pressure from surrounding equipment.

18. After one day the tightening torque of the cap bolts and the attachment bolts shall be checked.