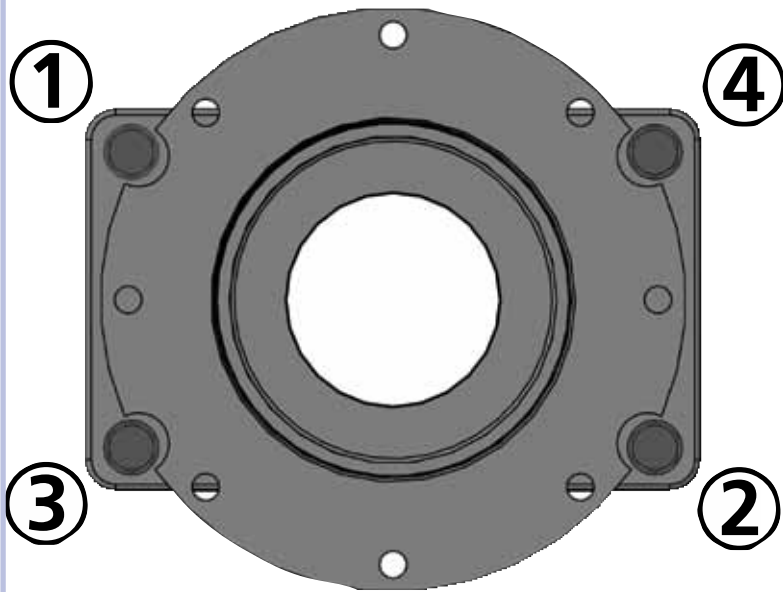


## 2 Assembly of bearing houses

# 6



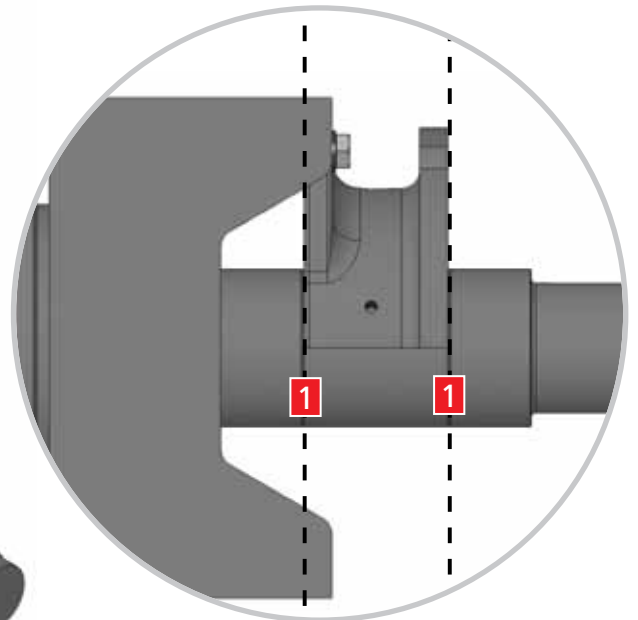
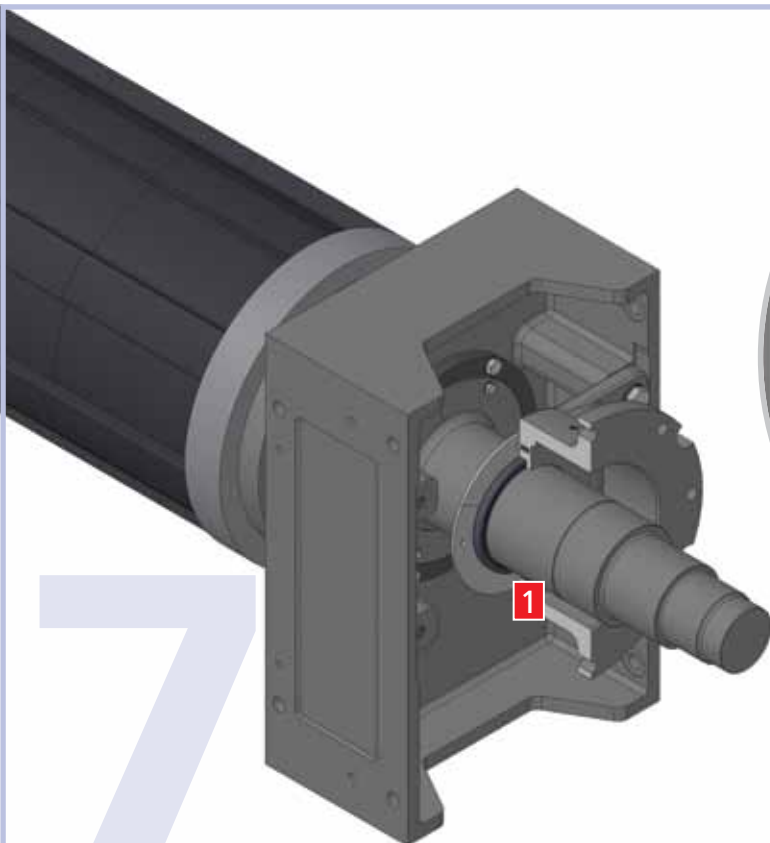
Tighten bearing house to frame module. Cross-tighten bolt 1 to 4 in 3 stages:  
Stage 1: 50%  
Stage 2: 75%  
Stage 3: 100%



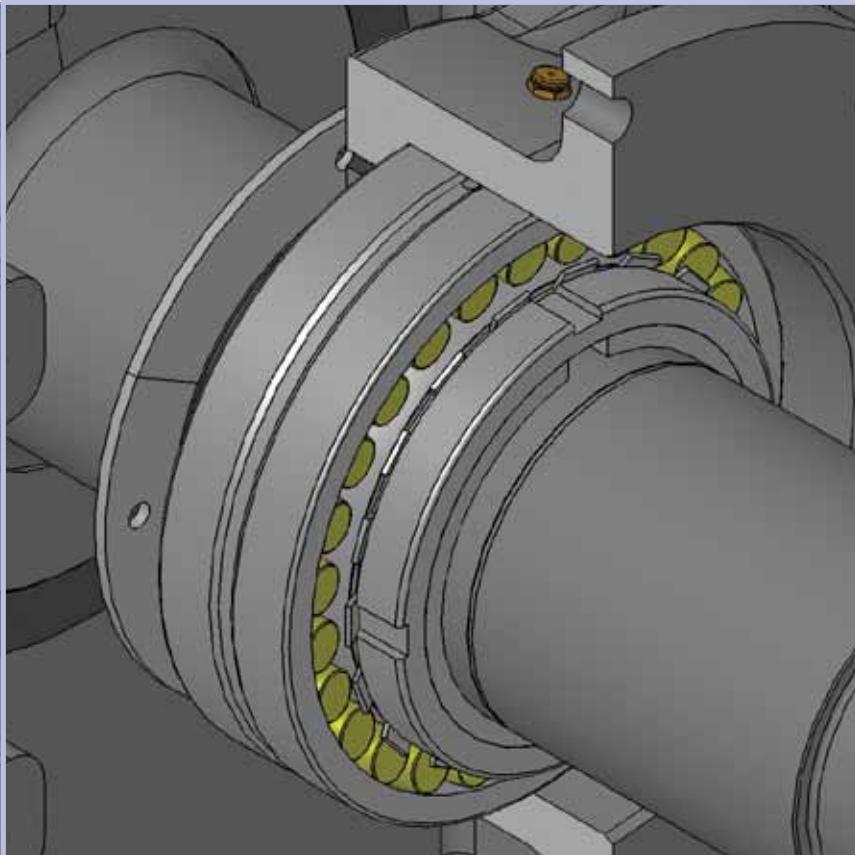
**M12: Torque to 70 Nm**

**Erection  
Check!**

**Erection  
Check 3**



Mount the bearing house so it is flush with the grooves **1** on the drive journal.



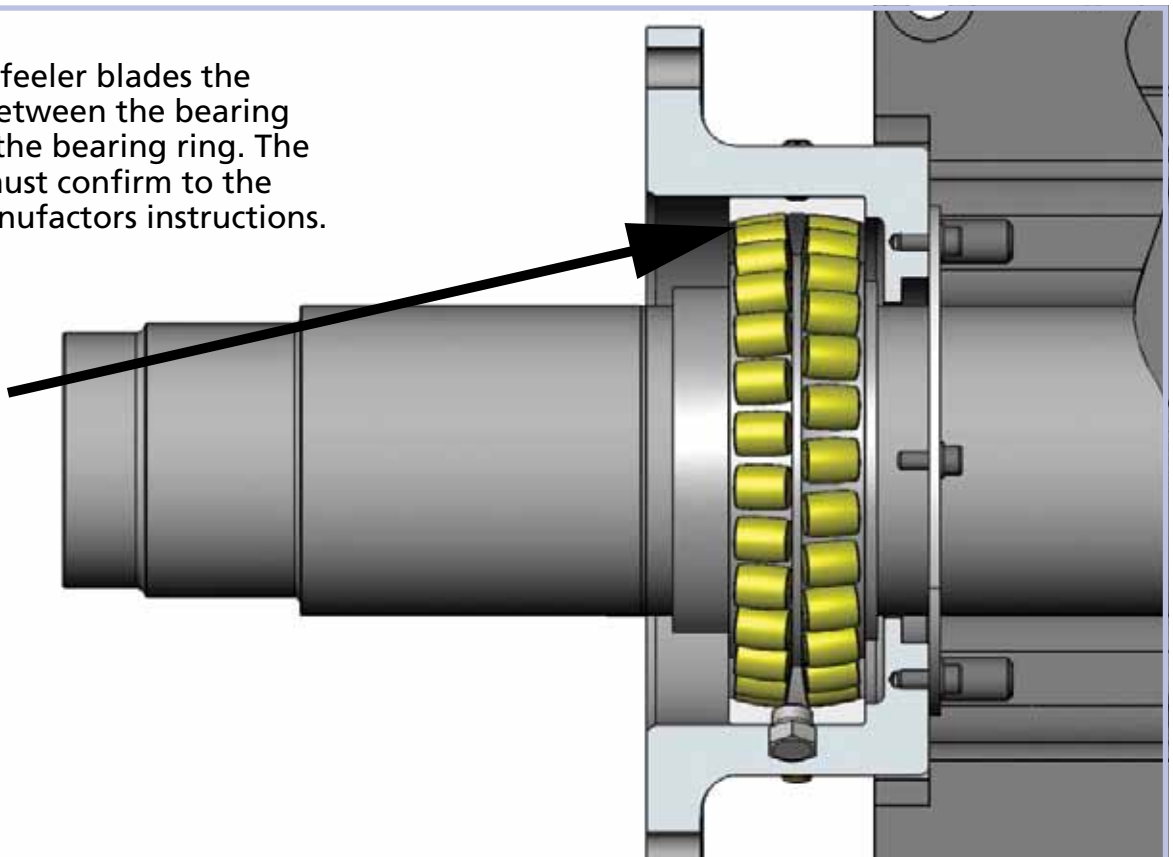
# 8

Push bearing as far back as possible in bearing house so it sits behind groove in drive journal.

**Reference** 

Bearing manufacturers instruction on mounting bearings on adapter sleeve, mechanical mounting.

Check with feeler blades the tolerance between the bearing rollers and the bearing ring. The tolerance must confirm to the bearing manfactors instructions.



# 9

