

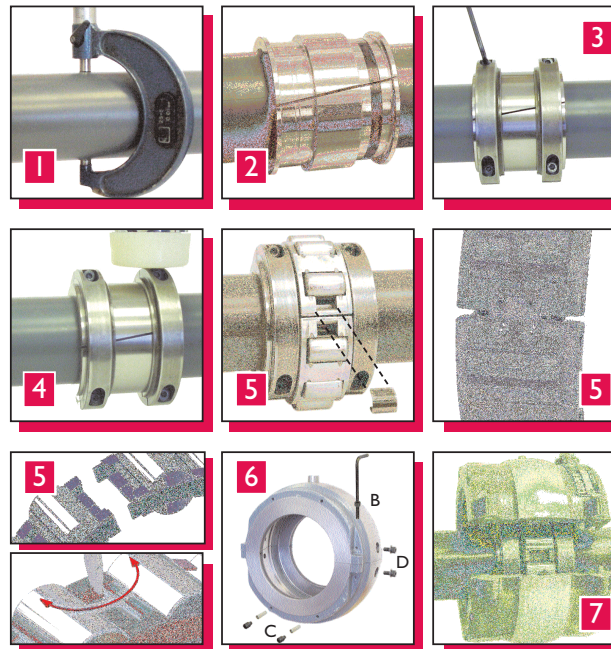
# Easy Assembly in 7 Easy Steps

## ASSEMBLING A COOPER SPLIT ROLLER BEARING

### Overview of Assembly Procedure

Comprehensive assembly procedures are shown in our Product Catalogue and on the instructions included with all new bearings. Full assembly information is also available from our website at [www.CooperBearings.com](http://www.CooperBearings.com)

- 1** Clean the shaft and check the diameter, roundness and parallelism.
- 2** Position the matched halves of the inner race on the shaft and ensure there is a gap at the inner race joints.
- 3** Fit the clamping rings, making sure the joints are at 90° to the inner race joints and tighten screws.
- 4** To ensure correct seating, tap down the clamping rings with a soft faced hammer and re-tighten screws. Repeat until the bearing parts are fully seated. Ensure there is a gap of equal amount at each race joint.
- 5** Coat the roller cage and the inner race with grease and assemble the cage around the inner race. Insert 'U' clip where supplied, or snap the two halves together if plate or pressed steel type cages.
- 6** Fit the outer race into the appropriate cartridge halves, noting the lubrication hole is in the upper half outer race. Fit radial screws (D) where appropriate and side screws (C) on GR (fixed) type cartridges.
- 7** Install the seals having followed the appropriate recommendations for the seal type as described in our full installation guide. Coat the outer race and seals with grease. Close the cartridge and tighten joint screws. Lubricate spherical seating as recommended.



### Basic Tools Required

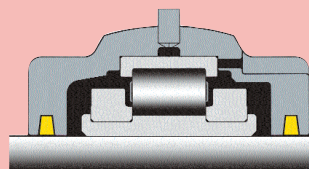
**Allen Keys** -  
For bearing and housing assembly.  
**Feeler Gauges** -  
To ensure correctly spaced joint gaps.  
**Flat Bladed Screwdriver** -  
For cage clip removal and cage separation.  
**Micrometer** - To measure the shaft.  
**Soft Faced Hammer** -  
To ensure correct seating of components.  
**Torque Wrench** -  
To ensure correct torque on screws.



### Bearing Types

#### Fixed (GR) Bearing

Bearings with grooved inner race assemblies and grooved outer races for radial and axial loads. To be fitted in GR cartridges with side screws.

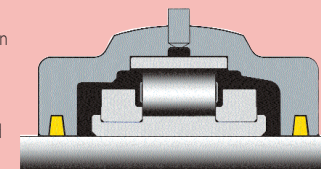


#### Expansion (EX) Bearing

Bearings with grooved inner race assemblies and plain outer races for radial loads. To be fitted in EX cartridges without side screws.

#### Special Expansion (EXILOG) Bearing

Bearing with plain inner race assemblies and grooved outer races, must be fitted into GR cartridges with side screws.



For more information, visit [www.CooperBearings.com](http://www.CooperBearings.com) or contact your nearest Authorised Cooper Distributor



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