

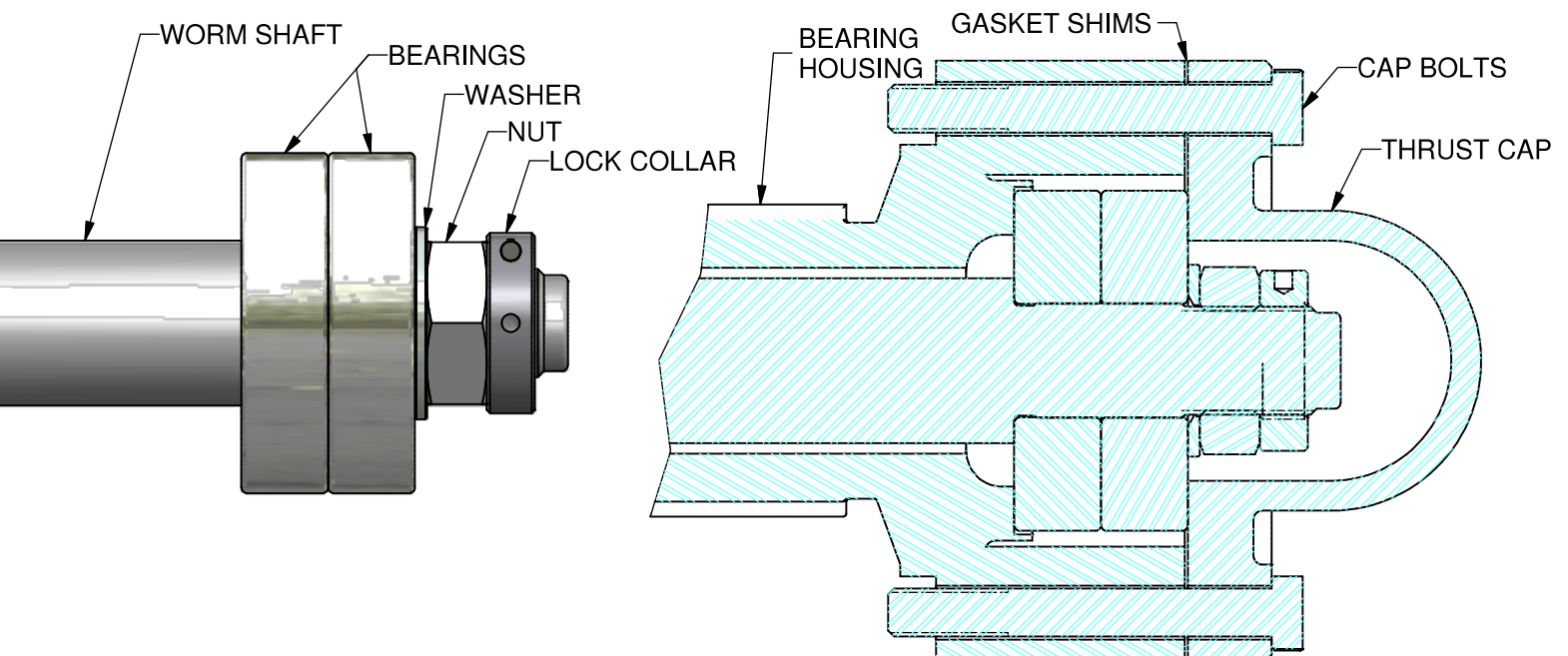


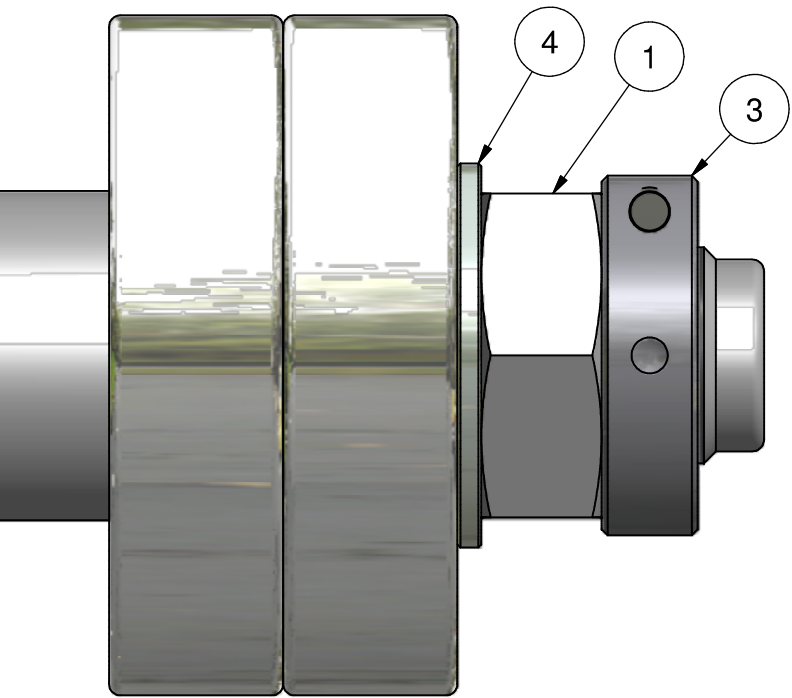
HOLLISTER-WHITNEY ELEVATOR CORPORATION INSTALLATION PROCEDURE FOR #7400 SERIES THRUST BEARINGS

- 1.) Drain and thoroughly clean gear housing, thrust bearing housing, and thrust cap. The face of the shoulder on worm shaft must project beyond bearing face on bearing housing.
- 2.) Place the STAMPED faces of outer races of thrust bearings together and assemble on worm shaft as shown.
- 3.) Install washer on worm shaft. Make sure the bore chamfer on washer is toward bearings. Torque nut according to the CONDITIONING TORQUE on chart below to condition the worm threads. Back nut off and remove.
- 4.) Clean threads of nut and worm thoroughly with a non-oil based cleaner and let dry completely.
- 5.) Apply provided Thread Locking Adhesive (Loctite #2440 or Permatex Threadlocker Blue PX#24325) to worm threads where nut will be located.
- 6.) Re-install nut and re-torque to the FINAL TORQUE value specified in the chart below.
- 7.) Install new lock collar provided. Snug down collar against nut by tapping spanner wrench handle lightly with a brass hammer. Tighten clamping screw on collar to value specified in chart below.
- 8.) Install just enough shims between thrust cap and housing to eliminate ALL axial end play in worm shaft. Remove one shim and torque thrust cap bolts solid per chart (0.001" to 0.007" preload on outer races is recommended).
- 9.) After unit is completely re-assembled, and before starting machine, fill gear housing to correct oil level with worm gear oil of approved specification (See Lubrication instructions Bulletin #1150).
- 10.) Before restoring car to service, slightly back off all thrust bearing cap bolts temporarily, and run EMPTY car for several trips. Re-tighten cap bolts to specified torque value and place car into regular service.

THRUST NUT KIT PART LISTING

Machine	Thrust Bearin	CONDITIONING Torqu	Thrust Cap Bolts	FINAL Torque	Collar Clamping Screw
34	#7405	250 ft-lbs	23 ft-lbs	75 ft-lbs	14 ft-lbs (170 in-lbs)
43/44	#7406	350 ft-lbs	55 ft-lbs	95 ft-lbs	14 ft-lbs (170 in-lbs)
53/54	#7407	350 ft-lbs	55 ft-lbs	125 ft-lbs	14 ft-lbs (170 in-lbs)
63/64	#7409	350 ft-lbs	110 ft-lbs	200 ft-lbs	14 ft-lbs (170 in-lbs)
74	#7413	550 ft-lbs	200 ft-lbs	375 ft-lbs	27 ft-lbs (325 in-lbs)





NOTICE: CUSTOMERS WORKING ON THE ATTACHMENT OF THE THRUST BEARINGS; FOR MACHINES WITH JAM NUTS AND LOCK COLLARS (Generally Machines after October 2001 (A-#140000 & newer) THE PART NUMBERS LISTED BELOW SHOULD BE USED. (The thick thrust washer-castle nut-cotter pin combination is no longer being used. See E-127 for Instructions.)

EACH THRUST NUT KIT ALSO CONTAINS ONE (1) SMALL TUBE THREADLOCKER

SEE OTHER SIDE FOR ASSEMBLY INSTRUCTIONS.

THRUST NUT KIT PART LISTING

ITEM	QTY	DESCRIPTION	KIT #34-202 FOR 34 MACHINE CONTAINS	KIT #44-202 FOR 43/44 MACHINE CONTAINS	KIT #54-202 FOR 53/54 MACHINE CONTAINS	KIT #64-202 FOR 63/64 MACHINE CONTAINS	KIT #74-202 FOR 74 MACHINE CONTAINS
1	1	NUT	34-075	43-075	53-075	63-075	74-200
2	8	GASKET/SHIM	34-087	43-087	53-087	63-087	74-087
3	1	LOCK COLLAR	34-198	44-198	54-198	64-198	74-198
4	1	WASHER	34-199	44-199	54-199	64-199	74-199

					HOLLISTER-WHITNEY ELEVATOR CO.					
					TITLE PARTS LIST - THRUST NUT KIT, BEARING END					
			C	OIL SPECIFICATION UPDATE. PUR #518	LTL 9/10/12	DRAWN BY	SCALE	MATERIAL	DIMENSIONAL TOL. 1 PLACE ±0.1 2 PLACE ±0.01 3 PLACE ±0.001 ANGLES ±0.1° REF.=OPEN (NOMINAL) READING	
			B	ADD PERMATEX & 34 MACHINE. PUR #439	LTL 2/14/11	LTL				
			A	CLAMP SCREW TORQUE UPDATED PUR #231	LTL 9/4/03	SHEET SIZE A		DATE 6/19/03	E-126	