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(s) 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 Loctite #2440 or Permatex Threadlocker Blue PX #24325 to worm threads where nut will be located.

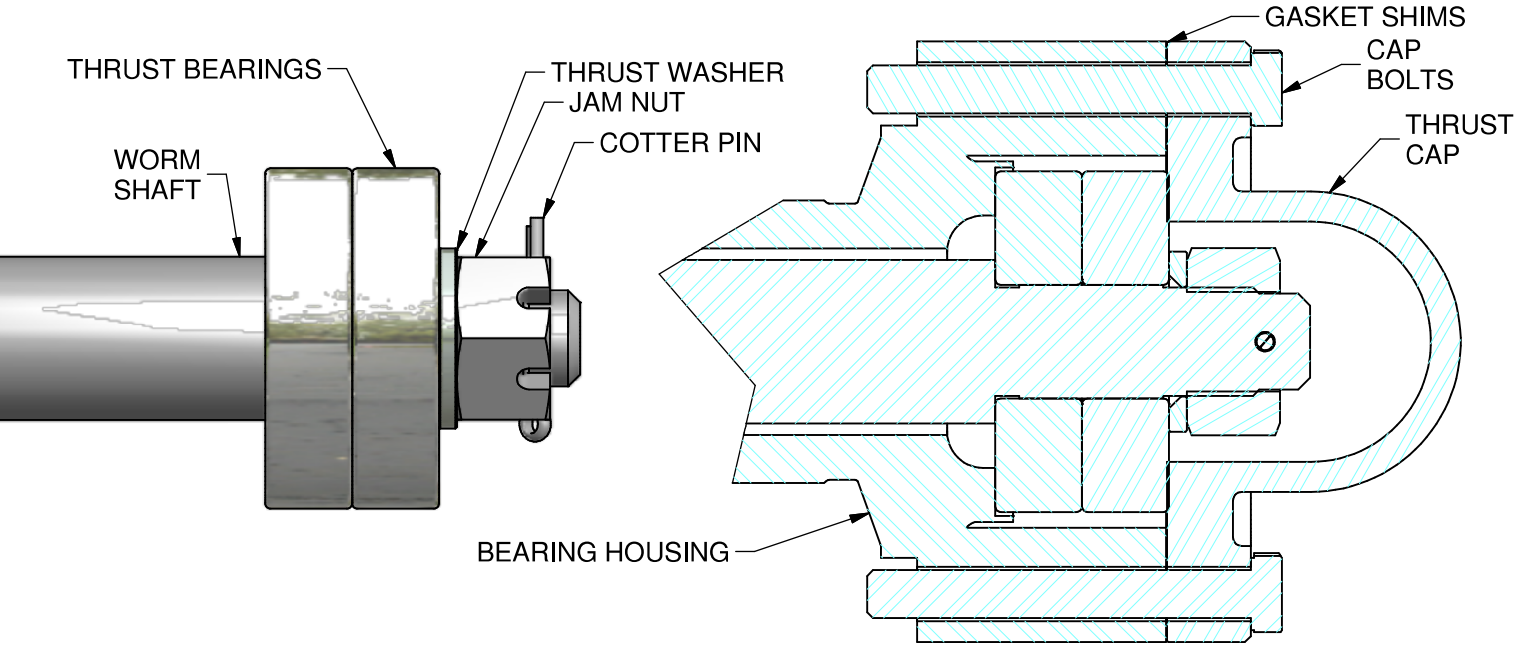
6.) Re-install nut and re-torque to the FINAL TORQUE value specified in the chart below. **NOTE**: If cotter pin hole does not line up with slots, tighten nut until hole is available - **DO NOT LOOSEN**.

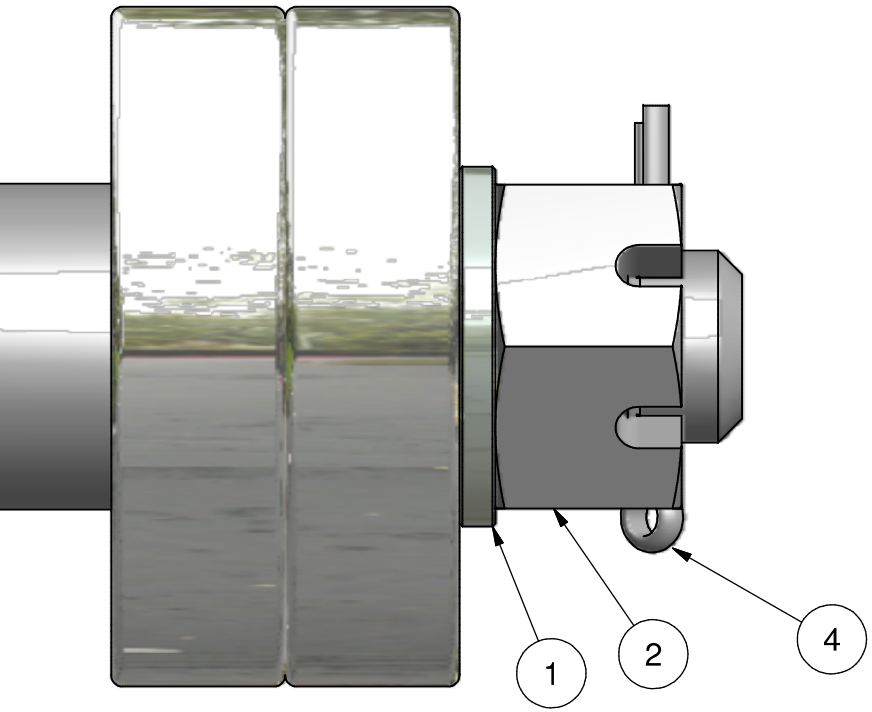
7.) Install just enough shims between thrust cap and housing to eliminate ALL axial end play in worm shaft. Remove one shim and torque thrust cap bolts solid per chart (0.001" to 0.007" preload on outer races is recommended).

8.) 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).

9.) 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.

TORQUE VALUES				
Machine	Thrust Bearing	CONDITIONING Torque	Thrust Cap Bolt	FINAL Torque
34	#7405	250 ft-lbs	23 ft-lbs	75 ft-lbs
43/44	#7406	350 ft-lbs	55 ft-lbs	95 ft-lbs
53/54	#7407	350 ft-lbs	55 ft-lbs	125 ft-lbs
63/64	#7409	350 ft-lbs	110 ft-lbs	200 ft-lbs
74	#7413	550 ft-lbs	200 ft-lbs	375 ft-lbs





NOTICE: CUSTOMERS WORKING ON THE ATTACHMENT OF THE THRUST BEARINGS;
1) FOR ALL MACHINES WITH CASTLEATED NUTS AND COTTER PINS (Generally Machines Prior to October 2001, A-#139999 & Older) USE THE PART NUMBERS LISTED BELOW. FOR JAM NUT & LOCK COLLAR ARRANGEMENT SEE DOCUMENT E-126
2) EACH THRUST NUT KIT ALSO CONTAINS ONE (1) SMALL TUBE OF THREAD LOCKER.

SEE OTHER SIDE FOR COMPLETE INSTRUCTIONS

TORQUE VALUES							
ITEM	QTY	DESCRIPTION	KIT #34-203	KIT #44-203	KIT #54-203	KIT #64-203	KIT #74-203
			FOR 34 MACHINE	FOR 43/44 MACHINE	FOR 53/54 MACHINE	FOR 63/64 MACHINE	FOR 74 MACHINE
			CONTAINS	CONTAINS	CONTAINS	CONTAINS	CONTAINS
1	2	WASHER	33-074	43-074	53-074	63-074	74-074
2	1	SLOTTED NUT	34-076	43-076	53-076	63-076	74-076
3	8	GASKET/SHIM	34-087	43-087	53-087	63-087	74-087
4	1	COTTER PIN	N/A	N/A	N/A	N/A	N/A

			B	OIL SPECIFICATION UPDATE, PUR #518	LTL 9/10/12
			A	ADD PERMATEX, PUR #439	LTL 2/14/11

HOLLISTER-WHITNEY
ELEVATOR CO.

TITLE: PARTS LIST - THRUST NUT KIT - BEARING END

DRAWN BY	SCALE	MATERIAL	DIMENSIONAL TOL.
LTL	NA	SEE PARTS LIST	1 PLACE ± 0.1 2 PLACE ± 0.01 3 PLACE ± 0.001 ANGLES ± 0.1° REF.=OPEN (NOMINAL) READING

SHEET SIZE	DATE	
A	6/19/03	E-127