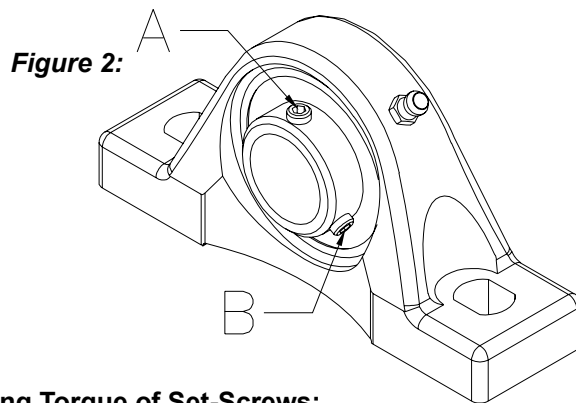
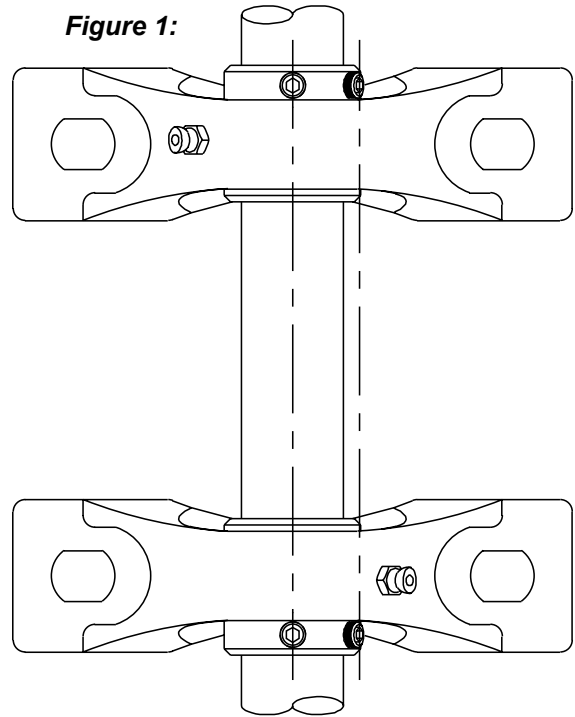


**BEARING MOUNTING**

**Set-Screw Locking:**

1. Inspect the Shaft
  - Measure the shaft to ensure it is within recommended tolerances per Table 3 on page 130:
  - Check for any nicks or burrs that might prevent the bearing from sliding on the shaft easily
  - Clean the mounting surface, then apply a film of light weight oil
  
2. Place the bearing on the shaft
  - Do not hammer the bearing onto the shaft
  
3. Bolt the housing to the mounting surface
  - **The bearing and shaft must be aligned within 2°**
  - Rotate the shaft to ensure it rotates smooth and freely
  - It is expected that plain washers will be used under mounting bolt heads to span the slot width
  
4. Align the setscrews of the bearings at both ends of the shaft
  - See Figure 1
  
5. Alternate Tightening of Setscrews
  - Tighten set screw “A” half of the recommended tightening torque (Figure 2)
  - Tighten set screw “B” all the way to the recommended tightening torque (Figure 2) per Table 5
  - Go back to set screw “A” and tighten it all the way to the recommended tightening torque with a variable torque wrench per Table 5



**Recommended Tightening Torque of Set-Screws:**

Table 5

Applicable Bearing #					Recommended Tightening Torque (in-lb)	
					zone hardened	through hardened inner ring (reference for stainless inserts)
—	—	—	—	B1-3	—	21
—	—	—	—	B4	22	—
MUC201-203	UC201-203	UC305-306	UCX05	—	—	34
MUC204-206	UC204-206	—	—	B5-6	43	—
MUC207-209	—	UC307	UCX06-X08	—	—	74
—	UC207-209	—	—	B7	104	—
MUC210	—	UC308-309	UCX09-X12	—	—	143
—	UC210-213	—	—	—	207	—
—	UC214-216	—	—	—	346	—
—	UC217-218	UC310-314	UCX13-X17	—	—	246
—	—	UC315-316	UCX18	—	—	246
—	—	UC317-319	UCX20	—	—	589
—	—	UC320-324	—	—	—	589
—	—	UC326-328	—	—	—	991

**Reference Through-Hardened Tightening Torque Specifications for Stainless Steel Inserts**