



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 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 14 ft-lbs (170 in-lbs). **NOTE EXCEPTION: For 74 Machine ONLY,** tighten clamping screw on collar to 27 ft-lbs (325 in-lbs).
- 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 (AGMA # 8 EP).
- 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.

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

