



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# 13999 and older), USE PART NUMBERS LISTED BELOW. FOR JAM NUT AND LOCK COLLAR ARRANGEMENT SEE E-126.
2) EACH THRUST NUT KIT ALSO CONTAINS ONE (1) SMALL TUBE OF #2440 LOCTITE (or Permatex Threadlocker Blue PX #24325).
3) SEE OTHER SIDE FOR INSTRUCTIONS

THRUST NUT KIT PART LISTING							
ITEM	QTY	DESCRIPTION	KIT #34-203 FOR 34 MACHINE	KIT #44-203 FOR 43/44 MACHINE	KIT #54-203 FOR 53/54 MACHINE	KIT #64-203 FOR 63/64 MACHINE	KIT #74-203 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

						HOLLISTER-WHITNEY ELEVATOR CO.	
						TITLE PARTS LIST - THRUST NUT KIT, BEARING END	
			DRAWN BY	SCALE	MATERIAL	DIMENSIONAL TOL.	
			LTL			1 PLACE ±0.1 2 PLACE ±0.01 3 PLACE ±0.001 ANGLES ±0.1° REF.=OPEN (NOMINAL) READING	
			A	ADD PERMATHEX, PUR #439	LTL 2/14/11	SHEET SIZE A	DATE 6/19/03
						E-127	



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 (AGMA # 8 EP).
- 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

