**NOTICE:** IF THE MACHINE BEING REPAIRED HAS A CASTLE NUT & COTTER PIN, SEE PAGE 2 OF 2 FOR INSTALLATION PROCEDURES.

H-W STOPPED USING CASTLE NUTS & COTTER PINS IN APPROXIMATELY OCTOBER 2001 (CONTRACT #A13999 & OLDER).

If the machine being repaired has a Jam Nut and Lock Collar, see Document E-126 for instructions.

### Parts List & Installation Instructions - #7400 Series Thrust Bearing w/Castle Nut

<table>
<thead>
<tr>
<th>ITEM</th>
<th>QTY</th>
<th>DESCRIPTION</th>
<th>KIT #34-203</th>
<th>KIT #44-203</th>
<th>KIT #54-203</th>
<th>KIT #64-203</th>
<th>KIT #74-203</th>
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<tbody>
<tr>
<td>1</td>
<td>1</td>
<td>THRUST BEARING SET</td>
<td>#7405</td>
<td>#7406</td>
<td>#7407</td>
<td>#7409</td>
<td>#7413</td>
</tr>
<tr>
<td>2</td>
<td>2</td>
<td>WASHER</td>
<td>33-074</td>
<td>43-074</td>
<td>53-074</td>
<td>63-074</td>
<td>74-074</td>
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<tr>
<td>3</td>
<td>1</td>
<td>SLOTTED NUT</td>
<td>34-076</td>
<td>43-076</td>
<td>53-076</td>
<td>63-076</td>
<td>74-076</td>
</tr>
<tr>
<td>4</td>
<td>8</td>
<td>GASKET/SHIM</td>
<td>34-087</td>
<td>43-087</td>
<td>53-087</td>
<td>63-087</td>
<td>74-087</td>
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<tr>
<td>5</td>
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<td>COTTER PIN</td>
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<tr>
<td>6</td>
<td>1</td>
<td>THREAD LOCKER</td>
<td>LOCTITE #243 or PERMATEX BLUE PX#24325 (Not Shown)</td>
<td></td>
<td></td>
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<td></td>
</tr>
</tbody>
</table>

**Detail A**

**Scale 2:1**

**Third Angle Projection**

**HOLLISTER-WHITNEY ELEVATOR CO. LLC**

**Title:** PARTS LIST & INSTALLATION INSTRUCTION - #7400 SERIES THRUST BEARING w/Castle Nut

**Drawing Information:**
- **DRAWN BY:** [Not Specified]
- **SCALE:** 1:1
- **MATERIAL:** SEE PARTS LIST
- **REFERENCE TOL.** ALL DIMENSIONS REFERENCE UNLESS OTHERWISE SPECIFIED
- **DATE:** 6/19/2003
- **SHEET SIZE:** A
- **SHEET:** 1 OF 2
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. Install and torque nut according to the CONDITIONING TORQUE on chart above 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 #243 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 above. **NOTE:** If cotter pin hole does not line up with slots, tighten nut until hole is available - **DO NOT LOOSEN NUT.**

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 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.