**Notice:** If the machine being repaired has a Jam Nut & Lock Collar, see page 2 of 2 for installation procedures.

Machines with Jam Nuts and Lock Collars have generally been used since October 2001 (Contract #A140000 & newer).

If the machine being repaired has a Castle Nut & Cotter Pin combination, see Document E-127 for instructions.

**Detail A**

**Scale 2:1**

**Washer Bevel Toward Bearings**

**Third Angle Projection**

**Hollister-Whitney Elevator Co. LLC**

**Parts List & Installation Instruction - #7400**

**Series Thrust Bearing w/ Lock Collar**

**Third Angle Projection**

**Parts List**

<table>
<thead>
<tr>
<th>Item</th>
<th>Qty</th>
<th>Description</th>
<th>Kit #34-202</th>
<th>Kit #44-202</th>
<th>Kit #54-202</th>
<th>Kit #64-202</th>
<th>Kit #74-202</th>
</tr>
</thead>
<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>1</td>
<td>Nut</td>
<td>34-075</td>
<td>43-075</td>
<td>53-075</td>
<td>63-075</td>
<td>74-200</td>
</tr>
<tr>
<td>3</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>
</tr>
<tr>
<td>4</td>
<td>1</td>
<td>Lock Collar</td>
<td>34-198</td>
<td>44-198</td>
<td>54-198</td>
<td>64-198</td>
<td>74-198</td>
</tr>
<tr>
<td>5</td>
<td>1</td>
<td>Washer</td>
<td>34-199</td>
<td>44-199</td>
<td>54-199</td>
<td>64-199</td>
<td>74-199</td>
</tr>
<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>
<td></td>
<td></td>
</tr>
</tbody>
</table>
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. 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.
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 value specified in chart above.
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 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 (See Lubrication Instructions Bulletin #1150).
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.

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**HOLLISTER-WHITNEY ELEVATOR CO. LLC**

**PARTS LIST & INSTALLATION INSTRUCTION - #7400 SERIES THRUST BEARING w/ LOCK COLLAR**

**SEE PARTS LISTS**

**THIRD ANGLE PROJECTION**

**DRAWN BY**

**SCALE**

**MATERIAL**

**REFERENCE TOL.**

**ALL DIMENSIONS REFERENCE UNLESS OTHERWISE SPECIFIED**

**SEE PAGE 1 OF 2 FOR REVISION HISTORY**

**DATE**

6/19/2003

**SHEET SIZE**

A

**SHEET**

2 OF 2