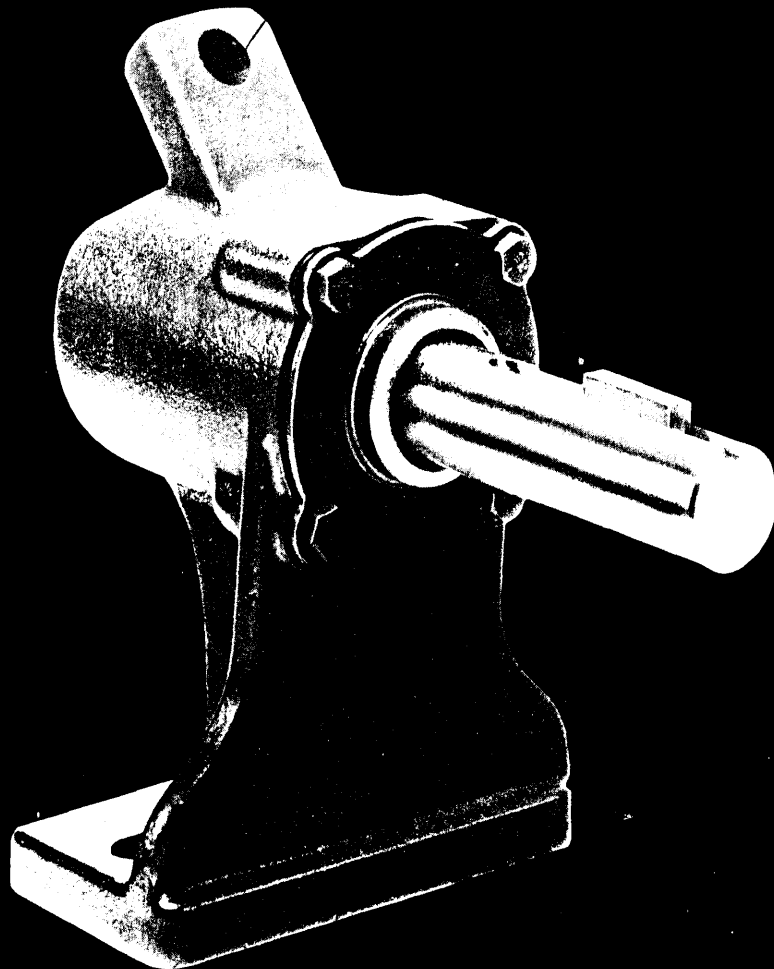


**TULSA<sup>®</sup>**  
**Service**  
**Parts**  
**Information**

**HB544**  
**Hanger Bearing**

**SPERRY**  **VICKERS**



## HB544

Item No.	Part Number	No. Req'd	Description
1	20280	4	Capscrew
2	21152	4	Lockwasher
3	24530	1	Cap
4	32534	1	Seal
5	939300		Shim Set
	<i>Which includes:</i>		
	22357	2	Shim .005
	22358	3	Shim .010
	22359	1	Shim .020
6	24523	1	Bearing Cup
7	24524	1	Bearing Cone
8	25534	1	Sleeve
9	20105	1	Key
10	25532	1	Shaft
11	25533	1	Roll Pin
12	24521	1	Bearing Cone
13	24522	1	Bearing Cup
14	24533	1	Housing
15	21128	1	Grease Fitting
16	24519	1	Plug

### Disassembly of Model HB544 Series Hanger Bearing

(Reference Drawing No. SA3695)

1. Remove key (Item 9) from shaft (Item 10).
2. Remove cap screws (Item 1) and lockwashers (Item 2) which retain cap (Item 3).
3. Remove cap (Item 3) containing seal (Item 4) being especially careful as shaft grooves may damage seal lip.
4. Remove shim set (Item 5).
5. Press out bearing cup (Item 6) from housing (Item 14).
6. Remove shaft sub-assembly (Items 7, 8, 10, 11 and 12) from housing (Item 14).
7. Drift or press out bearing cones (Items 7 and 12) from shaft (Item 10).
8. Bearing cup (Item 13) in housing (Item 12) can be pressed from housing if it is damaged or worn. Otherwise removal is not necessary.

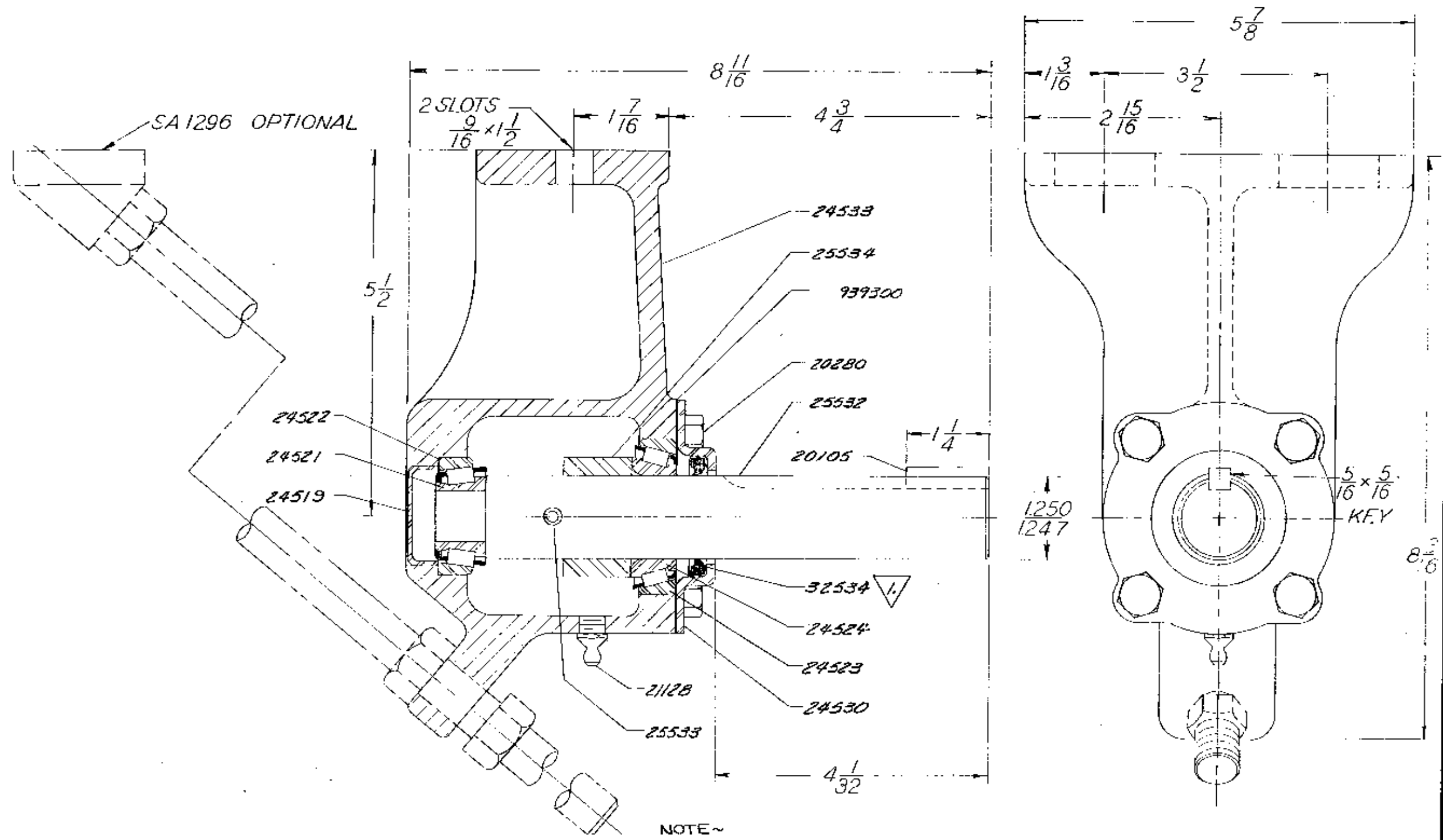
**NOTE:** Sleeve (Item 8) and roll pin (Item 11) need not be removed unless parts have been damaged.

### Assembly Instructions

Reverse the procedure to reassemble.

- NOTE:**
- a. Heating bearing cones (Items 7 and 12) to 212°F in bearing heater or oil bath, or freezing shaft (Item 10) will ease installation of cones on shaft.
  - b. Freezing bearing cups (Items 6 and 13) will ease their installation into housing (Item 14).
  - c. Capscrews (Item 1) should be torqued to 75 ft.-lbs.
  - d. Shim to achieve .005 end play in shaft (Item 10).
  - e. A lithium bearing grease should be used in unit, filling it until grease begins to extrude from the seal (Item 4).

DO NOT SCALE -- WORK TO DIMENSIONS -- REPORT ERRORS



NOTE ~  
 ▽ INSTALL SEAL WITH LIP DIRECTION TO BE AS SHOWN.

ALL PARTS MADE 1/4" UNLESS NOTED  
 ALL FRACTIONAL DIMENSIONS  $\pm$  1/64 UNLESS NOTED  
 ALL DECIMAL DIMENSIONS  $\pm$  .005 UNLESS NOTED

						TULSA WINCH DIVISION OF VICKERS, INC.			
		DRN. BY <u>SS</u>		DATE <u>4-25-84</u>		MODEL HB 544 HANGER BEARING ASSY		MATERIAL 	
		CHK. BY <u>LD</u>		DATE <u>5-24-84</u>					
		APP'D BY		DATE		DWG. NO. <b>K 4937E23</b>		REV. NO.	
LET.	CHANGE	NO.	DATE	BY	SCALE FULL.				

