



Figure 3-133. Sprocket Shaft Bearing Assembly

- m. Verify that the tool assembly is square, so that the bearing inner race is not cocked during removal. See Figure 3-130.
- n. Using the Robinair Heat Gun (HD-25070), uniformly heat the bearing inner race for about 30 seconds using a circular motion.

NOTE

To facilitate removal without heat, apply a light penetrating oil to shaft and leading edge of bearing inner race.

- o. Turn forcing screw until bearing inner race is pulled free of sprocket shaft.
 - p. Remove thrust washer from sprocket shaft.
2. Discard thrust washer and bearing inner race.

Installation

1. Place **new** thrust washer over sprocket shaft with the ink stamp facing outside (and the chamfer on the ID inboard).
2. Place **new** bearing inner race on bench top. Using the Robinair Heat Gun (HD-25070), uniformly heat bearing inner race for about 60 seconds using a circular motion.
3. Wearing suitable gloves to protect hands from burns, place heated bearing inner race over sprocket shaft.

NOTE

To facilitate installation without heat, apply a light penetrating oil to shaft and leading edge of bearing inner race.

WARNING

Never use both heat and penetrating oil. Use only one or the other. Excessive heat can cause the penetrating oil to ignite resulting in flames or fire. Inadequate safety precautions can result in death or serious injury.

4. Obtain the SPROCKET SHAFT TIMKEN BEARING CONE INSTALLER (HD-97225-55B). See Figure 3-131. Assemble tool as described below.
 - a. Thread pilot onto sprocket shaft until contact is made with shoulder.
 - b. Sparingly apply graphite lubricant to threads of pilot shaft to prolong service life and ensure smooth operation.
 - c. Slide sleeve over pilot until it contacts bearing inner race.
 - d. Slide Nice bearing and large flat washer over pilot until contact is made with sleeve.
 - e. Thread handle onto pilot shaft. See upper frame of Figure 3-132.

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