


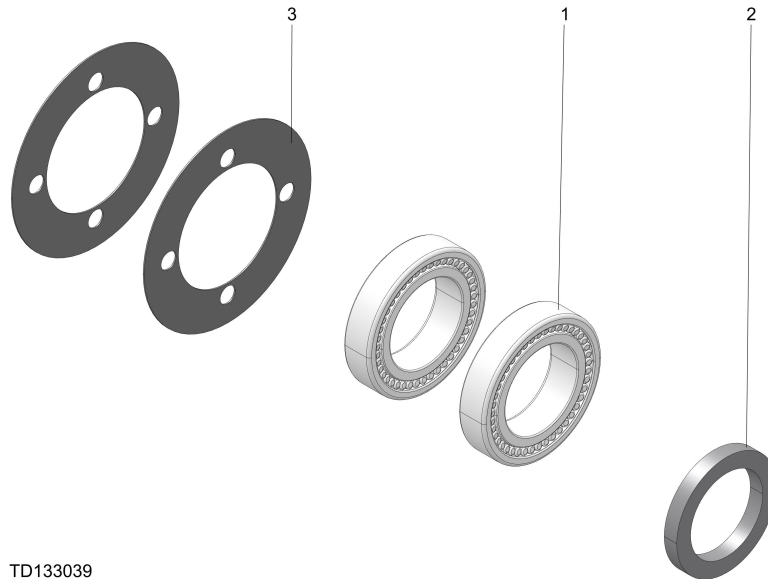
**FORM 2479**  
**HR150/250 BEARING REPAIR KIT INSTRUCTIONS**

**Part No. 133039-2479**

REF	DESCRIPTION	PART #	QTY.
	<b>KIT, HR150/250 BEARING REPAIR</b>	133039	1
1	4T-32011X- Bearing	116095	2
2	Sleeve, Hub Spacer	130951	1
3	Shim, HR Spindle	135012	2
	Loctite, #648 10mL Bottle	133034	1
	Inst Sheet, HR150/250 Bearing Repair Kit	133039-2479	1

 **WARNING!** Before performing maintenance or repairs on equipment, perform proper lockout procedures.

**NOTICE** Read the entire Operator's Manual before operating this equipment.



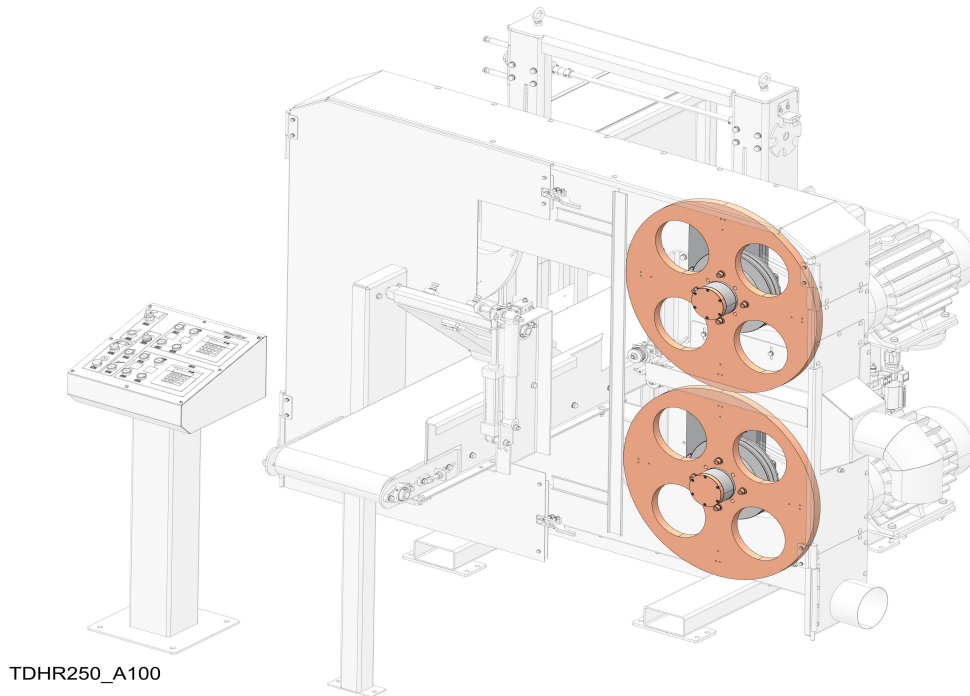
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**FIG. 1**

## Remove existing bearings

**Note the order and orientation of all parts being removed for reassembly.**

1. Locate drive wheel assembly inside sawhead cabinet..



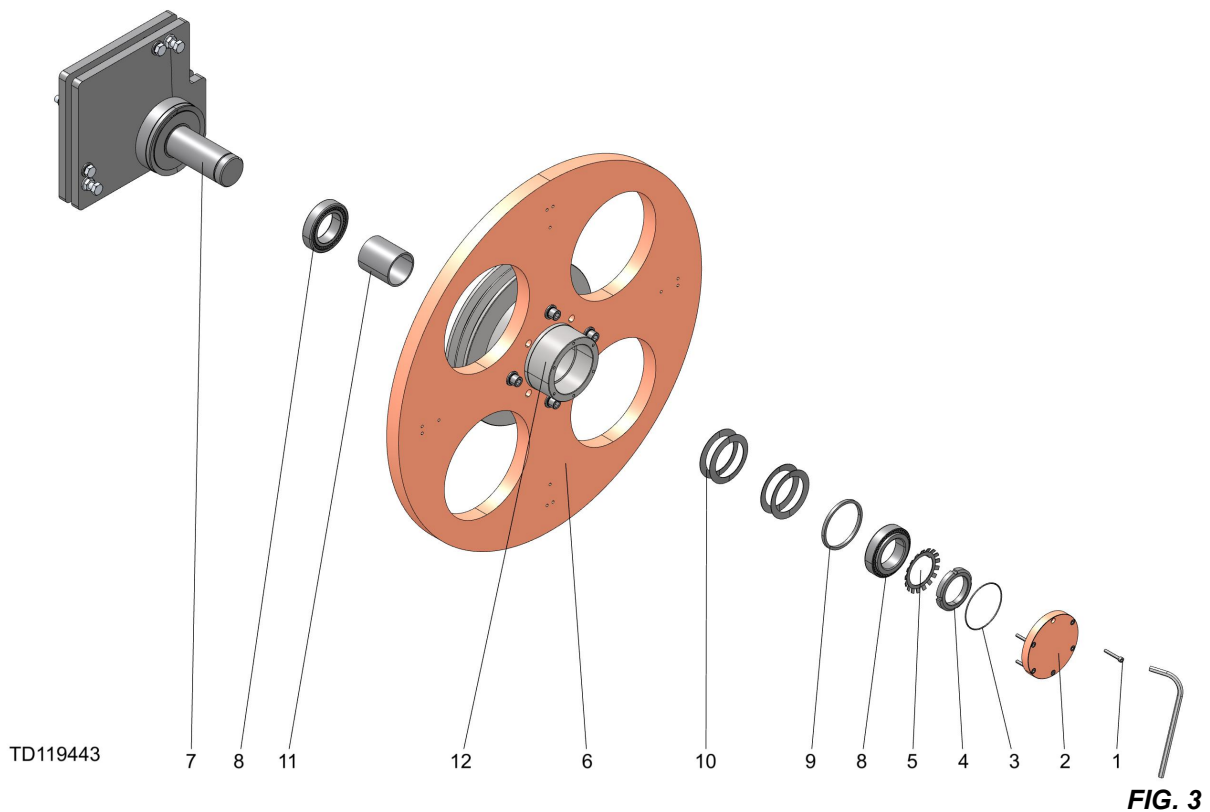
**FIG. 2**

**Blade wheel bearing hub will have either spring washers or a spacer. Each is shown below in FIGURES 3 & 4**

### WITH SPRING WASHERS (SEE FIG. 3)

1. Use 4mm Hex Key to remove wheel hub end cap with (#2) six M5 screws (#1).
2. Remove o-ring (#3), retainer nut (#4), and retainer lock washer (#5).
3. Pull drive wheel (#6) off drive wheel shaft (#7).
4. Remove two bearings (#8) from seat in drive hub (#12).

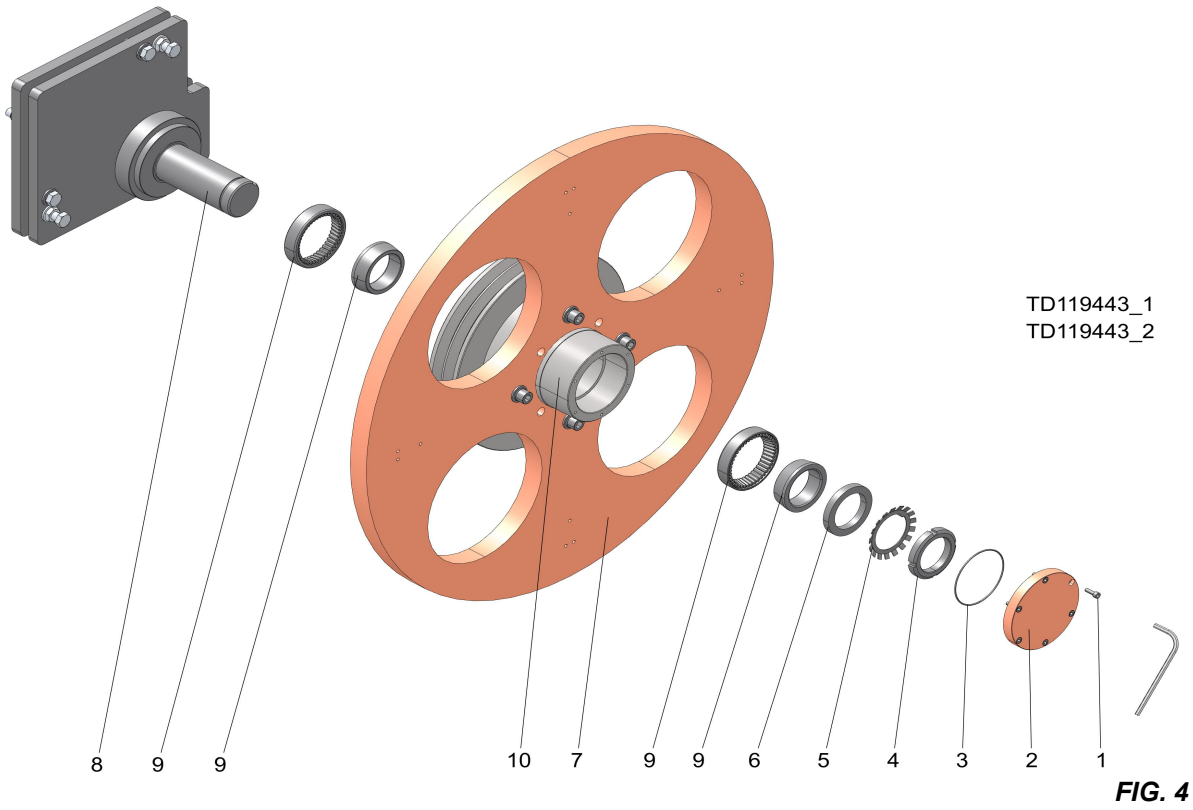
**NOTE: The spacer (#9), spring washers (#10), and sleeve spacer (#11) should be discarded. They will all be replaced with a new spacer.**



**WITH HUB SPACER SLEEVE (See FIG. 4)**

1. Use 4mm Hex Key to remove wheel hub end cap with (#2) six M5 screws (#1).
2. Remove o-ring (#3), retainer nut (#4), retainer lock washer (#5), and hub spacer sleeve (#6).
3. Pull drive wheel (#7) off drive wheel shaft (#8).
4. Remove two bearings (#9) from seat in drive hub (#10).

**NOTE:** Each bearing has a separate inner and outer race.

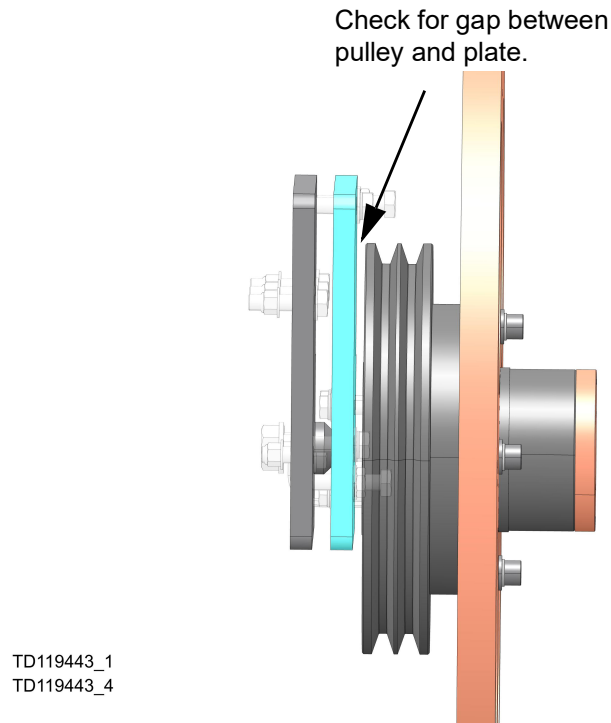


## Install new bearings

1. Clean all surfaces with a cleaning solvent and allow to dry.
2. Dry fit parts with (2) new bearings together as shown in FIG. 4.

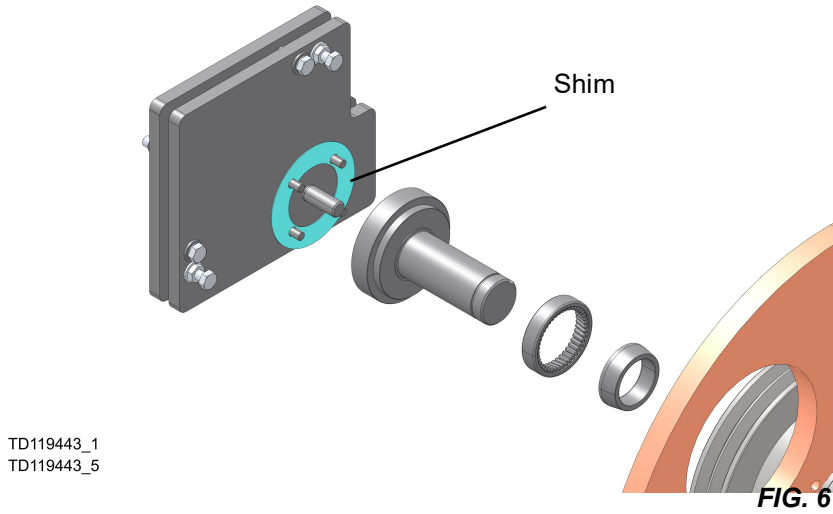
**NOTE:** If the hub used spring washers or a spacer, they will be replaced with a new spacer.

3. Check for clearance between pulley and inner plate. See FIG. 5



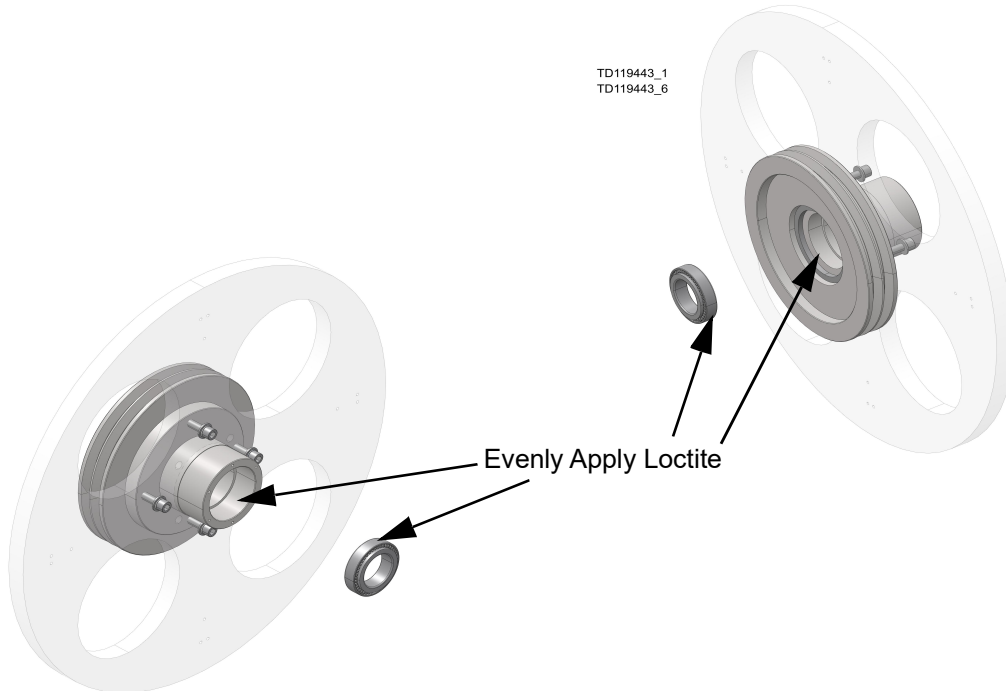
**FIG. 5**

4. If pulley contacts inner plate, remove assembly and install (1) shim. See FIG. 6.
5. Dry fit parts together as shown in FIG. 4.
6. Check for clearance between pulley and inner plate. See FIG. 5.
7. If needed, add a second shim.



8. Disassemble blade wheel hub.
9. Apply Loctite #648 around circumference of bearing and inside of bearing seat of blade wheel. See FIG. 7
10. Install (2) bearings.
 

**NOTE:** Rotate bearing during assembly to ensure good coverage.
11. Reinstall remaining assembly parts as shown in the FIG. 4.
12. Allow minimum of 24 hours to cure before operating machine



13. End of Task.