

g. Apply wet primer (C312) to sleeve OD and housing bore as required by figure 11-44. Press sleeve into housing with equal projection on each side. Apply wet primer to sleeve ID and bearing OD and install bearing, centered equally from each end.

WARNING

Cleaning materials are flammable and toxic. Avoid skin contact and breathing of solvent vapors.

h. Cleaning housing bore, sleeve and bearing OD with naphtha (C178). Apply primer (C211) (grade as specified by figure 11-44) to sleeve OD and housing bore. Allow three to five minutes drying and apply sealant (C211) (grade as specified by figure 11-44) sparingly to sleeve and bore. Install sleeve and check for equal projection each side. Sealant cure time is 10 to 40 minutes.

CAUTION

Do not allow sealant to contaminate bearings.

i. Apply primer (C211) (grade as specified by figure 11-44) to ID of sleeve and OD of bearing. Allow three to five minutes drying time and apply sealant (grade as specified by figure 11-44) to bearing OD and sleeve ID. Install bearing, centered equally from each end. After bearing is centered, apply additional drops of sealant to parting line between bearing and sleeve.



Staking operation should be performed within 30 minutes after sealant application. Do not allow sealant to cure before staking.

NOTE

Select a staking tool to accomplish a ring stake as shown in figure 11-44. The tool shall be so designed to have a 90 degree ring stake, using a radius equal to the retaining hole plus 1/2 the thickness of the sleeve, within plus or minus 0.0025 inch tolerance.

j. Ring stake sleeve both sides in accordance with figure 11-44.

k. Check bearing for freedom of movement after curing of sealant. Check that bearing is true to surface.

l. Inspect housing by fluorescent penetrant per ASTM E1417. Refer to TM 55-1500-335-23.