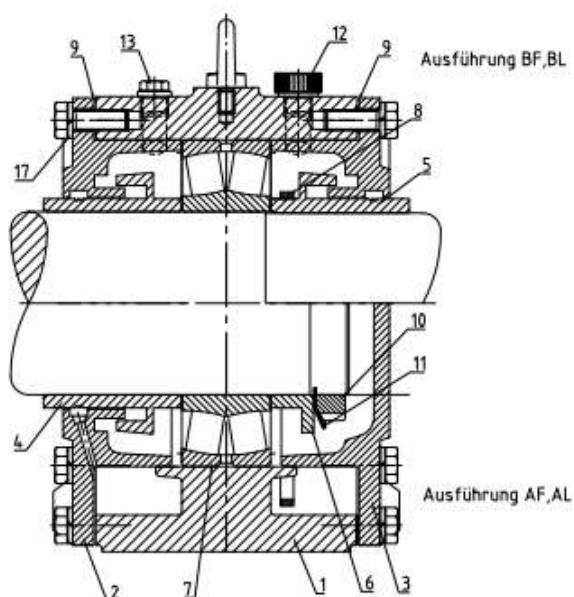
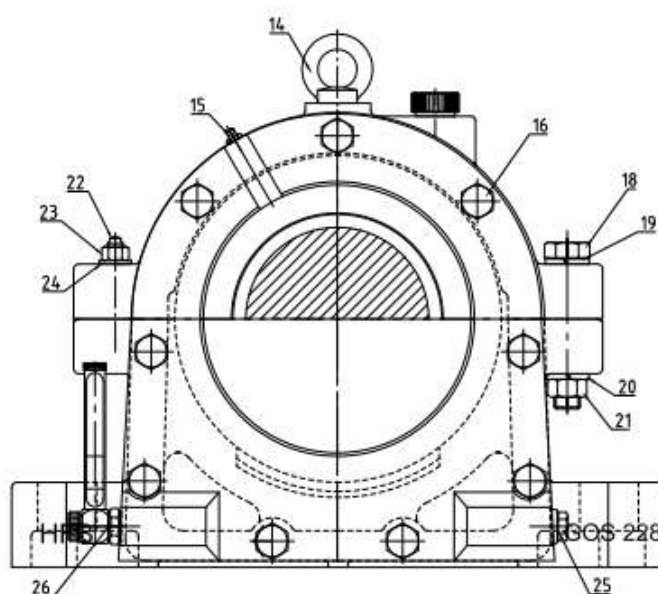




Assembly Instructions Oil-Lubricated Plummer Block Housings Series GOS 200 + 300



Assembly preparation:

Clean the working area before starting assembly. Ensure that only clean tools are used during the entire assembly process. Check for dimensional and geometrical accuracy of the positions on the shaft. Check the surface roughness of the clamping area; Ra must not be larger than 12.5µm. Levelness should be within IT7.

Dismount the housings completely. In doing so, loosen the side covers (pos. 2 and 3) and remove them together with the cover gasket (pos. 9). Then separate the top and bottom parts of the housing (pos. 1 and pos. 16). Caution! During assembly, keep track of which housing parts go where by marking them adequately.
Clean shaft, labyrinth seals (pos. 4 and 5) and the inner sides of the housing.

Assembly:

Fix the housing on the clamping area by means of fastening bolts. Do not tighten! Slide the inner side cover (pos. 2) with the cover gasket (pos. 9) onto the shaft. Note: The side cover has a drain hole on the centring pin at 6-o'clock-position. Always mount the pin opposite to the oil lubrication ring.

Slide the labyrinth seal (pos. 4), recognisable by the larger hole, onto the shaft.

Mount the housing (pos. 7) towards the labyrinth seal at the correct position. For this purpose, heat the housing up to max. 120° C. Ensure that the housing label points towards the shaft end.

Mount a second labyrinth seal (pos. 5) on the shaft in case of housings for continuous shafts. In case of housings at shaft ends, place the spacer ring (pos. 6) and the shaft nut (pos. 10) with lock washer (pos. 11) and tighten.

Place the oil lubrication ring (pos. 8) onto the labyrinth ring (pos. 5) or the spacer ring (pos. 6).

Coat the mating surfaces on the bottom and top part of the housing using an oil-resistant sealing compound.

Place the preassembled shaft-housing-unit into the housing.

Carefully align the housing. Then slightly tighten the fastening bolts on the housing foot. Insert the conical pins with nut and spring washer (pos. 22, 23 and 24), place the top part of the housing onto it and mount the connecting bolts (pos. 18-21).

While tightening the connecting bolts, tap the conical pins several times. Then fasten the bolts applying the specified torque.

Place the cover gasket (pos. 9) on the outer side cover (pos. 3) and slide the side cover onto the shaft, and attach to the housing. Use the closed cover (pos. 3) for housings with shaft end.

Verify the alignment of the housings, and tighten the fastening bolts applying the specified torques.

Screw in bleeder (pos. 12). If possible, always mount the oil level indicator (pos. 26) on the opposite side of the oil lubrication ring. Finally, fill oil into the housing. Refer to the table for adequate oil volumes and appropriate oil levels.

Recommended torque (Nm)

Bolt size	Side cover Property class 8.8	Top & bottom part Property class 8.8	Foot bolts Property class 8.8 **
M 8	23		
M10	45	50	
M12	77	80	
M14	125		
M16	190	150	
M18	275		
M20	300	200	410
M22	400		
M24	500	350	710
M30	900	400	1450
M36			2600
M42			3900
M45			4950

** Torques are maximum values at 90% utilisation of the yield strength of the bolt material and a friction of 0.14. We recommend fastening the bolts at 70% of the values specified above.

Oil volumes and oil level for Plummer Block Housings, Series 200:

Type	Oil Volume Approx. (Litres)	Oil level indicator	
		MIN (mm)	MAX (mm)
GOS 217	0,7	42	63
GOS 218	0,8	45	68
GOS 219	0,9	50	70
GOS 220	1,0	50	70
GOS 222	1,3	50	77
GOS 224	1,7	60	80
GOS 226	2,3	60	85
GOS 228	2,4	60	85
GOS 230	2,8	60	90
GOS 232	3,3	65	95
GOS 234	5,0	75	105
GOS 236	5,2	80	115
GOS 238	5,8	85	120
GOS 240	7,0	85	125
GOS 244	8,5	95	140
GOS 248	9,5	110	155

Oil volumes and oil level for Plummer Block Housings, Series 300:

Type	Oil Volume Approx. (Litres)	Oil level indicator	
		MIN (mm)	MAX (mm)
GOS 310	0,3	33	53
GOS 311	0,4	37	53
GOS 312	0,5	40	60
GOS 314	0,6	45	65
GOS 316	1,0	45	73
GOS 318	1,4	55	80
GOS 320	1,8	57	85
GOS 322	2,0	67	95
GOS 324	2,8	65	100
GOS 326	3,4	70	105
GOS 328	4,2	70	115
GOS 330	6,0	75	120
GOS 332	6,5	80	125
GOS 334	7,5	85	130
GOS 336	10,5	90	155