

# STANDARD OPERATING PROCEDURE

## Bearing Replacement - TRON Lightcycle

SOP-MAINT-001 | Revision 2.1 | 2025-09-02

### 1. PREPARATION

- Obtain work permit and safety clearance
- Gather required tools: bearing puller, torque wrench, alignment tools
- Verify replacement bearing part number matches specification
- Ensure proper PPE is worn

### 2. LOCKOUT/TAGOUT

- Place ride in maintenance mode
- Isolate all energy sources (electrical, hydraulic, pneumatic)
- Apply personal locks and tags
- Test isolation effectiveness

### 3. BEARING REMOVAL

- Remove bearing housing cover bolts (torque: 85 ft-lbs)
- Extract old bearing using appropriate puller
- Clean bearing housing thoroughly
- Inspect housing for damage or wear

### 4. INSTALLATION

- Apply thin layer of approved grease to housing
- Install new bearing ensuring proper orientation
- Torque housing bolts to specification: 450 ft-lbs
- Verify bearing alignment within 0.002" TIR

### 5. TESTING

- Remove lockout/tagout devices
- Perform low-speed rotation test
- Monitor vibration levels during initial operation
- Complete post-maintenance inspection checklist