Shaft to bearing clearances for babbitted sleeve bearing horizontal motors shall be determined in this order of preference:

1. Customer Specification
2. Manufacturer's Specification for that specific motor
3. Manufacturer's Specification per chart Table 1 and EASA Figure 4
4. General Specification per Table 2.

TABLE 1 Babbitt Bearing Shaft Clearances per Manufacturer

MANUFACTURER	MINIMUM (NEW/REBUILT AND IN SERVICE))	MAXIMUM (IN SERVICE)
GE	0.002 per shaft diameter inch	0.004 per shaft diameter inch
US Electric Motor	0.002 per shaft diameter inch	
Kingsbury Max	0.002 plus 0.0010 per shaft diameter inch	0.003 plus 0.0015 per shaft diameter inch
EASA Tech Paper (chart) Figure 4	0.003 plus 0.0010 per shaft diameter inch	0.005 plus 0.0010 per shaft diameter inch
Teco Min	0.001 plus 0.0010 per shaft diameter inch	0.0015 plus 0.0015 per shaft diameter inch
Westinghouse Min (< 8")	0.003 plus 0.0010 per shaft diameter inch	0.005 plus 0.0010 per shaft diameter inch
	Above 8" (W) lines curve toward .004 plus .001 Max & .002 plus .001 Min.	
Where a minimum and maximum are given the minimum shall be interpreted as the correct size for a new or newly rebuilt babbitted bearing in horizontal service.		

TABLE 2 Babbitt Bearing General Shaft Clearances

MOTOR	MINIMUM (NEW/REBUILT AND IN SERVICE))	MAXIMUM (IN SERVICE)
For motors 600 RPM and slower with bearing length greater than bearing inside diameter	0.002 per shaft diameter inch	0.004 per shaft diameter inch
For motors rated at 3000 RPM or higher	0.001 plus 0.0010 per shaft diameter inch	0.0010 plus 0.0015 per shaft diameter inch
All other motors	0.0015 per shaft diameter inch	0.002 per shaft diameter inch

EASA Figure 4 Attached

SLEEVE BEARING CLEARANCES – BABBITT LINED

EASA FIGURE 4 WITH NAMES