

EMQ-INSULATED SLEEVES

PROBLEM:

Bearing damaged by electrical corrosion - current passing through the bearing causes fluting and pitting.

SOLUTION:

INSULATED SLEEVES - Thermoplastic Polymer Alloy

- Advantages:
- 1) Cost
 - 2) Availability
 - 3) Machinability
 - 4) Resistance to Environmental Attack
 - 5) Good Thermal and Electrical Resistance
 - 6) Good Impact Resistance
 - 7) Special Sizes can be made to order in 1-3 Days

INVENTORY AVAILABLE:

Part #	Bearing	O.D.	I.D.	Width
018898B	202/ /6003	1.629	1.329	.787
018904B	203/	1.825	1.525	.630
018908B	/302/6004	1.904	1.604	.669
018912B	204/303/6005	2.101	1.801	.709
018916B	205/304	2.298	1.998	.748
018920B	206/305/6007	2.692	2.392	.906
018924B	207/306	3.085	2.785	.984
018928B	208/307/6010	3.400	3.101	1.024
018932B	209/	3.597	3.297	.945
018936B	210/308/6011	3.794	3.494	1.142
018940B	211/309/6011	4.188	3.888	1.221
018944B	212/310/6014	4.582	4.282	1.299
018948B	213/311	4.975	4.675	1.457
018952B	214/ /6016	5.172	4.872	1.260
018957B	215/312/6017	5.369	5.069	1.535
018961B	216/313/6018	5.763	5.463	1.614
018965B	217/314/6020	6.157	5.857	1.693
018969B	218/315/6021	6.550	6.250	1.772
018973B	219/316/6022	6.944	6.644	1.850
018977B	220/317/6024	7.338	7.038	1.929
018981B	221/318	7.731	7.431	2.008
018986B	222/319/6026	8.125	7.825	2.087
018991B	224/320	8.716	8.416	2.244
019010B	226/	9.307	9.007	2.750
019012B	228/	10.093	9.793	2.750
019014B	230/	10.882	10.582	3.150
019016B	/321	9.109	8.809	3.540
018996B	/322	9.700	9.400	2.362
018998B	/324	10.488	10.188	2.756
019017B	/326	11.275	10.975	3.540
019019B	/328	12.062	11.762	3.900
019022B	236/330	12.850	12.550	4.300
019024B	/332	13.636	13.336	4.300
019034B	232/	11.668	11.368	3.000
019036B	234/	12.455	12.155	3.100
019038B	236/	12.849	12.549	3.100
019040B	238/	13.636	13.336	4.300
019042B	240/	14.473	14.173	3.900



RECOMMENDED INSTALLATION INSTRUCTIONS

INSULATED SLEEVES

1. Obtain proper sleeve for bearing housing.
 - A. Sleeve will be .250" larger than I.D. of bearing housing, unless special size.
2. Chuck housing in lathe or mill.
 - A. Alignment is critical, check face (within .003") and diameter (within .001").
 - B. Be sure not to squeeze end bell too tight or fit will egg when removed.
3. Bore end bell sleeve fit. 250 surface finish, glue will seat into rough surface - for a better hold.
 - A. Make housing bore .004" to .010" diametric clearance over sleeve O.D.
 1. Up to a 6" Ø > bore .004" to .006" oversize.
 2. Over 6" Ø > bore .006" to .010" oversize.
 3. Note: Glue needs this clearance to work properly.
 - B. Face bottom of bore .065" deeper beyond original face.
 - C. Clean all metal dust, oil, chips, and loose debris from bore crown 8060 Safety Solvent - cleans and degreases.
4. Installing sleeve.
 - A. Install end bell insulator washer in housing first.
 - B. Clean O.D. of bearing sleeve. Try not to touch after cleaning.
Use: Crown 8060 Safety Solvent.
 - C. Mix fast cure epoxy, apply a thin coat to I.D. of housing bore, and O.D. of sleeve.
Cut bristles on paint brush short - mix glue with brush.
Use: Loctite Poxo-Pak, Item #81120 / or # 1166731.
 - D. Insert BRG sleeve, in bearing bore. Clean up excess glue.
 - E. Allow epoxy to set (15min.). See instructions on back of Poxo-Pak.
 - F. Face excess width of sleeve off.
 - G. Bore sleeve to proper size for specified bearing. Cutting forces - low.
 - H. If a retainer is used, be sure to insulate it.
5. Sleeve, out of round - You can tap in with soft hammer. !USE CAUTION!
6. Don't heat or cool - Glue will thicken FAST!
7. Generally insulate O.D.E bearing to break current flow. Load is usually lighter. Both sides may require insulating or even coupler!
8. Test sleeve for ground: MEGOHMS 1000 INFINITY = GOOD
It could go as low as 3 MEGOHMS and work ok - Depends on application.
9. As glue dries it will MEG. Better. Check after 1 hour.
10. Dielectric strength of poly - 1000 V/ MIL.