RECOMMENDED INSTALLATION INSTRUCTIONS
EMQ - 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 lather 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 .0140” 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 of I.D. of housing bore and O.D. of sleeve.
      Cut bristles on paint brush short – mix glue with brush.
      Use: Loctite Poxy-Pak, Item #81120 / or #1166731.
   D. Insert BRG sleeve in bearing bore. Clean up excess glue.
   E. Allow epoxy to set 15 minutes. See instructions on back of Poxy-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.