**STEPS TO INSTALL EM-QUIK SLEEVES-STEEL & CAST**

1. **OBTAIN PROPER SLEEVE FOR BEARING HOUSING**
   
   A. **CHOOSE PREFERENCE STEEL OR CAST**
   
   B. **SLEEVES ARE AVAILABLE IN NUMEROUS WIDTHS. *SEE CHART FOR WIDTH OPTIONS.**

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 ENDBELL TOO TIGHT OR FIT WILL EGG WHEN REMOVED.**

3. **BORE ENDBELL BEARING FIT**

   A. **FREEZE SLEEVE**

      1) **PREFERRED METHOD IS TO USE LIQUID NITROGEN**

      * 2) **ALTERNATIVE METHOD – DRY ICE OR FREEZER**  
         (REDUCE PRESS BY .001” OR YOU WILL HAVE TO TAP OR PRESS SLEEVE IN).

   B. **INSERT SLEEVE AND NORMALIZE TEMPERATURE**

5. **CHECK FACE RUNOUT .003” AND BORE CONCENTRICITY .001” AGAIN**

6. **FACE EXCESSIVE WIDTH OF SLEEVE OFF**

7. **BORE SLEEVE TO PROPER SIZE FOR SPECIFIED BEARING**