

MINCO

SUGGESTED INSTALLATION PROCEDURE TEMPERATURE SENSOR IN THRUST BEARING CASE STYLE A

1.0 SUGGESTED INSTALLATION PROCEDURE:

NOTE: For easier installation, sensors may be purchased with babbitt tips already applied. See specification drawings for complete details.

- 1.1. Drill a 7/32" (5,55mm) diameter axial hole through the babbitt layer and bearing shoe in the desired location.
- 1.2. Counterbore a .278/.281" (7,05/7,15mm) diameter hole, 5/16" (7,95mm) deep from the bearing surface, using a 9/32" (7,15mm) diameter counterbore with a 7/32" (5,55mm) diameter pilot. Break or chamfer corners to remove sharp edges.
- 1.3. Mill a groove in back of the bearing shoe 1/8" (3,20mm) wide by 3/16" (4,75mm) deep. The groove should extend from the 7/32" (5,55mm) diameter hole to where the leadwires exit the bearing. Terminal connection points must be located within the leadwire length of the temperature detector being installed.
- 1.4. Thoroughly clean machined surfaces so they are free of oil, chips, etc. Also, make sure the detector case is clean.
- 1.5. Insert the leadwires of the detector in the .278/.281" (7,05/7,15mm) diameter counterbored hole. Extend the leadwires through the 7/32" (5,55mm) diameter hole in the bearing shoe. Carefully draw the leadwires through the hole: make certain they are not kinked or damaged. **DO NOT** pull the leadwires to seat the detector case in the .278/.281" (7,05/7,15mm) diameter hole. Gently guide the case into the hole and press into place. The end of the case should be about 1/16" (1,60mm) below the bearing surface when the detector is properly seated.
- 1.6. Fill the hole above the detector with shavings or small pieces of babbitt. Use enough babbitt to cover the end of the detector case and extend slightly above the bearing surface after melting.
- 1.7. Use a small gas flame to heat and melt the edge of the babbitt layer surrounding the detector tip. **DO NOT** allow the flame to contact the detector case. **DO NOT** concentrate the flame in one place for any length of time. **KEEP THE FLAME MOVING.** The babbitt must be melted to fusion-bond to the detector case, but must not be heated to a temperature that will damage the detector. The detector may be exposed to temperatures as high as 572°F (300°C) for short periods of time. If needed, add babbitt to fill the hole flush or slightly above the bearing surface.
- 1.8. Scrape off excess babbitt and dress to create a smooth, unbroken surface.

DR: <u>JEH 05-10-95</u>	MINCO PRODUCTS, INC. 7300 Commerce Lane Minneapolis, MN 55432 USA Phone: (612) 571-3121 FAX: (612) 571-0927 CAGE No. 09359	Engineering Instruction #167
CHK: <u>BAM 05-10-95</u>		ECO #28237 Rev. E
ENG: <u>BAL 05-10-95</u>		
APP: _____		PAGE 1 OF 2

- 1.9. Lay leadwires flat in the bottom of the milled groove in the bearing shoe. Pot the leadwires in the groove using an epoxy or other suitable potting compound compatible with the bearing shell material, temperature, and service conditions.

NOTE: Although the illustration below depicts a thrust bearing, the above installation procedure can be used with other types of bearings, and also with equipment other than bearings.

