REPLACING THE REAR-MOST FEED ROLL SHAFT BEARING (#20) ON THE 90AD EXTRUDER
SAFETY

J.C. Steele and Sons equipment is designed to process large amounts of heavy products. To accomplish many of the required operations of our customers, high horsepower and heavy components are required. A great deal of time and effort has been invested into our equipment to make them as safe as practically possible. The safety features are no substitute of caution and common sense. A careless moment is all that is needed to cause a serious accident. Please refer to the machine’s Owner’s Manual for a detailed list of safety precautions.

GENERAL DESCRIPTION

SPECIAL TOOLS NEEDED

- Black silicone
- Wedge

MANPOWER ESTIMATE

This procedure will require 2 men for 4 hours.
PROCEDURE

1. Remove both feed roll shaft couplings and middle feed roll shaft section.

2. On the outside of gearbox, loosen the two set screws which lock the bearing inner race to the rear feed roll shaft section.

3. Remove top, cover section of extruder gearbox (see Figure 2).

4. Once inside gearbox, begin by prep[ping the gear for removal] of shaft.
   - Locate the folded tab of the lock washer which is engaged in the locknut.
   - Remove locknut and lock washer.
   - The gear will need to stay in the location throughout the process, thus, use a wedge or appropriate device to support gear against inside of gearbox casting.
   - Gear is a slide fit and should be removed with relatively light force.
5. Prior to removing the shaft, attention should be paid that once the key is clear of the gear, it is not allowed to fall out and down into the gearbox.

- Also ensure that the spacing sleeve is between gear and inner race of bearing (this will need to be supported as shaft is removed in the following step).

6. Remove the shaft by pulling it out the front of gearbox (towards vacuum chamber of extruder).

7. Remove bolts from face of bearing assembly on the outside of gearbox and remove bearing assembly from gearbox, using the jack bolt holes in the flange to assist.

8. Remove RTV from all mating surfaces prior to reassembly.

9. Apply black silicone to backside flange of replacement bearing assembly.

10. Reverse procedure to reinstall.