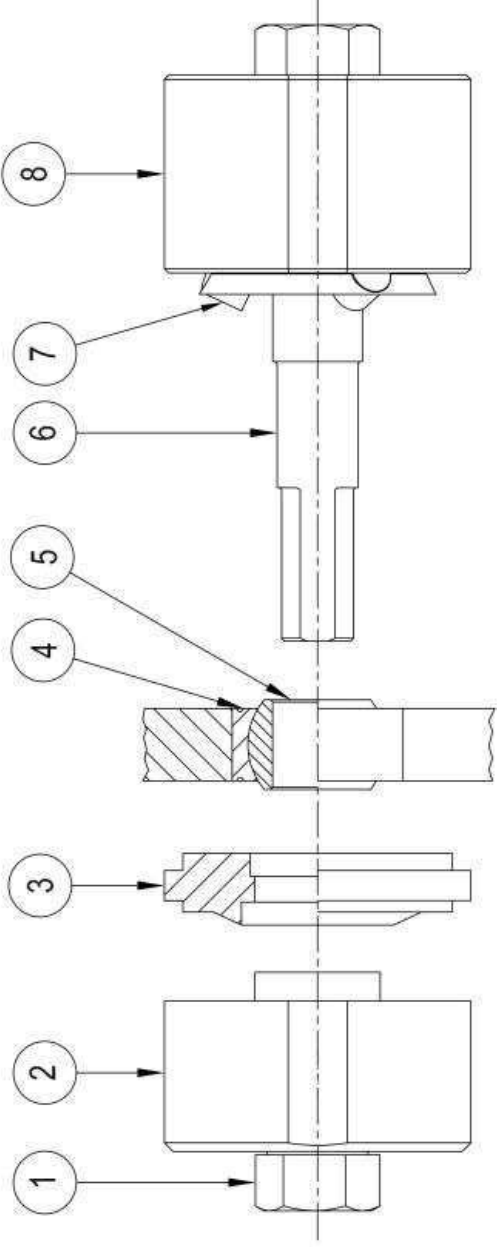


Portable Swaging Tool

Operating instructions



1) Disassemble tool by carefully unscrewing draw rod hex nut (1) in locating fixture (2).

2) Place flip-ring (3) into locating fixture assembly (2) with flat side facing out.

3) Insert roller fixture assembly into bearing with connecting sleeve (6) through the bore of the bearing (5).

4) Insert draw rod (4) into connecting sleeve in locating fixture assembly (2), threading the bolt into the sleeve by turning hex nut (1). Tighten until rollers (7) are snug against groove lip (4) and locating fixture assembly (2) with flip-ring (3) is flush with the face of the bearing outer race and housing

Note: Never over tighten causing rollers to dent or make an impression in groove lip.

5) Rotate roller fixture (8) by hand to ensure there are no restrictions.

6) Turn hex nut (1) clockwise approximately 30 degrees causing roller to press against lip.

7) Rotate roller fixture (8) three complete revolutions or until it rotates without resistance

8) Repeat steps 6 & 7 until the draw rod nut (1) is rotated approximately 180 degrees or until the bearing lip is completely swaged and there is no gap between the lip and housing or it meets specification.

9) Disassemble tool by carefully unscrewing draw rod hex nut (1) in locating fixture (2).

10) Swage the other side of the grooved bearing.

Turn the flip-ring (3) over so angled side faces out and place into locating fixture assembly (2). Repeat steps 3 through 8 to swage the opposite side of the bearing with the angled face now supporting the lip of the bearing that has been swaged.
