

Ball Staking Tool Operating Instructions

- 1) Arbor or hydraulic press.
- 2) Proper staking tool for each bearing size to make an impression in the housing over the bearing chamfer. Tool consists of: Two anvils to make correct impressions displacing housing material into recess formed by bearing chamfer and edge of the housing and a pilot pin.

Preparations:

- 1) Clean housing bore of all contaminants and foreign material. No burrs shall exist on outside edges of bore.
- 2) Insure bearing is clean from contaminants.

Installation:

- 1) Install bearing straight into housing. Make sure bearing is not cantered when pressing in. Do not push on inner race or shield.

- 2) Press bearing until centered in housing and outer race is flush with housing.

Staking:

- 1) Apply light amount of machine oil to tool or housing.
- 2) Locate tool and bearing under press. Align tool with ram of press.
- 3) Make sure housing is perpendicular to press.
- 4) Gradually apply even force until impression reaches drawing specified depth.
- 5) Stake all housings using same load.

Inspection:

- 1) Verify depth of stake on both sides as specified.
- 2) Inspect bearing for flushness with housing. Asymmetry is permitted provided race faces are within (+,-) 0.01" of housing face or as specified.
- 3) Verify bearing is contained as specified.
- 4) Visually inspect for any irregularities.

