Brand of **NTN Group**

DEEP GROOVE BALL BEARINGS

Cold mounting instructions

Before starting

Verify:

- ❑ Bearing reference compliant
- ❑ Clean packaging and bearing, less than 3 years old
- ❑ Clean shaft, housing, and shoulders
- ❑ Worn without scuffs or knocks
- ❑ Measured shaft/housing adjustments compliant
- ❑ Tools available and ready to use near you

Materials needed

- Mounting tool kit case
  - Mounting sleeve with socket
  - Tool Impact ring
  - Dead-blow mallet
  - > **TOOL IFT SET 33**
- Mounting paste (Anti-fretting)
- Lint-free clean cloth
- Heat-resistant gloves

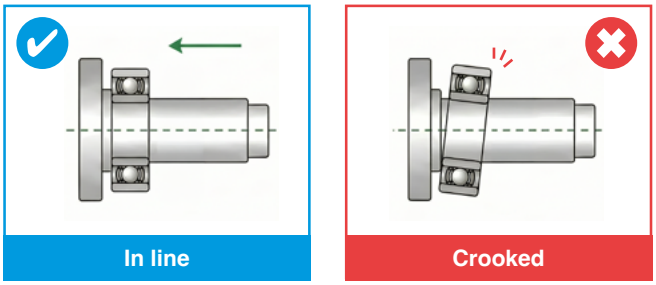
Use only clean tools in good condition.

Step 1: Prepare

- ❑ Prepare the bearing just before assembly
- ❑ Check for shock/pollution/rust
- ❑ Clean shaft and housing
- ❑ Apply a thin layer of mounting paste to the shaft
- ❑ Fit the bushing onto the corresponding firing pin tube

Step 2: Position

- ❑ Present the bearing perfectly in the axis and with the legible marking
- ❑ Engage by hand for a few millimetres if possible
- ❑ Put the bushing in contact with the right bushing
- ❑ Centre the bushing against the bearing



Never start at an angle.

Step 3: mount

- ❑ Hit the firing pin tube with a dead-blow mallet (or use a press)
- ❑ Check that the socket presses on the inner and outer rings at the same time
- ❑ Progressive, regular efforts in the axis
- ❑ Control the progress after a few blows
- ❑ Continue until you have a clear footing on the shoulder behind the bearing

Never hit the bearing directly.
Never strike sideways.
Never transmit the effort via the balls.

Step 4: Check

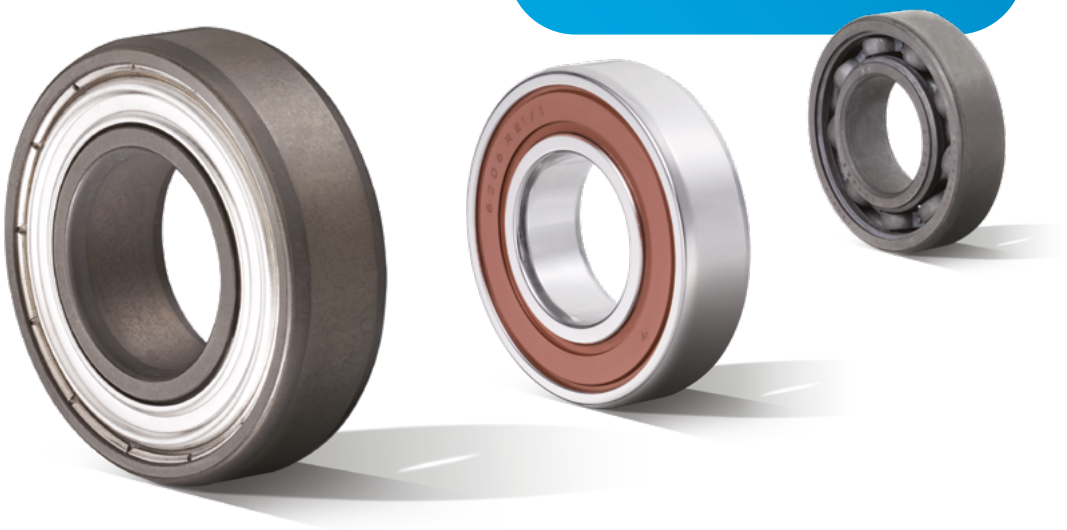
- ❑ Bearing in full support on the shoulder
- ❑ Free rotation by hand
- ❑ No hard points
- ❑ No abnormal noise
- ❑ Intact gasket/deflector
- ❑ No visible shock

Never use:

- Direct steel hammer on bearing
- Pin punch
- Torch to help cold assembly
- Dirty / marked / deformed tool
- Socket not suitable
- Stress on cage or balls

Advice from our experts

If the mounting effort becomes too great: Check the fit dimensions and choose a suitable hot mounting.



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