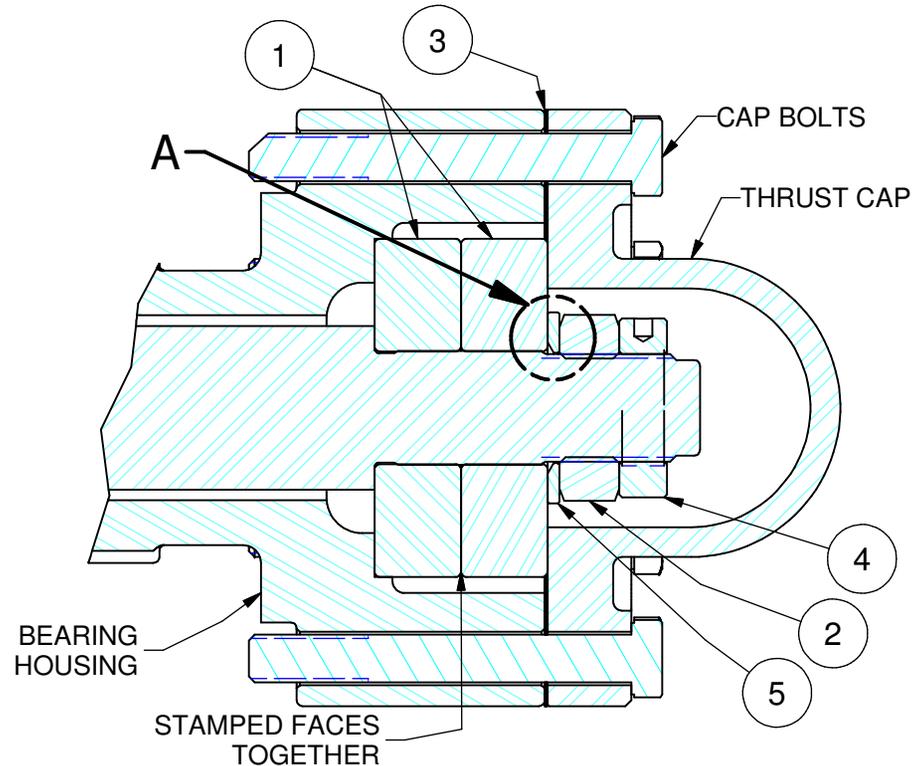
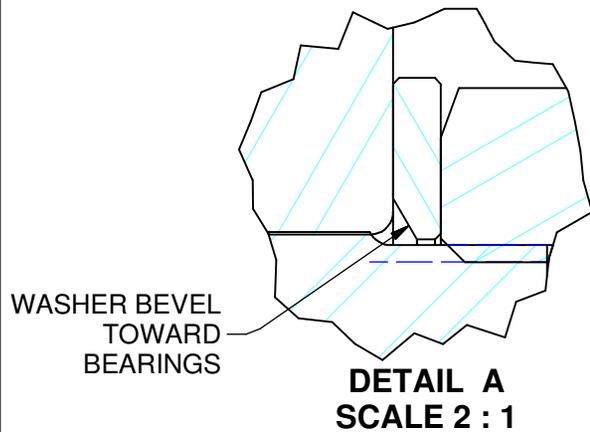


NOTICE: IF THE MACHINE BEING REPAIRED HAS JAM NUT & LOCK COLLAR, SEE PAGE 2 OF 2 FOR INSTALLATION PROCEDURES.

MACHINES WITH JAM NUTS AND LOCK COLLARS have generally been used since October 2001 (Contract #A140000 & newer).

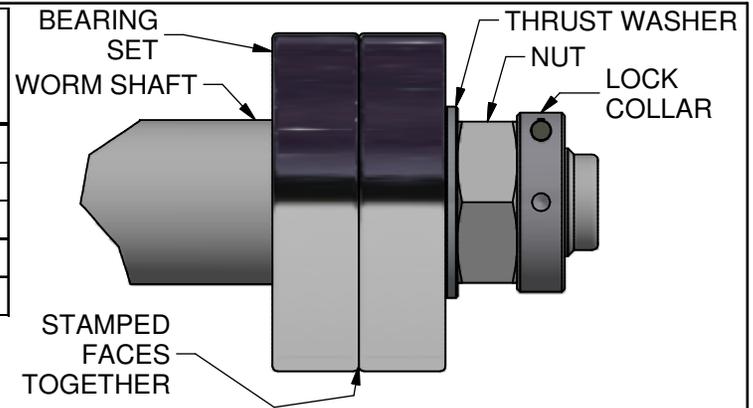
If the machine being repaired has a Castle Nut & Cotter Pin combination, see Document E-127 for instructions.

ITEM	QTY	DESCRIPTION	KIT #34-202	KIT #44-202	KIT #54-202	KIT #64-202	KIT #74-202
1	1	THRUST BEARING SET	#7405	#7406	#7407	#7409	#7413
2	1	NUT	34-075	43-075	53-075	63-075	74-200
3	8	GASKET/SHIM	34-087	43-087	53-087	63-087	74-087
4	1	LOCK COLLAR	34-198	44-198	54-198	64-198	74-198
5	1	WASHER	34-199	44-199	54-199	64-199	74-199
6	1	THREAD LOCKER	LOCTITE #243 or PERMATEX BLUE PX#24325 (Not Shown)				



			C	OIL SPECIFICATION UPDATE, PUR #518	LTL	9/10/12	HOLLISTER-WHITNEY ELEVATOR CO. LLC				
			B	ADD PERMATEX & 34 MACHINE, PUR #439	LTL	2/14/11					
D	UPDATE, LOCTITE #243 WAS #2440, PUR #1034	LTL	12/11/18	A	CLAMP SCREW TORQUE UPDATED PUR #231	LTL	9/4/03	TITLE PARTS LIST & INSTALLATION INSTRUCTION - #7400 SERIES THRUST BEARING w/ LOCK COLLAR			
THIS DRAWING IS SUPPLIED AS A REPRESENTATION OF THE EQUIPMENT HOLLISTER-WHITNEY ELEVATOR CO. LLC ("MANUFACTURER") HAS AGREED TO SUPPLY. SLIGHT ADJUSTMENTS MAY OCCUR DURING MANUFACTURING AND INSTALLATION. ANY MODIFICATIONS NOT APPROVED IN WRITING BY MANUFACTURER MAY AFFECT OPERATION, VOIDS ANY WARRANTY AND RELEASES MANUFACTURER OF ALL LIABILITY. THIS DOCUMENT CONTAINS CONFIDENTIAL AND PROPRIETARY INFORMATION THAT CANNOT BE REPRODUCED OR DIVULGED, IN WHOLE OR IN PART, WITHOUT WRITTEN AUTHORIZATION FROM THE MANUFACTURER.				THIRD ANGLE PROJECTION			DRAWN BY LTL		SCALE 1 / 2	MATERIAL SEE PARTS LISTS	REFERENCE TOL. ALL DIMENSIONS REFERENCE UNLESS OTHERWISE SPECIFIED
							SHEET SIZE A		DATE 6/19/2003		E-126 SHEET 1 OF 2

Machine	Thrust Bearing	CONDITIONING Worm Threads, Nut Torque	FINAL Worm Nut Torque	Collar Clamping Screw Torque	Thrust Cap Bolt Torque
34	#7405	250 ft-lbs	75 ft-lbs	14 ft-lbs (170 in-lbs)	23 ft-lbs
43/44/44F	#7406	350 ft-lbs	95 ft-lbs	14 ft-lbs (170 in-lbs)	55 ft-lbs
53/54	#7407	350 ft-lbs	125 ft-lbs	14 ft-lbs (170 in-lbs)	55 ft-lbs
63/64	#7409	350 ft-lbs	200 ft-lbs	14 ft-lbs (170 in-lbs)	110 ft-lbs
74	#7413	550 ft-lbs	375 ft-lbs	27 ft-lbs (325 in-lbs)	200 ft-lbs



1. Drain and thoroughly clean gear housing, thrust bearing housing, and thrust cap. The face of the shoulder on worm shaft must project beyond bearing face on bearing housing.
2. Place the STAMPED faces of outer races of thrust bearings together and assemble on worm shaft as shown.
3. Install washer on worm shaft. Make sure the bore chamfer on washer is toward bearings. Install and torque nut according to the CONDITIONING TORQUE on chart above to condition the worm threads. Back nut off and remove.
4. Clean threads of nut and worm thoroughly with a non-oil based cleaner and let dry completely.
5. Apply provided Thread Locking Adhesive (Loctite #243 or Permatex Threadlocker Blue PX#24325) to worm threads where nut will be located.
6. Re-install nut and re-torque to the FINAL TORQUE value specified in the chart above.
7. Install new lock collar provided. Snug down collar against nut by tapping spanner wrench handle lightly with a brass hammer. Tighten clamping screw on collar to value specified in chart above.
8. Install just enough shims between thrust cap and housing to eliminate ALL axial end play in worm shaft. Remove one shim and torque thrust cap bolts per chart (0.001" to 0.007" preload on outer races is recommended).
9. After unit is completely re-assembled, and before starting machine, fill gear housing to correct oil level with worm gear oil of approved specification (See Lubrication Instructions Bulletin #1150).
10. Before restoring car to service, slightly back off all thrust bearing cap bolts temporarily, and run EMPTY car for several trips. Re-tighten cap bolts to specified torque value and place car into regular service.

					HOLLISTER-WHITNEY										
					ELEVATOR CO. LLC										
					TITLE PARTS LIST & INSTALLATION INSTRUCTION - #7400 SERIES THRUST BEARING w/ LOCK COLLAR										
					SEE PAGE 1 OF 2 FOR REVISION HISTORY		DRAWN BY LTL		SCALE 1 / 2		MATERIAL SEE PARTS LISTS		REFERENCE TOL. ALL DIMENSIONS REFERENCE UNLESS OTHERWISE SPECIFIED		
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