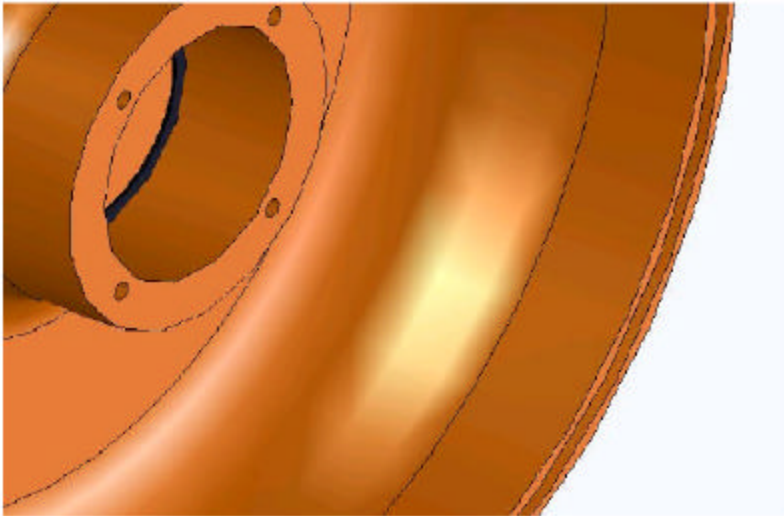


Shaver-Kudell Insulated Sleeve Assembly Instructions

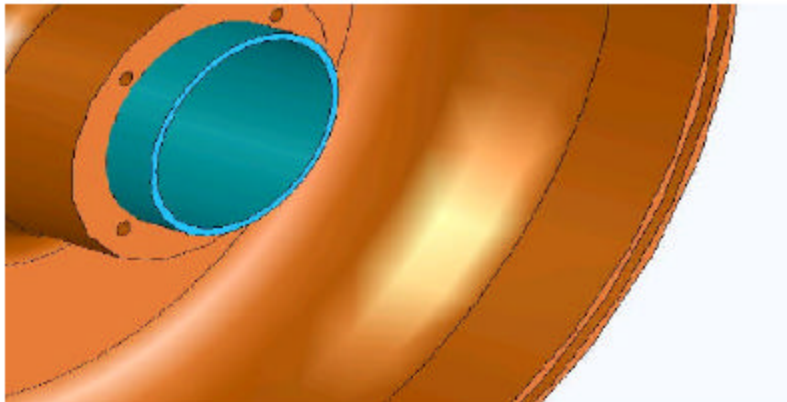
With or Without A Bearing Cap

1. Important: Do not machine sleeve until it is installed in the end bell. Bore the housing until the insulated sleeve will actually slide in. This should be a 0.008" to 0.010" slide fit.
2. Machine the back face .0625 (1/16") deeper to allow for the nylon spacer.
3. Install the nylon spacer. Clean sleeve with acetone, then prepare the sleeve as per "Loctite 620" instructions and slide into position. After "Loctite" has cured (approx 24hrs), machine the sleeve bore.
4. If a bearing retainer is used it must be insulated, use the second washer and machine according to the following slides.



Install bottom washer into bored end bell.

1



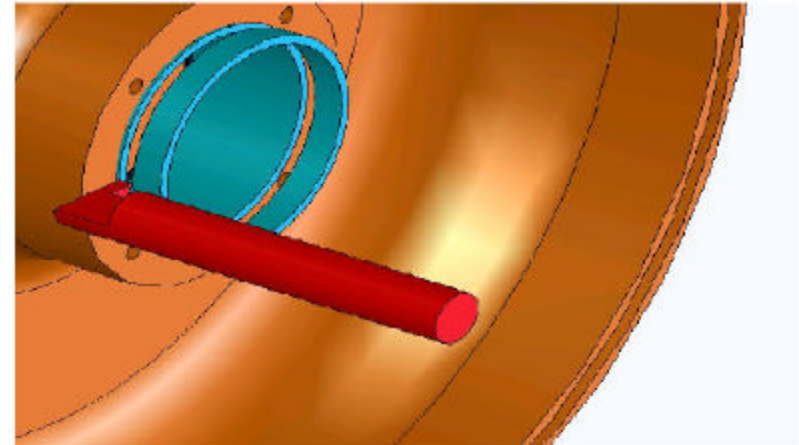
Loctite the insulated sleeve into the prepared bore. Allow sleeve to set before boring the I.D. Bore out the I.D. of the sleeve to suit the new bearing that you will be installing later.

2



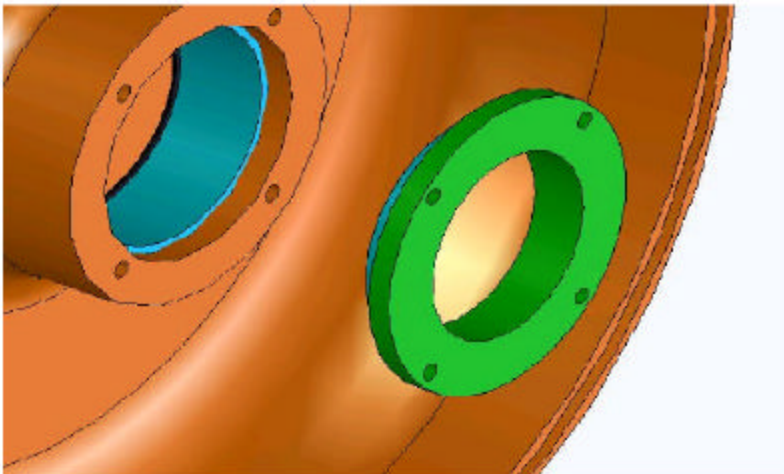
Remove 1/16" from bearing cap face to allow for the top washer.

3



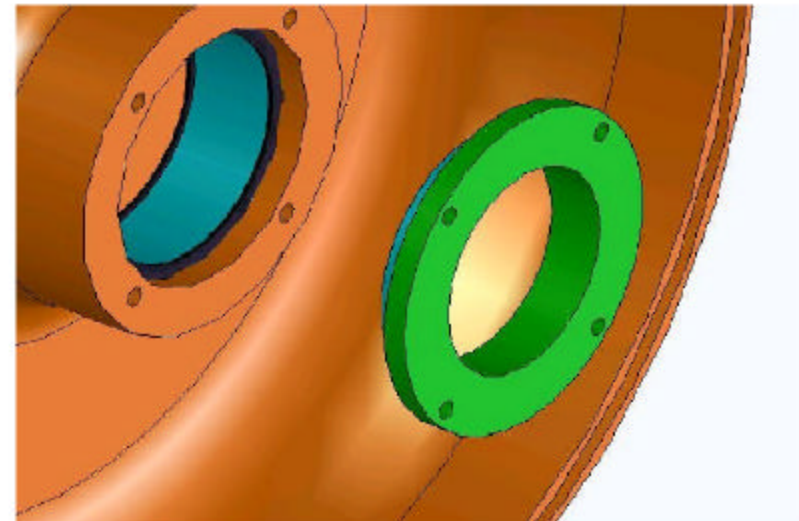
Part off a portion of the protruding sleeve equal to the length required to suit the bearing cap. This piece will be used as a spacer to locate the bearing cap on center.

4



Add the spacer to the bearing cap as shown. Face bore the top of the sleeve to the required depth.

5



Install the top washer as shown.

6