



SERVICE INSTRUCTIONS FOR THE RE [530 & 531] SERIES MOTORS

For Use With Seal Kits: 500444004 & 700666000

dimensions: mm [in]

Housing/shaft disassembly and assembly

NOTE - These instructions are intended to service all RE motors with 1.5" Bearings. However, there are slight differences in the bearing/seal assemblies of these motors. It is important that you determine which motor type you have before servicing so that you can turn to the appropriate section. The section headings list each housing flange type. The housing number is the 7th - 9th alpha-numeric digit in the model code, which is located on the tag on the rear of the motor. If the tag is missing, the exploded views may be used to determine which housing type you have.

SECTION 1. "R" FLANGE MOTORS (ex. 530300R3131AAAAA)

- A) Remove all shaft related components from shaft (26) (i.e. Keys, wire rings, nuts, etc.). Secure motor in vise by clamping onto housing. Remove retaining snap ring (9) from groove in pilot of housing (14). Lift shaft/bearing assembly from housing (14) then remove bearing spacer (10), bearing (11), thrust bearing (13) and two thrust washers (12) from shaft (26).
- B) Being careful not to drop any rolls from bearing (11), pry out shaft seal (5), backup seal (4), and dust seal (1) from bearing assembly (11). (Note: metal backup ring (3) may or may not come out of bearing (11). It is not necessary to remove the metal backup ring (3) from the bearing (11) to service the motor.) Remove high pressure seal (2) from groove in pilot of housing (14) discard shaft seal (5), backup seal (4) dust seal (1) and high pressure seal (2).

At this point, all parts should be cleaned in a oil-based solvent and dried using compressed air (for safety, observe all Osha Safety Guidelines). All new seals should be lightly coated with clean oil prior to installation.

- C) Install high pressure seal (2) into groove in pilot of housing (14). Place shaft (26) on a clean, flat surface with output end facing up. Place thrust washer (12), thrust bearing (13) and second thrust washer (12) over shaft (26). Being careful not to cut seal on keyway, place shaft seal (5) over shaft (26) making sure that lip on seal faces down (see figure 2). Repeat process for backup seal (4) making sure that lip faces down. If metal backup ring (3) came out of bearing (11), place over shaft (26) making sure that large O.D. side faces down. Lightly grease bearing (11) if needed. Place bearing (11) over shaft making sure that the large O.D. side faces down. Using an arbor press, carefully press bearing (11) down to press seal assembly (3-5) into bearing (11).
- D) Place shaft (26) assembly into housing (14). Install dust seal (1) over shaft (26) with lip facing up (see figure 1) and carefully press the seal down to seat it in the bearing (11). Place bearing spacer (10) over shaft (26) and push down until snap ring groove is visible. Install retaining snap ring (9) into groove in housing pilot (14). (Note: it may be necessary to lightly tap the retaining snap ring (9) and bearing spacer (10) to allow the retaining snap ring (9) to seat properly.) Replace all shaft related components (i.e. keys, wire rings, nuts).
- E) See section 4 for motor disassembly and assembly.

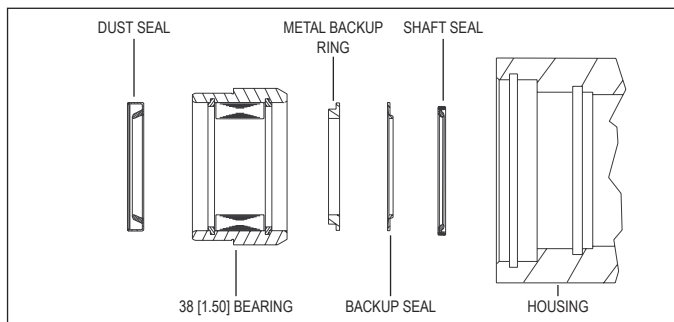


FIGURE 1

- | | |
|-------------------------|--------------------------|
| 1. * Dust Seal | 13. Thrust Bearing |
| 2. * High Pressure Seal | 14. Housing |
| 3. * Metal Backup Ring | 15. Rear Housing Bearing |
| 4. * Backup Seal | 26. Shaft |
| 5. * Shaft Seal | 27. Shaft Key |
| 9. Retaining Snap Ring | 28. Shaft Nut |
| 10. Bearing Spacer | |
| 11. 1.5" Bearing | |
| 12. Thrust Washers (2) | |
- * Contained in Seal Kit 700666000

