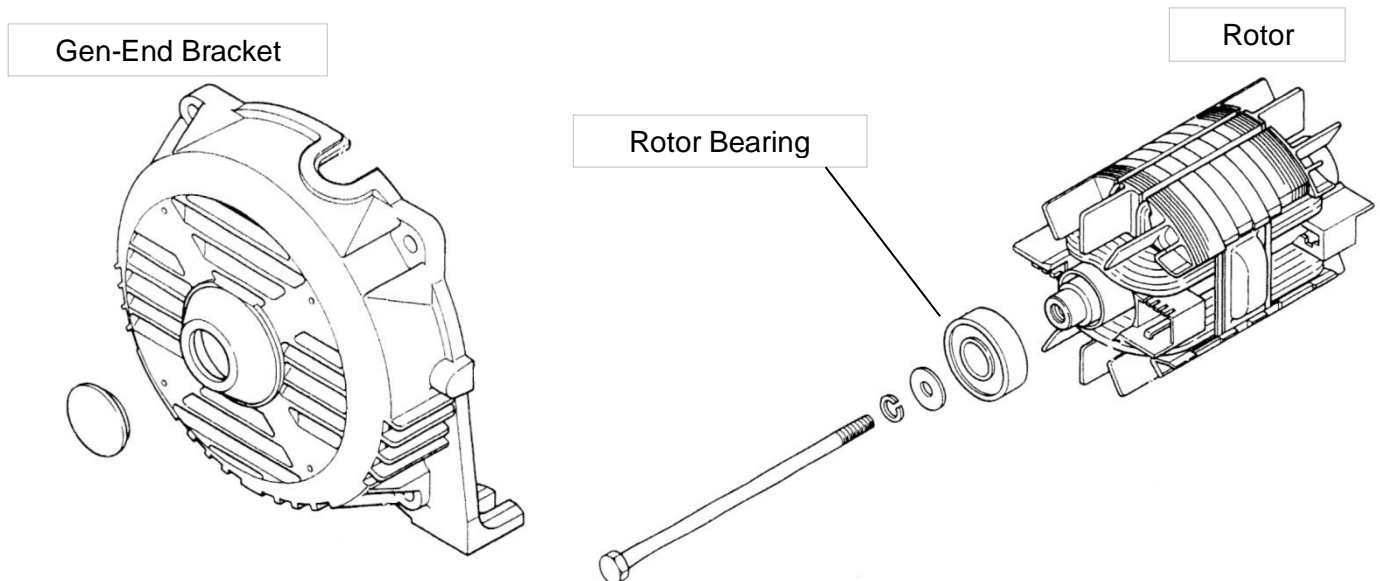


## GENERATOR END BEARING INSTALL

During installation of the generator end (gen-end) it is suggested to install the rotor bearing into the (gen-end) bracket first when assembling the (gen-end) to prevent an incorrect bearing installation.

- Install rotor bearing onto the gen-end bracket.
- Install gen-end bracket onto the rotor.
- Install gen-end bracket/bearing/rotor as complete assembly on to the engine shaft.



It has been noted when incorrectly installed failures that occur:

- Bearing creep: The bearing will become loose and move within the gen-end bracket.
- Bracket damage: The bearing seat becomes damaged during install not allowing the bearing to seat flush in the dedicated area.



The following should be done by a qualified technician with extreme caution using eye protection and proper safety gear.

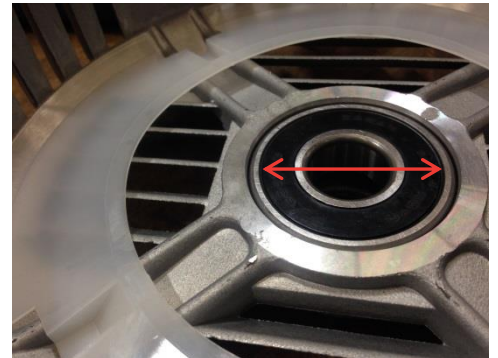


See notes on next page

- Clean both bearing and end bracket before assembling.



- Install bearing into gen-end bracket by using a properly sized bearing driving tool.

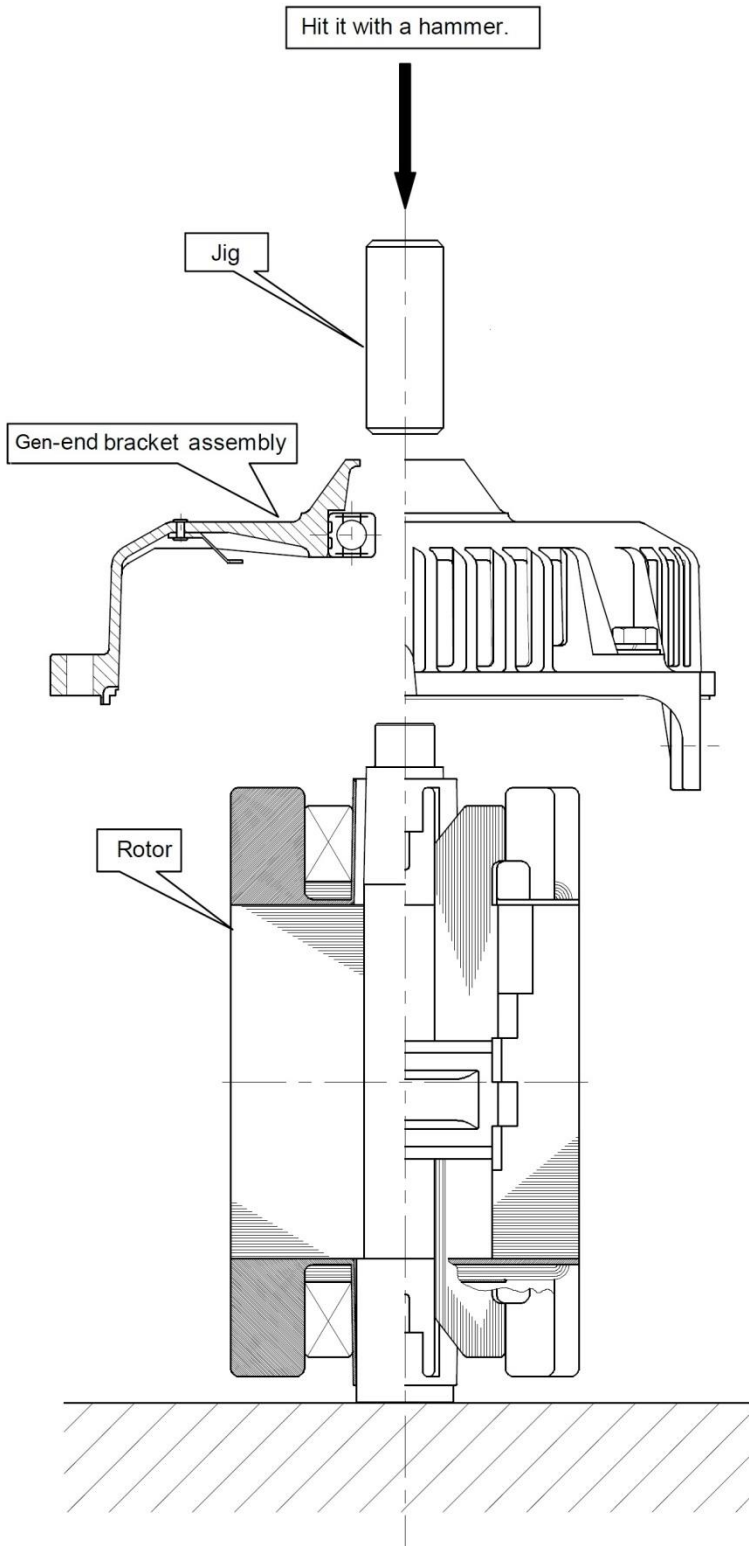


- Insertion is complete when the bearing becomes flush with the gen-end bracket.

- Install gen-end bracket / bearing together as a unit onto rotor.

See next page for details





- After installing bearing onto gen-end bracket.
  - Place rotor vertically on a flat horizontal surface.
  - Allow the gen-end bracket assembly to lightly contact the rotor shaft.
  - Install gen-end bracket / bearing onto rotor
- NOTE:** Use properly sized bearing drive tool through the round hole of the gen-end bracket to tap bearing onto the rotor.
- Insertion is complete when the bearing becomes flush with the end of rotor shaft.

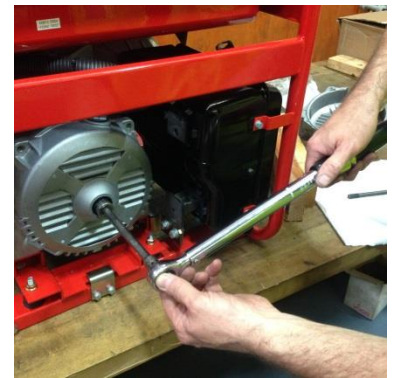




- Install completed assembly onto engine shaft and tighten rotor bolt to spec.



- Rotor bolt torque specification
  - Torque spec: 15.6 to 19.1 ft. lbs



- Gen-end bracket bolts torque specification.
  - Torque spec: 9 to 9.5 ft. lbs



- Install gen-end dust cover grommet and ground cable.

