General Installation Procedure Maritex AQUARIUS Grade Bearing.

Pre- condition:
Drive train is free of pre-existing alignment issues.
Bearing carrier surface is clean, dry and free of corrosion.
Shaft is ground smooth and within 0.1mm straightness.

Procedure:
1 Confirm bearing(s) length matches bearing carrier(s) length.
Confirm bearing carrier(s) diameter.
Machine bearing(s) OD so that:
BEARING O.D. = CARRIER I.D. MINUS 0.2 ~ 0.3mm

2 ENSURE BEARING(S) CAN FREELY ROTATE WHEN FULLY IN CARRIER(S).

3 Make temporary support to prevent FWD bearing exiting carrier during shaft installation. **Important.**

4 Select a flat clean board with surface dimensions approx 400mm x 400mm.
Mix a minimum 100ml or 100g batch of Selley's Araldite 24 Hr Super Strength epoxy or equivalent.
Insert the freshly mixed epoxy resin into the forward end of a bearing carrier. This is to allow gravity to help spread the resin.
5 Select a ½ length broomstick handle. Using the handle spread resin to completely cover the carrier inside surface. Use the mixing board to catch and reuse any resin dripping from the carrier.
Employing a technique similar to applying paint to a paint roller carefully roll the first bearing over the board, coating the entire bearing outside surface with freshly mixed resin.

6 Immediately press the bearing into carrier. This is best done slowly with steady hand pressure.
Make sure at the same time the board is carefully positioned under the bearing so that dripping resin is automatically returned to the board.

7 For a second bearing and if deemed necessary make more resin by adding fresh epoxy parts A & B to the already mixed resin thoroughly re-mix. Return to 4.

8 Remove excess resin, especially resin that has entered the bearing sliding surface and waterways.
USE ONLY CLEAN DRY CLOTH TO REMOVE EXCESS EPOXY RESIN.
NEVER USE SOLVENT AS THIS MAY COMPROMISE THE BEARING BOND.

9 DO NOT IMMEDIATELY INSTALL A SHAFT. LIQUID EPOXY MUST BE ALLOWED TIME TO THICKEN.
In order to check on the cure keep unused epoxy at same ambient temperature and away from direct sunlight and test every ten minutes until the resin thickens and becomes non-slumping.

10 Insert the shaft and once fully inserted remove fwd bearing temporary support.