

ASSEMBLY INSTRUCTIONS FOR WALTER BUSHES

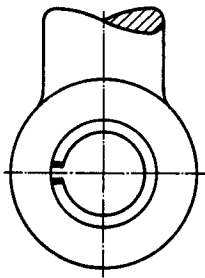


Fig.1

When inserting the BUSH attention should be paid to the positioning. The slot must be located perpendicularly to the stress direction (Fig.1).

Once the BUSH is inserted, the wedge-shaped pin is plugged into the slot and pressed down by hand. The pin is driven home by light hammer blows until it correctly meets the tapered slide-way. Heavier blows will drive the pin completely home until it is upset. It is advisable to grease the square pin to reduce friction between pin and BUSH and the risk of deforming the pin.

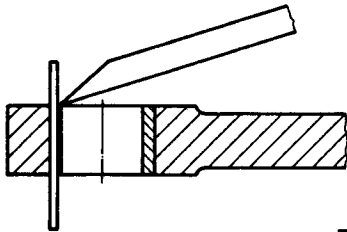


Fig.2

Driving the pin home vigorously is a fundamental condition of the correct assembling of WALTER BUSHES.

Protruding parts of the pin (normally at both ends) should be removed immediately by chiseling (Fig.2). Edges may be removed by filing.

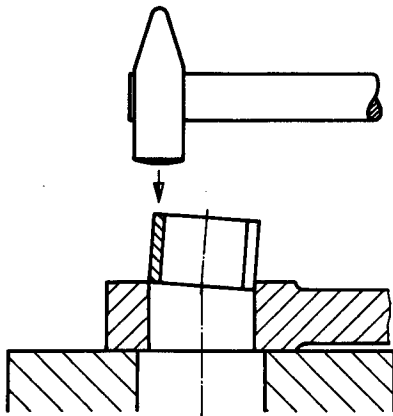


Fig.3

BUSHES protruding from the bearing are not allowed, because parts of them may unexpectedly break off due to their hardness.

Expanded bushes are put on top of the bore, slightly inclined to the axis, and will slip in due to their elasticity. They may be inserted by light hammer blows afterwards (Fig.3).

Contracted BUSHES will be widened sufficiently by means of the introduced pin until they will slip into the bore smoothly (Fig.4).

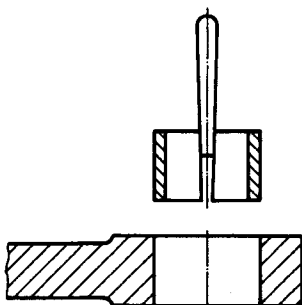


Fig.4

The process of hardening may enlarge or contract the cross-section of the BUSH. The dimensional accuracy of the BUSH can only be inspected in fitted in condition after the assembly has been finished.

When a BUSH has to be exchanged, only the pin has to be punched out. Then the BUSH can be removed easily. Finally a new BUSH will replace the previous one and no redressing of the bore whatsoever will be required.