



VACGEN

Assembly Guide

MLRD/MLD Front Bearing Assembly

AS0031

VGS03-02T31



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DISCLAIMER

This Assembly Guide should be used in conjunction with the owner's manual where available, and is intended as a guide only as there may be variations between versions and therefore must be used at the Owner's Risk. For more detailed assistance, please contact our Support desk +44 (0) 1323 379 335 or support@vacgen.com.

HEALTH AND SAFETY

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Revision	Date	Comment	Initials
1			
2			
3			

Unit A, Swallow Business Park
Diamond Drive, Lower Dicker
Hailsham, East Sussex
BN27 4EL, UK



MLRD/MLD Front Bearing Assembly

Before you start, mark flanges to keep same orientation when reassembling.

1. Remove the sample transfer end.
2. Undo the six bolts holding chamber to the tube.
3. Pull the chamber off the tube and you will now see the back of the casting that holds the bearings.
4. **IMPORTANT:** Note the orientation the housing comes off the shaft, as one bearing is offset for adjustment and this one rolls on the flat of the shaft.
5. Mark the housing and the casting orientation, then remove three screws and pull out the housing casting.
6. On the end of the housing casting there are three holes with a grub screw in each hole, remove these to release the pins that hold the bearings.
7. Push the pins and the cam out, noting the washer positions
8. Replace the bearings

Refitting:

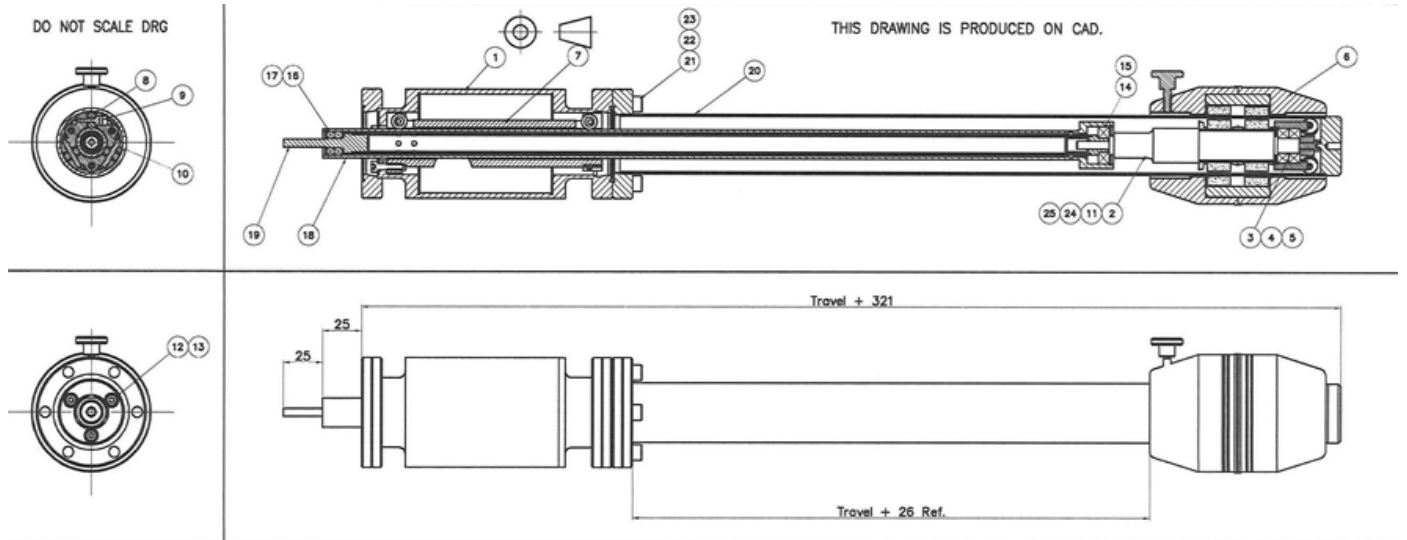
1. Four bearings are on fixed position pins and two are on cams, the cams should be adjusted so the bearings are in contact with the shaft, but not loaded.
2. Assemble bearings and check the bearing housing movement over the whole length before fitting back into the chamber.
3. Adjust as required for the optimum smoothness of movement.
4. Refit in the same orientation.
5. When doing up the flange bolts, make sure these are even as you tighten and check the movement is still smooth as you tighten.

Note that the final flange position may not be parallel to get the smooth movement, owing to tolerances in the welding etc. giving an off set.



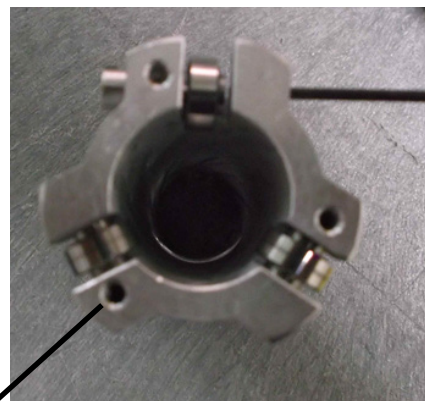
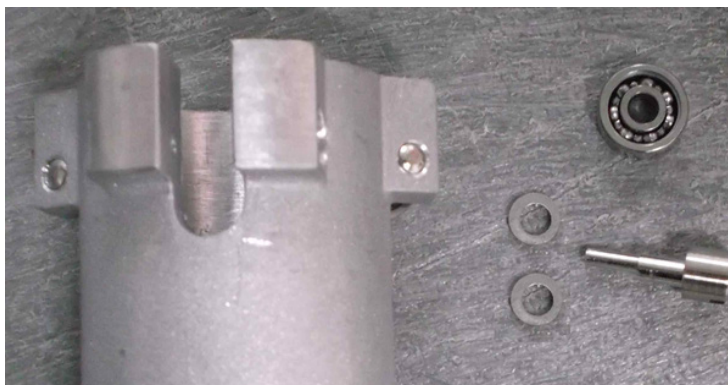
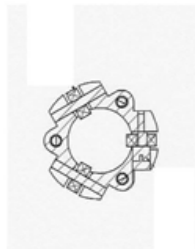
DRAWINGS

Bearing Set Part Code: MLDBS



DC2410	-	-	-	-	-
DC2409	-	-	-	-	-
DC2408	-	-	-	-	-
DC2407	-	-	-	-	-
DC2406	-	-	-	-	-
DC2405	MLRD209	DC2440	DC2420	DC2460	914 (36")
DC2404	-	-	-	-	-
DC2403	MLRD208	DC2438	DC2418	DC2458	610 (24")
DC2402	MLRD204	DC2437	DC2417	DC2457	480 (18")
DC2401	MLRD203	DC2436	DC2416	DC2456	306 (12")
Drw No:	MODEL	ITEM A	ITEM B	ITEM C	TRAVEL

25	SCREW SET M2x4	\$ 2
24	CORE MAGNET ASSEMBLY	1
23	GASKET COMMERCIAL (10)	0.1
22	WASHER PLAIN M6 S/S	\$ 6
21	SCREW CAP HD 6.0x35	\$ 6
20	MLR/MLRD OUTER TUBE	1
19	ROTATION TUBE ASSEMBLY	1
18	GUIDE TUBE ASSEMBLY	1
17	CIRCLIP EH-15 SPIROLOX	1
16	XBEA04 LUB 05:1C	\$ 2
15	CIRCLIP EH-24 SPIROLOX	1
14	XBEA034 LUB 05: 1C.	\$ 1
13	WASHER PLAIN M4 S/S A4	\$ 3
12	SCREW CAP HD 4.0x16	\$ 3
11	SCREW CAP M3X6	\$ 8
10	PIN DOWEL 3.0 x 20.0 S.S.	4
9	ECCENTRIC PIN	2
8	XBEA16 LUB 05:1C.	\$ 6
7	CAST HOUSING MACH(10236)P	1
6	MLRV MAG. HOUSING ASSY.	1
5	WASHER SCHNORR M4 x 0.3	\$ 1
4	SCREW CAP HD 4.0x16	\$ 1
3	REAR BEARING ASSEMBLY	1
2	CORE SUPPORT	1
1	HOUSING	1



Grub Screw Access Hole