



**Bearing Staking,
Removal, and Testing**

• request a quote

Cutting Tool Operating Instructions

Operating instructions

1. Separate cutter by unscrewing locking nut ⁽¹⁾ and removing washer ⁽²⁾ and locating cap ⁽³⁾.
2. Insert connecting ⁽⁵⁾ shaft through bearing bore ⁽⁴⁾ and reassemble tightening locking nut ⁽¹⁾
3. Holding pressure nut ⁽¹²⁾ tighten clamp nut all the way down.
4. Turn pressure nut ⁽¹²⁾ until teeth exert light pressure on bearing lip.
5. Turn cutter ⁽⁷⁾ until rotating freely (at least one full turn clockwise) and then tighten pressure nut ⁽¹²⁾ 1/8 turn while holding clamp nut ⁽¹³⁾.

Note: Use pin type spanner wrench to turn cutter. The wave spring ⁽¹¹⁾ will insure that the cutter maintains constant pressure.

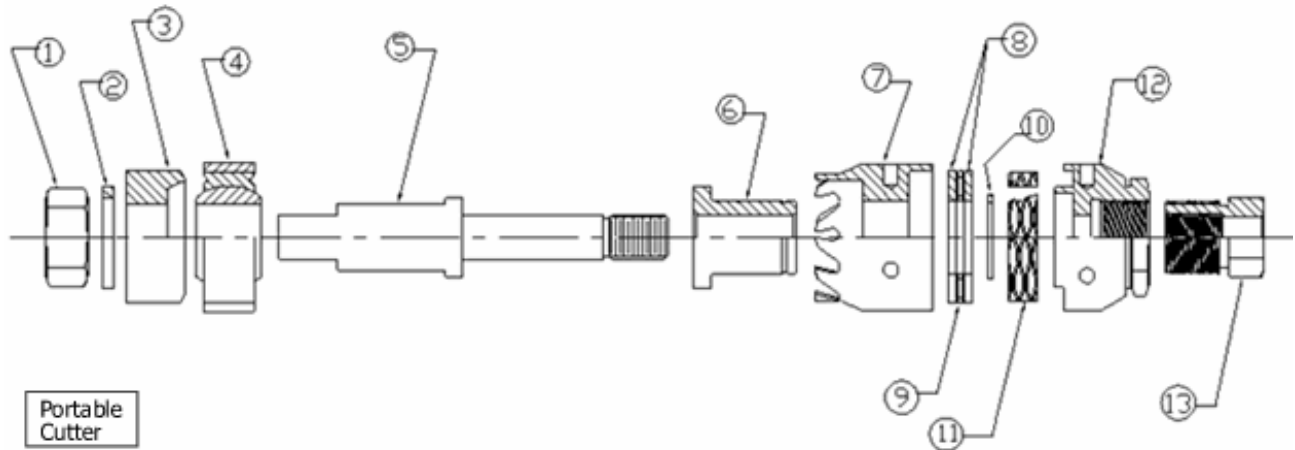
6. Repeat step 5 until cutter has creased bearing lip. Pressure may be increased by turning pressure nut ⁽¹²⁾ clockwise and holding clamp nut ⁽¹³⁾ or by turning clamp nut counter clockwise and holding the pressure nut.

Note: Cutter will bottom out when sleeve flange ⁽⁶⁾ meets connecting flange ⁽⁵⁾. It is not necessary to cut to this depth but teeth are dimension to not cut into housing.

7. Remove tool by unscrewing locking nut ⁽¹⁾ and removing washer ⁽²⁾ and locating cap ⁽³⁾ and disassembling shaft through bearing.
8. Push bearing out of housing using ASIR tool.

NPB Bearings:

- miniature & instrument ball bearings
- aerospace bearings
- spherical plain
- nu & nx bearings
- thin section bearings
- bearing tools
- line card



Portable Cutter Parts List

ITEM NO.	QTY REQ'D	DESCRIPTION	STANDARD
01	1	LOCKING NUT	3/8"-16 STANDARD NUT
02	1	WASHER	7/8"OD x 3/8"ID x 1/8" THK
03	1	LOCATING CAP	
04	1	BEARING	MSJ4101-9
05	1	CONNECTING SHAFT	
06	1	SLEEVE	
07	1	CUTTER	
08	2	NEEDLE BEARING RACE	BDI OR TIMKEN TORRINGTON TRB-1018
09	1	NEEDLE BEARING	BDI OR TIMKEN TORRINGTON NTA-1018
10	1	SNAP RING	SMALLEY FSE-0062
11	1	WAVE SPRING	SMALLEY CREST TO CREST CS112-HJ
12	1	PRESSURE NUT	
13	1	CLAMP NUT	

Bearing Tools Contact: [Bruce Dumas](#)

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