

INSTRUCTION MANUAL  
FOR  
**DODGE® SAF-XT & SAFS**  
**Pillow Blocks**  
All Sizes 1<sup>15</sup>/<sub>16</sub>" through 10<sup>1</sup>/<sub>2</sub>"  
2 and 4 Bolt Base



**WARNING:** Because of the possible danger to person(s) or property from accidents which may result from the improper use of products, it is important that correct procedures be followed: Products must be used in accordance with the engineering information specified in the catalog. Proper installation, maintenance and operation procedures must be observed. The instructions in the instruction manuals must be followed. Inspections should be made as necessary to assure safe operation under prevailing conditions. Proper guards and other suitable safety devices or procedures as may be desirable or as may be specified in safety codes should be provided, and are neither provided by Baldor Electric Company nor are the responsibility of Baldor Electric Company. This unit and its associated equipment must be installed, adjusted and maintained by qualified personnel who are familiar with the construction and operation of all equipment in the system and the potential hazards involved. When risk to persons or property may be involved, a failsafe device must be an integral part of the driven equipment beyond the speed reducer output shaft.

## INSPECTION

Inspect shaft. Ensure that the shaft is smooth, straight, clean and within commercial tolerances.

Inspect bearing. Do not allow bearing to be exposed to any dirt or moisture. Do not remove slushing compound as it acts as both a protectant and lubricant and is also compatible with standard greases.

## INSTALLATION

### WARNING

To ensure that drive is not unexpectedly started, turn off and lock out or tag power source before proceeding. Failure to observe these precautions could result in bodily injury.

**NOTE: Housing caps and bases are not interchangeable, they must be matched with mating half. Install non-expansion bearing first.**

1. Apply a light coating of spindle oil to the adapter area of the shaft.

2. **Measure the internal clearance of the bearing before mounting.** Place the bearing in an upright position as shown in **Figure 1**. Seat the inner ring and roller elements by pressing down firmly on the inner ring bore while rotating the inner ring a few times. Position the roller assemblies so that a roller is at the topmost position on both sides. Press these top rollers inward ensuring contact with center guide flange (above 6 1/2" only). Using a feeler gage measure the clearance for both sides by inserting as far as possible and sliding over top of roller (Figure 1). Write down the measured clearance for use in step 3d. **NOTE:** Do not rotate bearing when moving feeler between roller and outer ring.



**Figure 1 — Internal Clearance**

3. Install the bearing parts in the following sequence: (refer to Figure 3). **NOTE:** Bearing can only be correctly installed one way. Refer to **Figure 2** on page 4.

**a) V-ring Seal** — Slide one of the V-ring seals onto the shaft **making sure lip is toward the bearing**. Set aside until step 11. **NOTE: Do not install V-ring seal on seal ring until housing cap has been set in place and tightened.**

**b) Seal Ring** — Install a seal ring on shaft with the largest O.D. toward bearing.

**c) Adapter** — Slide adapter onto the shaft, threaded end outboard to the approximate location of the bearing. Apply light coating of oil to sleeve O.D. **Do not use grease.**

**d) Bearing** — Make sure that the internal clearance has been written down. Install bearing on adapter sleeve, large end of tapered bore first. Locate bearing in proper position on shaft. Before tightening refer to **Figure 2** and Table 4 on page 4.

**e) Lockwasher and Locknut**—Install the lockwasher (8" and smaller sizes only) on the adapter with inner prong located in the slot and toward the bearing. Install locknut, chamfered face toward bearing.

Tighten locknut using a spanner wrench and hammer until clearance noted in step 2 is **reduced by** amount shown in Table 1. During this step shaft should be supported so all weight is off of the bearing.

Find a lockwasher tab that aligns with a locknut slot and bend tab into slot. If slot is past tab then tighten, not loosen, locknut to meet a washer tab. Sizes larger than 8" require a lockplate bolted to the locknut with the inner prong of the plate located in the slot of the adapter sleeve. If necessary, tighten, not loosen, locknut to allow prong to fit in adapter slot. Lock plates for only the 9" must be hand fitted on the job.

**Table 1 — Internal Clearance Reduction**

Shaft Diameter	Reduction in Internal Clearance
1 <sup>15</sup> / <sub>16</sub> , 2 <sup>3</sup> / <sub>16</sub>	.0012/.0015
2 <sup>7</sup> / <sub>16</sub> , 2 <sup>1</sup> / <sub>2</sub> , 2 <sup>11</sup> / <sub>16</sub> , 2 <sup>3</sup> / <sub>4</sub>	.0015/.0020
2 <sup>15</sup> / <sub>16</sub> , 3, 3 <sup>3</sup> / <sub>16</sub> , 3 <sup>7</sup> / <sub>16</sub> , 3 <sup>1</sup> / <sub>2</sub>	.0018/.0025
3 <sup>15</sup> / <sub>16</sub> , 4, 4 <sup>3</sup> / <sub>16</sub>	.0020/.0028
4 <sup>7</sup> / <sub>16</sub> , 4 <sup>1</sup> / <sub>2</sub> , 4 <sup>15</sup> / <sub>16</sub> , 5	.0025/.0035
5 <sup>3</sup> / <sub>16</sub> , 5 <sup>7</sup> / <sub>16</sub> , 5 <sup>1</sup> / <sub>2</sub>	.0030/.0040
5 <sup>15</sup> / <sub>16</sub> , 6, 6 <sup>7</sup> / <sub>16</sub> , 6 <sup>1</sup> / <sub>2</sub>	.0030/.0045
6 <sup>15</sup> / <sub>16</sub> , 7	.0035/.0050
7 <sup>1</sup> / <sub>2</sub> , 7 <sup>15</sup> / <sub>16</sub> , 8	.0040/.0055
8 <sup>7</sup> / <sub>16</sub> , 8 <sup>1</sup> / <sub>2</sub> , 8 <sup>15</sup> / <sub>16</sub> , 9	.0045/.0060
9 <sup>7</sup> / <sub>16</sub> –10 <sup>1</sup> / <sub>2</sub>	.0045/.0065

f) **Seal Ring** — Install a second seal ring with large O.D. toward locknut.

g) **V-Ring Seal** — Slide second V-ring seal onto the shaft, again making certain lip is toward bearing.  
**NOTE: Do not install V-ring seal on seal ring until housing cap has been set in place and tightened.** See Step 11.




4. Remove any paint, dirt or burrs from the mating surfaces of the housing halves. Thoroughly clean seal grooves on both sides. Set lower half of housing on base with all four cap bolts in place and apply oil to the bearing seats. Apply grease to the seal grooves in the lower housing. **Be sure the housing is positioned as shown in Figure 2 view relative to adapter nut.**

5. Apply grease to the bearings and seal rings. The lubricant should be smeared between the rolling elements (see Grease Lubrication section).

6. Place shaft with bearing into lower half while carefully guiding the seal rings into the housing grooves as shown in **Figure 4**.

7. Bolt lower half of the non-expansion bearing housing to the base. Move shaft endwise so that stabilizing ring can be inserted between the bearing outer ring and the lower half shoulder on same side as the locknut. Make all other bearings on same shaft expansion by centering in the middle of their housing seat. Bolt expansion housings to base. **NOTE: Only one bearing per shaft is nonexpansion; other bearings should be expansion.**

**Table 2 – Recommended Torque Values, Ft.-Lbs.**

	Housing Cap Bolt Size	7/16-14	1/2-13	5/8-11	3/4-10	7/8-9	1-8	1 1/4-7
	Grade 2	28-32	40-50	80-100	140-175	136-170	200-250	400-500
	Grade 5	40-50	60-75	120-150	208-260	344-430	512-640	880-1100
	Grade 8	56-70	88-110	168-210	304-380	480-600	728-910	1456-1820

8. When closed end is required, the end plug supplied should be fit into the center seal ring groove of the housing (see **Figure 4**).

9. Grease the bearing seal grooves in the housing cap and place over the bearing after wiping the mating surfaces. The two dowel pins will align the cap with the lower housing half. **NOTE: Each cap must be matched with its mating lower half as these parts are not interchangeable.**

10. Tighten cap bolts to the recommended torque in Table 2.

11. Assure that there is seal running clearance then install V-ring seals onto the seal rings as shown in **Figure 4** and coat V-ring seals with grease.

12. Misalignment of pillow blocks must not exceed values shown on Table 3 below.

**Table 3 – Static or Dynamic Allowable Misalignment Degrees Spherical Roller Bearings**

SHAFT SIZE	BLOCK SIZE	TRIPLE-TECT SEALS	LER	AUXILIARY SEAL
1 <sup>15</sup> / <sub>16</sub>	511	1°08´	0°52´	0°35´
2 <sup>3</sup> / <sub>16</sub>	513	1°01´	0°55´	0°32´
2 <sup>7</sup> / <sub>16</sub> -2½	515	0°59´	0°50´	0°28´
2 <sup>11</sup> / <sub>16</sub> -2¾	516	0°52´	0°52´	0°26´
2 <sup>15</sup> / <sub>16</sub> -3	517	0°48´	0°52´	0°25´
3 <sup>3</sup> / <sub>16</sub>	518	1°06´	0°51´	0°32´
3 7/16-3½	520	1°03´	0°46´	0°30´
3 <sup>15</sup> / <sub>16</sub> -4	522	0°55´	0°42´	0°28´
4 <sup>3</sup> / <sub>16</sub>	524	0°49´	0°41´	0°27´
4 7/16-4½	526	0°56´	0°44´	0°26´
4 <sup>15</sup> / <sub>16</sub> -5	528	0°55´	0°40´	0°24´
5 <sup>3</sup> / <sub>16</sub>	530	—	0°35´	0°22´
5 7/16-5½	532	0°47´	0°34´	0°22´
5 <sup>15</sup> / <sub>16</sub> -6	534	0°43´	0°32´	0°22´
6 7/16-6½	536	0°33´	0°23´	0°26´
6 <sup>15</sup> / <sub>16</sub> -7	538	0°37´	0°27´	0°25´
7½, 7 <sup>15</sup> / <sub>16</sub> , 8	544	0°31´	0°24´	0°22´
8 7/16-9	048	0°36´	0°25´	0°22´
9 7/16-9½	052	0°26´	0°23´	0°33´
9 <sup>15</sup> / <sub>16</sub> -10½	056	0°28´	0°16´	0°30´

**Table 4 — Bearing  $\odot$  to Housing  $\odot$  Offset — “S” Dimension  
(Expansion brg. located at center of expansion)**

Size	Non-Expansion	Expansion	Size	Non-Expansion	Expansion
1 <sup>15</sup> / <sub>16</sub>	19/64	3/16	5 <sup>3</sup> / <sub>16</sub>	3/4	9/16
2 <sup>3</sup> / <sub>16</sub>	25/64	1/4	5 <sup>7</sup> / <sub>16</sub> –5½	49/64	37/64
2 <sup>7</sup> / <sub>16</sub> –2½	17/64	5/32	5 <sup>15</sup> / <sub>16</sub> –6	25/32	37/64
2 <sup>11</sup> / <sub>16</sub> –2¾	3/8	3/16	6 <sup>7</sup> / <sub>16</sub> –6½	3/4	35/64
2 <sup>15</sup> / <sub>16</sub> –3	3/8	3/16	6 <sup>15</sup> / <sub>16</sub> –7	13/16	5/8
3 <sup>3</sup> / <sub>16</sub>	31/64	19/64	7½	29/32	23/32
3 <sup>7</sup> / <sub>16</sub> –3½	9/16	3/8	7 <sup>15</sup> / <sub>16</sub> –8	29/32	23/32
3 <sup>15</sup> / <sub>16</sub> –4	35/64	3/8	8 <sup>7</sup> / <sub>16</sub> –9	25/32*	25/32
4 <sup>3</sup> / <sub>16</sub>	39/64	27/64	9 <sup>7</sup> / <sub>16</sub> –9½	45/64*	45/64
4 <sup>7</sup> / <sub>16</sub> –4½	41/64	29/64	9 <sup>15</sup> / <sub>16</sub> –10½	7/8*	7/8
4 <sup>15</sup> / <sub>16</sub> –5	11/16	½			

\* One spacer on each side of bearing

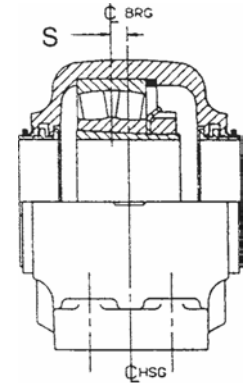


Figure 2

## MAINTENANCE

### WARNING

To ensure that drive is not unexpectedly started, turn off and lock out or tag power source before proceeding. Failure to observe these precautions could result in bodily injury.

Remove housing cap in order to inspect bearing and grease. Before reassembly it is important that the

V-ring seals be removed. This will ensure that seal lip will not be damaged while setting cap in place. Reassemble per installation steps 9 thru 11 above.

**Seal Replacement** — When removing bearing it is recommended that V-ring seals and seal rings be replaced.

**Auxiliary Seals** — Install per instruction sheet #499665.

## GREASE LUBRICATION

SAF-XT and SAFS bearings are specifically designed for dirty, dusty or wet environments. In order to properly protect bearings during installation pack the bearing insert 100% full immediately after having properly mounted bearing on the shaft. If the RPM of the application falls between 20% and 80% of maximum RPM (Table 7), pack the lower half of the housing one-third to one half full. If the RPM of the application is less than 20% of maximum RPM, pack bearing housing cavity 100% full. If the RPM exceeds 80% of maximum RPM, pack 1/3 of the lower half of the housing.

At each regreasing cycle, for applications up to 80% of maximum RPM, slowly add grease until fresh grease is seen purging at the seals.

Regreasing should be done while running. Remote regreasing lines should be added to avoid endangering personnel.

### WARNING

Regreasing requires rotating parts to be exposed. Exercise extreme care during such operations. Failure to observe these precautions could result in bodily injury.

If the RPM is greater than 80% of maximum RPM add 4 strokes of a grease gun at each regreasing cycle for bores up to 2". For bores greater than 2" up to 5" add 8 strokes of a handgun at each regreasing cycle. For bores greater than 5" up to 10 1/2" add 16 strokes of a grease gun at each regreasing cycle. For units running above 80% of maximum RPM, running temperature should be monitored. If a drastic change in running temperature is noted, it is recommended to remove the used grease completely and recharge with

**Table 5 – Viscosity of Oil in the Grease**

DN ▲	Viscosity for Loads Up To 18% of Dyn. Cap.* (SUS @ operating temp.)	DN ▲	Viscosity for Loads Up To 18% of Dyn. Cap.* (SUS @ operating temp.)
100	3500	1400	625
200	3150	1800	450
300	2750	2000	400
400	2375	3000	300
500	2000	4000	200
600	1750	5000	150
700	1500	6000	130
800	1300	7000	110
900	1075	8000	100
1000	900		

▲ DN = Bore Dia. (ins.) x RPM

\* For loads above 18% of dynamic capacity an EP grease with the above viscosity oil is recommended

fresh grease per above instructions.

Select a grease with a viscosity at operating temperature which will provide full film lubrication (see Table 5). Assume 50°-100°F increase in bearing temperature above the ambient, depending on RPM and load.

Use Table 6 as a general guide for regreasing the bearings. A small amount of grease at frequent intervals is preferable to a large amount of grease at infrequent intervals.

For special applications involving high speeds, high temperatures or oil lubrication, consult the factory.

**Table 6 – Regreasing Intervals (Months) (Based on 12 hour per day 150°F max.)**

Size	RPM									
	250	500	750	1000	1250	1500	2000	2500	3000	3500
1 <sup>15</sup> / <sub>16</sub>	8	6	4	3	2	1	.5	.5	.25	.25
2 <sup>3</sup> / <sub>16</sub>	7	5	3	2	1	1	.5	.25	.25	
2 <sup>7</sup> / <sub>16</sub> -3	6	4	3	2	1	.5	.25	.25		
3 <sup>3</sup> / <sub>16</sub> -3½	5	3	2	1	.5	.5	.25			
3 <sup>15</sup> / <sub>16</sub> -4½	4	3	2	1	.5	.25				
4 <sup>15</sup> / <sub>16</sub> -5½	3	2	1	.5	.25					
5 <sup>15</sup> / <sub>16</sub> -7	2	1	1	.5						
7½-9	1	1	.5							
9 <sup>7</sup> / <sub>16</sub> -10½	1	.5								

**Table 7 – Maximum RPM (Grease Lubrication)**

SHAFT SIZE	BASIC BEARING DESCRIPTION	MAX. RPM
1 <sup>15</sup> / <sub>16</sub>	22211K	4500
2 <sup>3</sup> / <sub>16</sub>	22213K	3600
2 <sup>7</sup> / <sub>16</sub> , 2 <sup>1</sup> / <sub>8</sub>	22215K	3400
2 <sup>11</sup> / <sub>16</sub> , 2¾	22216K	3200
2 <sup>15</sup> / <sub>16</sub> , 3	22217K	3000
3 <sup>3</sup> / <sub>16</sub>	22218K	2600
3 <sup>7</sup> / <sub>16</sub> , 3½	22220K	2200
3 <sup>15</sup> / <sub>16</sub> , 4	22222K	2000
4 <sup>1</sup> / <sub>16</sub>	22224K	1800
4 <sup>7</sup> / <sub>16</sub> , 4½	22226K	1700
4 <sup>15</sup> / <sub>16</sub> , 5	22228K	1600
5 <sup>3</sup> / <sub>16</sub>	22280K	1500
5 <sup>7</sup> / <sub>16</sub> , 5½	22282K	1400
5 <sup>15</sup> / <sub>16</sub> , 6	22284K	1300
6 <sup>7</sup> / <sub>16</sub> , 6½	22236K	1200
6 <sup>15</sup> / <sub>16</sub> , 7	22288K	950
7½, 7 <sup>15</sup> / <sub>16</sub> , 8	22244K	800
8 <sup>7</sup> / <sub>16</sub> , 8½	23048K	800
8 <sup>15</sup> / <sub>16</sub> , 9		
9 <sup>7</sup> / <sub>16</sub> , 9½	23052K	750
9 <sup>15</sup> / <sub>16</sub> , 10	23056K	700
10 <sup>7</sup> / <sub>16</sub> , 10½		

**LONG-TERM STORAGE OF PRE-ASSEMBLED BEARINGS**

Applications such as conveyor pulleys and fans are shipped to a job site with bearings already mounted to the shafts. Since these units may be stored for long periods of time in unprotected areas subject to rain, dust, etc., bearings should be packed 100% full and so tagged at bearing assembly to prevent contamination or corrosion of the bearings.

Prior to installation on the structure, if the application RPM is greater than 20% of catalog maximum speed, excess grease must be removed to the levels outlined previously. Removal of excess grease must be done in a clean, protected environment.

# REPLACEMENT PARTS FOR SAF-XT PILLOW BLOCKS

**NOTE:** Large cavity of Pillow Block Housing must be on the same side as the locknut.

**NOTE:** Spacer required for Non-Expansion Pillow Blocks. See Chart.

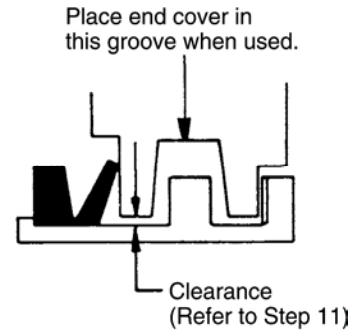
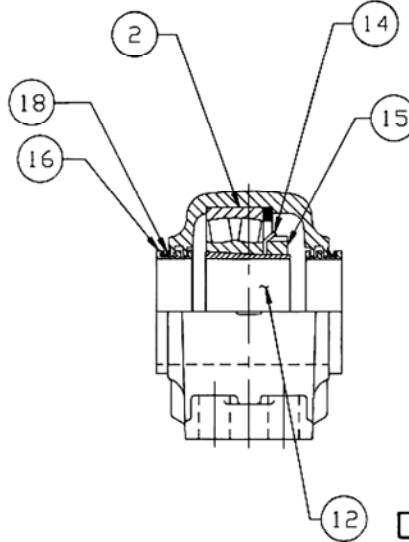
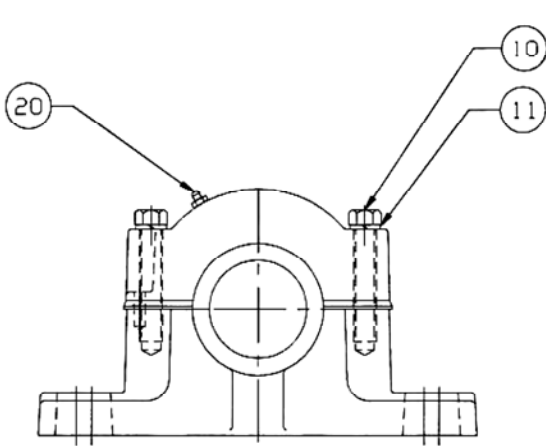


Figure 3

Figure 4

Reference	Name of Part	No. Req'd	Part Numbers														
			1-15/16D	2-3/16D	2-7/16D	2-7/16	2-1/2D	2-1/2	2-11/16D	2-11/16	2-3/4D	2-3/4	2-15/16D	2-15/16	3D	3	3-3/16D
2	Bearing	1	422123	422124	422001	422001	422001	422001	422003	422003	422003	422003	422005	422005	422005	422005	422007
	HOUSING ASSEMBLY*	1	042100	042103	042106	042109	042106	042109	042111	042114	042111	042114	042116	042119	042116	042119	042121
10	Housing Bolt	4	411625	411637	411240	411240	411240	411240	411240	411240	411240	411240	411240	411240	411240	411240	411240
11	Lockwasher	4	419012	419012	419013	419013	419013	419013	419013	419013	419013	419013	419013	419013	419013	419013	419013
12	Adapter	1	042310	042311	041110	041110	041111	041111	041109	041109	041126	041126	041112	041112	041113	041113	041114
14	Lockwasher	1	419182	419183	419150	419150	419150	419150	419152	419152	419152	419152	419154	419154	419154	419154	419156
15	Lock Nut	1	419164	419135	460901	460901	460901	460901	460902	460902	460902	460902	460903	460903	460903	460903	460904
16	Seal Ring	2	042050	042051	042052	042052	042053	042053	042054	042054	042083	042063	042055	042055	042056	042056	042057
18	V-Ring Seal	2	042225	042226	042227	042227	042227	042227	042228	042228	042228	042228	042229	042229	042229	042229	042230
20	Grease Fitting	1	405015	405015	405015	405015	405015	405015	405015	405015	405015	405015	405015	405015	405015	405015	405015
∅	Stabilizing Ring	1	042315	042316	041174	041174	041174	041174	041172	041172	041172	041172	041175	041175	041175	041175	041175

Reference	Name of Part	No. Req'd	Part Numbers														
			3-3/16	3-7/16D	3-7/16	3-1/2D	3-1/2	3-15/16	4	4-3/16	4-7/16	4-1/2	4-15/16	5	5-3/16	5-7/16	5-1/2
2	Bearing	1	422007	422009	422009	422009	422009	422011	422011	422013	422015	422015	422017	422017	422019	422021	422021
	HOUSING ASSEMBLY*	1	042124	042126	042129	042126	042129	042131	042131	042134	042137	042137	042140	042140	042143	042146	042146
10	Housing Bolt	4	411638	411638	411638	411638	411638	411710	411710	411831	411831	411831	411498	411498	411498	411498	411498
11	Lockwasher	4	419013	419014	419014	419014	419014	419016	419016	419016	419014	419014	419016	419016	419016	419016	419016
12	Adapter	1	041114	041115	041115	041116	041116	041117	041118	041119	041120	041121	041122	041123	041124	041125	042318
14	Lockwasher	1	419156	419158	419158	419158	419158	419160	419160	419162	419164	419164	419166	419166	419168	419170	419170
15	Lock Nut	1	460904	460905	460905	460905	460905	460906	460906	460906	460906	460906	460906	460906	460906	460906	460906
16	Seal Ring	2	042057	042056	042058	042059	042059	042060	042061	042062	042063	042064	042065	042066	042067	042068	042069
18	V-Ring Seal	2	042230	042230	042230	042230	042230	042231	042231	042232	042233	042233	042234	042234	042235	042235	042235
20	Grease Fitting	1	405015	405015	405015	405015	405015	405015	405015	405015	405015	405015	405015	405015	405015	405015	405015
∅	Stabilizing Ring	1	041173	041176	041176	041176	041176	041177	041177	041185	041178	041178	041179	041179	041186	041160	041160

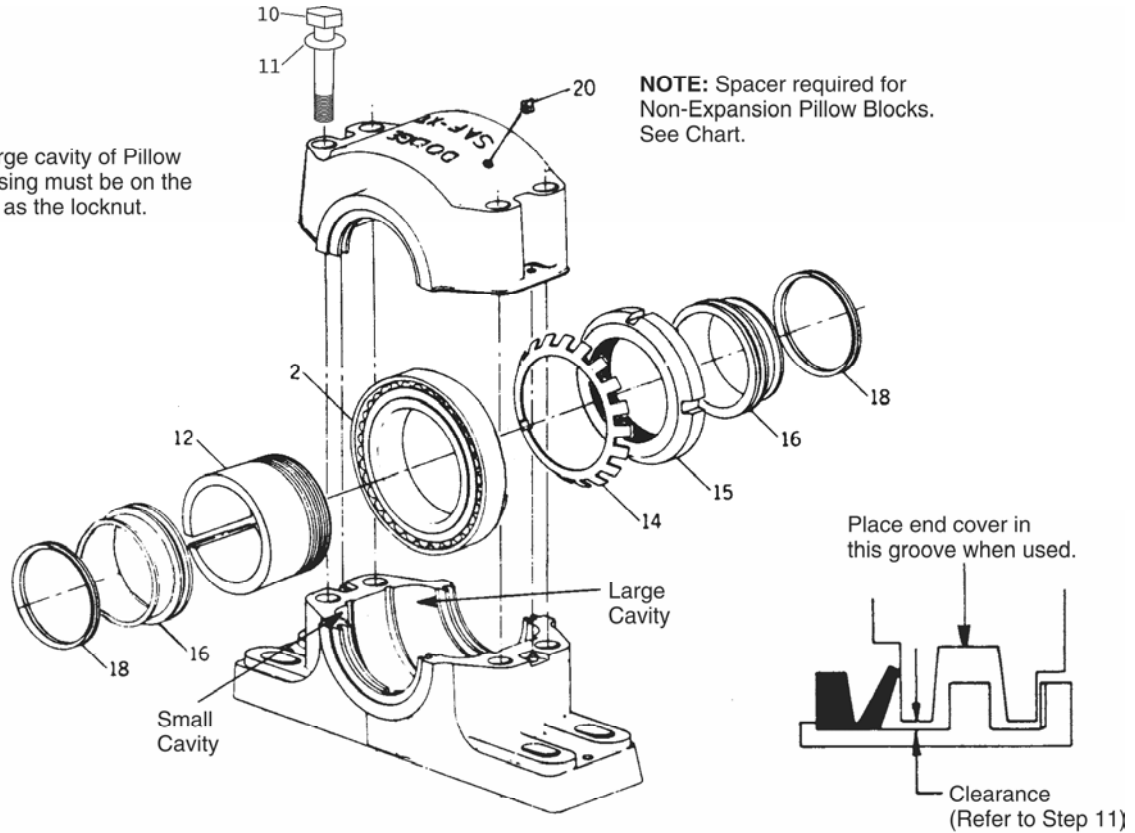
\* Housing Assembly consists of cap, base, roll pins, bolts, nuts and spacer(s).  
 ∅ Not shown on drawing. 2 required on sizes 8-7/16 and larger.

△ 2 Bolt Base.  
 ‡ Locking plate used instead of lockwasher (not shown).

Sizes 5<sup>15</sup>/<sub>16</sub> to 10<sup>1</sup>/<sub>2</sub> continued on next page.

## REPLACEMENT PARTS FOR SAF-XT PILLOW BLOCKS

**NOTE:** Large cavity of Pillow Block Housing must be on the same side as the locknut.



**NOTE:** Spacer required for Non-Expansion Pillow Blocks. See Chart.

Figure 3

Figure 4

Reference	Name of Part	No. Req'd.	Part Numbers							
			5-15/16	6	6-7/16	6-1/2	6-15/16	7	7-1/2	7-15/16
2	Bearing	1	422023	422023	422025	422025	422027	422027	422029	422029
	HOUSING ASSEMBLY*	1	042149	042149	042152	042152	042155	042155	042167	042158
10	Housing Bolt	4	411381	411381	411381	411381	411381	411381	411860	411860
11	Lockwasher	4	419020	419020	419020	419020	419020	419020	419024	419024
12	Adapter	1	041127	041128	041129	041130	04132	041133	041145	041137
14	Lockwasher	1	419172	419172	419174	419174	419176	419176	419178	419178
15	Lock Nut	1	041067	041067	041070	041070	041068	041068	041069	041069
16	Seal Ring	2	042070	042071	042072	042073	042074	042075	042081	042076
18	V-Ring Seal	2	042236	042236	042237	042237	042238	042238	042239	042239
20	Grease Fitting	1	405015	405015	405015	405015	405015	405015	405015	405015
↓	Stabilizing Ring	1	041181	041181	041184	041184	041182	041182	041183	041183

Reference	Name of Part	No. Req'd.	Part Numbers										
			8	8-7/16	8-1/2	8-15/16	9	9-7/16	9-1/2	9-15/16	10	10-7/16	10-1/2
2	Bearing	1	422029	422031	422031	422031	422031	422543	422543	422030	422030	422030	42203
	HOUSING ASSEMBLY*	1	042158	042161	042161	042161	042161	422555	422555	047378	042164	042379	422572
10	Housing Bolt	4	411860	411860	411860	411860	411860	411860	411860	411864	411864	411864	411864
11	Lockwasher	4	419024	419024	419024	419024	419024	419024	419024	419024	419024	419024	419024
12	Adapter	1	041138	042319	041078	042320	041079	042597	422541	041053	041136	042582	422570
14	Lockwasher	1	419178	419177†	419177†	419177†	419177†	422540‡	422540‡	419179†	419179†	419179†	419179†
15	Lock Nut	1	041069	041074	041074	041074	041074	422539	422539	041073	041073	041073	041073
16	Seal Ring	2	042077	042082	042078	042084	042079	043496	422546	422546	042086†	042036	422573†
18	V-Ring Seal	2	042239	042240	042240	042240	042240	422547	422547	-	042241	-	-
20	Grease Fitting	1	405015	405015	405015	405015	405015	405015	405015	405015	405015	405015	405015
↓	Stabilizing Ring	1	041183	041161	041161	041161	041161	422554	422554	041213	041213	041213	041213

\* Housing Assembly consists of cap. base, roll pins, bolts, nuts and spacer(s).

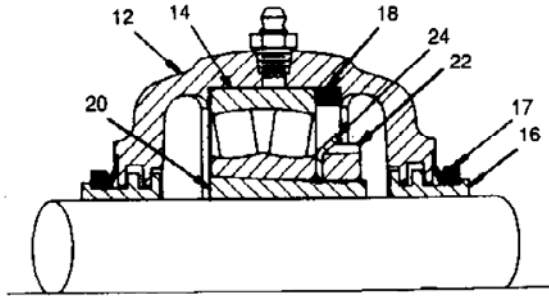
‡ 2 Bolt Base.

† ER Seals

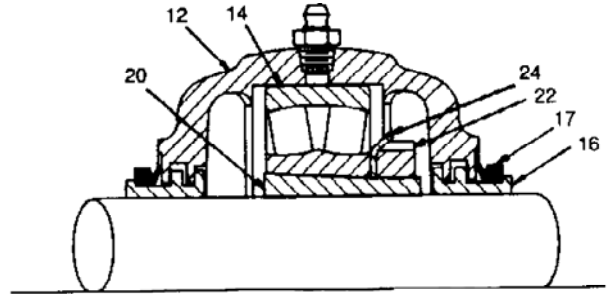
↓ Not shown on drawing. 2 required on sizes 8-7/16 and larger.

‡ Locking plate used instead of lockwasher (not shown).

## REPLACEMENT PARTS FOR SAFS PILLOW BLOCKS



**NON-EXPANSION TYPE  
SAFS PILLOW BLOCKS**



**EXPANSION TYPE  
SAFS PILLOW BLOCKS**

Name of Part	# Req'd.	1-7/16	1-11/16	1-15/16	2-3/16	2-7/16	2-1/2	2-11/16	2-3/4	2-15/16	3	3-3/16	3-7/16	3-1/2	3-15/16	4	4-3/16	4-7/16	4-1/2
2 Bolt Base Housing Assem. *	1	043995	043996	043997	043998	044000	044000	044198	044198	044010	044010	044199	044020	044020	.....	.....	.....	.....	.....
12 4 Bolt Base Housing Assem. *	1	.....	.....	.....	.....	044003	044003	044007	044007	044013	044013	044114	044023	044023	044025	044025	044031	044031	.....
2 Bolt Base Housing (SAFS) Assem. *	.....	.....	.....	.....	.....	042425	042425	042423	042423	042433	042433	044233	042440	042440	.....	.....	.....	.....	.....
12 4 Bolt Base Housing (SAFS) Assem. *	.....	.....	.....	.....	.....	042428	042428	044232	044232	042436	042436	044234	042443	042443	042450	042450	044235	042455	042455
14 Roller Bearing	1	422134	422137	422123	422124	422001	422001	422003	422003	422005	422005	422007	422009	422009	422011	422011	422013	422015	422015
16 Seal Ring	2	043389	043390	042050	042051	042052	042053	042054	042083	042055	042056	042057	042058	042059	042060	042061	042062	042073	042064
17 V-Ring Seal	2	042243	042224	042225	042226	042227	042227	042228	042228	04222	042229	042230	042230	042230	042231	042231	042232	042233	042233
18 Non-Exp. Spacer	1	041987	042335	042315	042316	041174	041174	041172	041172	041175	041175	041175	041176	041176	041177	041177	041185	041178	041178
20 Adapter Sleeve	1	042013	042014	042310	042311	041110	041111	041109	041126	041112	041113	041114	041115	041116	041117	041118	041119	041120	041121
22 Nut	1	419187	419188	419184	419185	460901	460901	460902	460902	460903	460903	460904	460905	460905	460905	460906	041071	041064	041064
24 Lockwasher	1	419180	419181	419182	419183	419150	419150	419152	419152	419154	419154	419156	419158	419158	419160	419162	419162	419164	419164
Name of Part	# Req'd.	4-15/16	5	5-3/16	5-7/16	5-15/16	6	6-7/16	6-1/2	6-15/16	7	7-1/2	7-15/16	8	8-7/16	8-1/2	8-15/16	9	
12 4 Bolt Base Housing Assem. *	1	044034	044034	044203	044040	044043	044043	044046	044046	044049	044049	044054	044055	044055	044200	044200	044200	044200	.....
12 4 Bolt Base Housing (SAFS) Assem. *	.....	042460	042460	044236	042465	042469	042469	042468	042468	042472	042472	044237	042477	042477	.....	.....	.....	.....	.....
14 Roller Bearing	1	422017	422017	422019	422021	422023	422023	422025	422025	422027	422027	422029	422029	422029	422031	422031	422031	422031	422031
16 Seal Ring	2	042065	042066	042067	042068	042070	042071	042072	042073	042074	042075	042081	042076	042097	042082	042078	042084	042079	042079
17 V-Ring Seal	2	042234	042234	042235	042235	042236	042236	042237	042237	042238	042238	042239	042239	042239	042240	042240	042240	042240	042240
18 Non-Exp. Spacer	1	041179	041179	041186	041180	041181	041181	041184	041184	041182	041182	041183	041183	041183	041161	041161	041161	041161	041161
20 Adapter Sleeve	1	041122	041123	041124	041125	041127	041128	041129	041130	041132	041133	041145	041137	041138	042319	041078	042320	041079	041079
22 Nut	1	041065	041065	041072	041066	041067	041067	041070	041070	041068	041068	041069	041069	041069	041074	041074	041074	041074	041074
24 Lockwasher	1	419166	419166	419168	419170	419172	419172	419174	419174	419176	419176	419178	419178	419178	419177	419177	419177	419177	419177
Name of Part	# Req'd.	9-7/16	10	10-1/2															
12 4 Bolt Base Housing Assem. *	1	422542	422560	044201															
12 4 Bolt Base Housing (SAFS) Assem. *	.....	.....	.....	.....															
14 Roller Bearing	1	422543	422030	422030															
16 Seal Ring	2	043496	042086	.....															
17 V-Ring Seal	2	422547	042241	.....															
18 Non-Exp. Spacer	1	422554	041213	041213															
20 Adapter Sleeve	1	042597	041136	422570															
22 Nut	1	422539	041073	041073															
24 Lockwasher	1	422540	419179	419179															

◇ Not shown on drawing.  
 \* Housing assembly consists of cap, base, roll pins, bolts, nuts and spacers.  
 ‡ Locking plate used instead of lockwasher (not shown).  
 • Two required for these sizes.



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