

Vertical helical bearing installation steps and attention to detail

1. Confirm the required accessories: ① metal gasket, ② metal gasket, ③ bearing, ④ rubber gasket



2. Install the screw rod into the bearing test first, and observe whether the bottom of the screw rod is flush with the bearing surface.

2-1 The bottom of the screw is flush with the bearing surface



2-2 Protruding bearing surface at the bottom of the screw



2-1 The bottom of the screw is flush with the bearing surface:

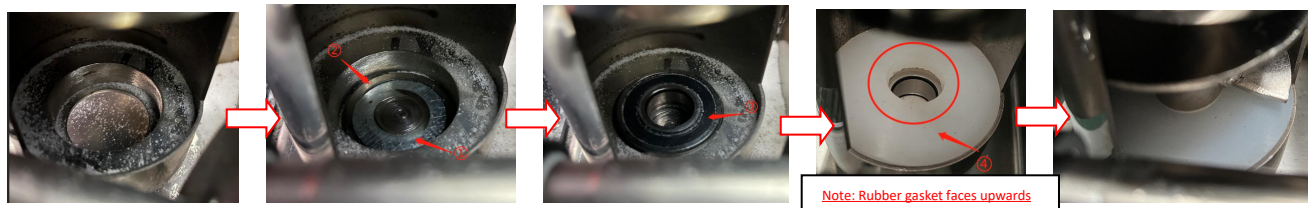
Accessories required: ①Metal gasket 1PC, ②Metal washer 1PC, ③Bearing 1PC, ④Rubber gasket 1PC

2-2 The bearing surface protruding from the bottom of the screw rod:

Accessories required: ①Metal gasket 1PC, ②Metal washer 2-3PCS, ③Bearing 1PC, ④Rubber gasket 1PC

3. Steps in the installation sequence of accessories

Clean up the residual powder => Install ①Metal gasket =>Install ②Metal washer =>Install ③Bearing =>Install ④Rubber gasket =>Install screw



Note: Rubber gasket faces upwards

4. Manual rotation test



After the accessories are installed, manually rotate the screw clockwise to check whether the rotation is smooth and whether there is any abnormal noise.

5. Power-on test



After the manual rotation is confirmed to be smooth, do not add powder first, turn on the power and start the spiral rotation. Let the screw rotate for about 30 minutes without load, and gently touch the stainless steel outer wall with your hand to check whether it is hot. If there is a hot hand (over 55° C), it is abnormal, and the installation needs to be re-checked.

6. Normal working test

Add about 2KG of powder, operate normally, run for about 30 minutes, pay attention to whether the bottom is hot. It can be used normally if it is not hot.

