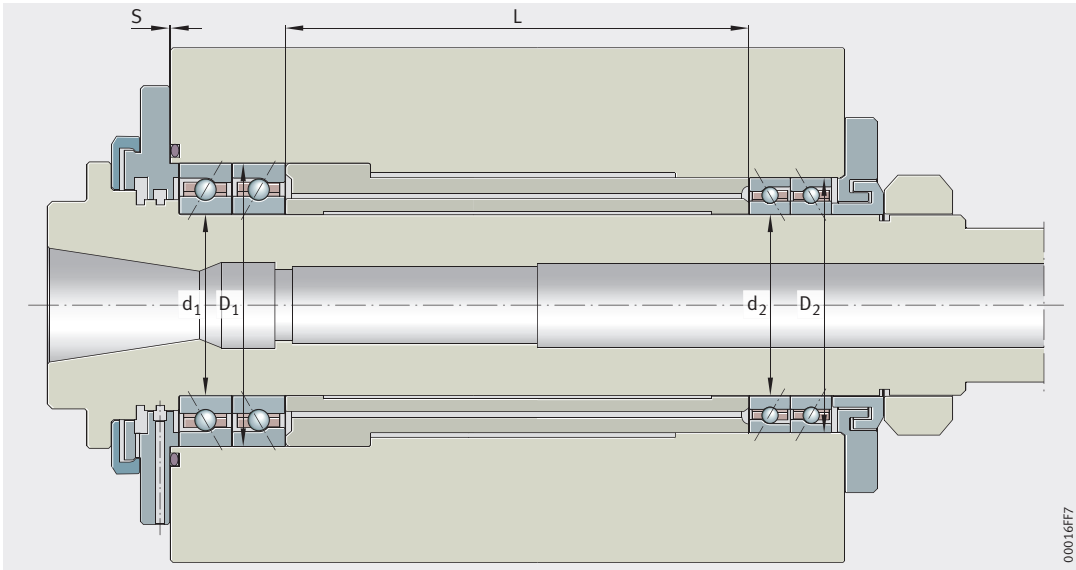
Checklist
for mounting of spindle bearings

Milling spindle (example)



Bearing seat diameter d_1, D_1, d_2, D_2

Spindle	∅ 70 ± 0,004	front d_1 = + 0,002	rear d_2 = 0
Housing	∅ 110 – 0,004 / + 0,006	front D_1 = + 0,003	rear D_2 = + 0,003

Difference in length L between intermediate sleeves	max. ± 0,002	actual: 0
Gap S before screw tightening	nominal 0,01 to 0,03	actual: 0,02

Balancing of rotational parts ❑ OK

Spindle bearing front	Part designation:	**HC7014-E-T-P4S-UL**
Spindle bearing rear	Part designation:	**HC7014-E-T-P4S-UL**

Correct designation ❑ OK ❑ Other: _____

Special notes _____

Grease quantity per bearing 9,2 cm^3 ❑ OK ❑ Other: _____

Nut tightening torque, three times nominal value initially	219 Nm	❑ OK, then loosen and tighten to
Nut tightening torque, nominal value permanently	73 Nm	❑ OK

Grease distribution cycle completed: ❑ OK

Continuous running completed, speed	10 000 min^{-1}	❑ OK
Equilibrium temperature	+44 °C	
Room temperature	+24 °C	

Note The difference should (without cooling) not exceed +30 K.

Radial runout	Rmax 0,002	Actual: 0,001
Axial runout	Amax 0,002	Actual: 0,001

Machine: Machining centre - customer **Spindel:** Drawing, serial number

Location: _____ Date: _____ Fitter: _____