

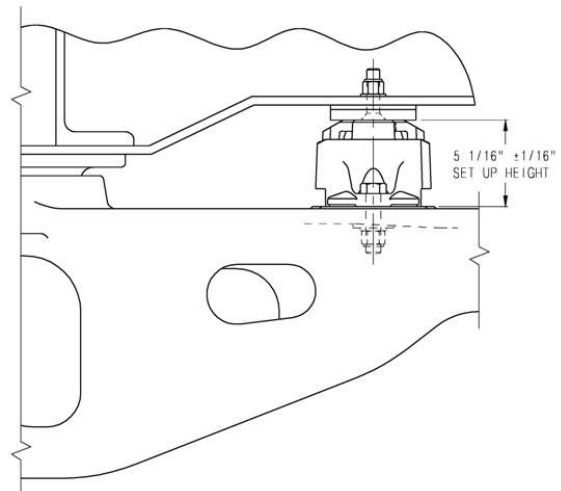
**INSTALLATION and MAINTENANCE Procedure, SK-3103,**  
**For SBX-30, 45, 60, 80 LTCCSB**

**Preparation**

1. Inspect car body bolster side bearing pad to ensure surface uniformity.
2. Body bolster wear plate surface should be parallel to side bearing pad on bolster.
3. Check car body wear plate size and condition. The wear plate surface must be free of pitting, weld spatter and surface protrusions. Must meet AAR standard S-235. Minimum wear plate length is 4" X 12".

**Installation**

4. The side bearing cage is to be secured to the bolster pad by 7/8"-9 grade 5 or better hex head bolts with self locking nuts. Bolts should be torqued to 365-435 ft. lbs if dry. If lubricated torque 275-325 ft.lbs.
5. The side bearing element should fit over the center cross. If the pad doesn't fit over the cross or if pad is loose with 1/16" side clearance, then the wrong pad is being applied. Check the pad markings to see if the model number matches the cage.
6. It is recommended that for new cars only, a thin layer of (No. 2 lithium grease or equivalent) be applied to the top cap surface. This will reduce the frictional resistance during the break in period.



**Set-Up**

7. The distance between the side bearing pad and the car body wear plate, or set up height must be adjusted to  $5 \frac{1}{16}'' \pm \frac{1}{16}''$ . If an elastomer center bowl liner is used, add  $\frac{1}{16}''$  to the standard set up height and adjust to  $5 \frac{1}{8}'' \pm \frac{1}{16}''$ . This procedure should be performed with an empty car on level track without side bearing element installed. It is recommended that inside calipers and steel ruler be used for accurate measurements.
8. Add (reduce distance) or remove (increase distance) the necessary amount of shims on the car body wear plate to achieve a  $5 \frac{1}{16}'' \pm \frac{1}{16}''$  distance between the bottom of the car body wear plate and the bolster side bearing pad using calipers, telescoping gages or go no-go gages.
  - a. During measurements, make sure the center plate is in contact with the bolster center bowl. Do not apply lube disc in center bowl when measuring the set-up height.
  - b. If new non-metallic horizontal bowl liners used, add  $\frac{1}{16}''$  to set-up height.
  - c. Do not expose side bearings to temperatures higher than 200° F for more then 1-2 hours.
  - d. After the side bearings have been installed and car body lowered onto the trucks, the set-up height may be greater then the original measured height. The bearing will take a set and the car will reach the designed set-up height. At temperatures lower then 40°F the car may require of 24 hours or more to settle to correct height. The elements should be stored in a environment at 40°F or greater for at least 24 hours prior to being installed on the trucks.

**Inspection**

1. For side bearing wear limits, gaging and cause for renewal or attention, please refer to RULE 62 of the Field Manual of the AAR Interchange Rules.