



SERVICE BULLETIN

The Trane Company - La Crosse, Wisconsin 54601

No: BG-061479

Date: 3/16/81

Dist: Upon Request

SUBJECT: REPLACEABLE SLEEVE BEARING INSERT FOR TRANE STANDARD MODEL "G"
COMPRESSORS

COMPRESSOR MODELS AFFECTED: ALL MODEL G7P AND EARLIER

Coach operators can improve the reliability and serviceability of their Trane Model G compressors built before early 1975 by use of the latest seal end bearing head assembly in lieu of the original design when the compressor is next rebuilt. Similar results are possible by rework of existing compressors or existing inventory. This bulletin provides data for either approach if compressor has external seal end bearing head. If bearing head is internal, see Bulletin BG-051980 as well.

IMPROVED SERVICEABILITY

The new seal end bearing head assemblies feature replaceable precision inserts. The other model had inserts requiring they be bored in place. Most commonly, the entire bearing head assembly is replaced. The newer style greatly reduces the overhaul expense.

IMPROVED RELIABILITY

Bearing life in this latest version of the Trane Model G was greatly improved over earlier models. The newer bearing head design offers improved lubrication and, in particular, when used with the latest crankshaft design it provides increased surface area for the bearing load.

IDENTIFICATION

New style bearing heads can be distinguished from earlier models by inspecting the bearing insert. The older style insert was bored in place and is not notched (see Figure 1).

UPDATE WITHOUT REWORK

Those operators not wishing to rework old style bearing heads can purchase the later version with replaceable inserts and install as a direct interchange. Order information follows:



TRANSPORT AIR CONDITIONING AND REFRIGERATION

<u>Former P/N (Obsolete)</u>	<u>Current Replacement P/N</u>	<u>Qty.</u>	<u>Description</u>
BRG-239	HD-161	1	Bearing Head Assembly (Type 21 Seal)
BRG-292	HD-160	1	Bearing Head Assembly (Type 2 Seal)
BRG-229	Not applicable	1	Bored in Place Insert (was used in BRG-239 or BRG-292)
Not applicable	IRT-2	1	Precision Replaceable Bearing Insert (for use in HD-160 or HD-161; or reworked BRG-239 or BRG-292)
CSF-35*	CSF-61	1	4G Crankshaft (Main bearing oil groove at both ends of shaft)

*Existing inventory may be used with a new bearing head design, though slightly less reliable. However, CSF-61 (main bearing oil groove at pump end only) may not be used with compressors not updated to use new bearings.

REWORK OF EXISTING COMPRESSORS OR INVENTORY

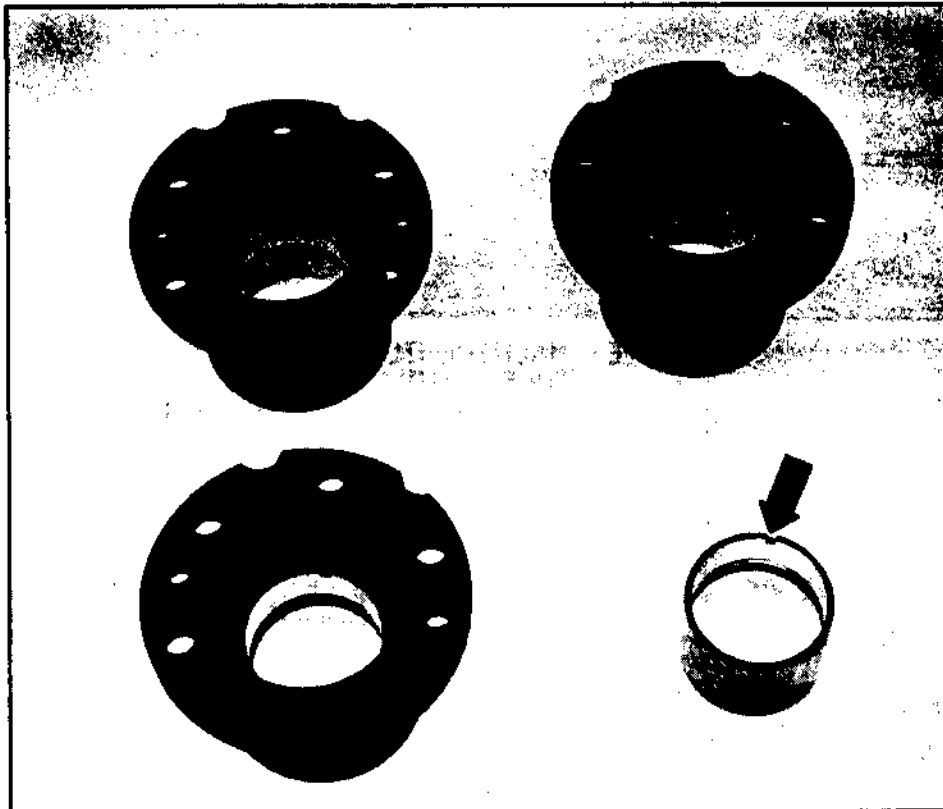
For those operators wishing to rework bearing heads BRG-239 or BRG-292 to accept the replaceable precision insert (IRT-2), the use of a press and the following procedures are required:

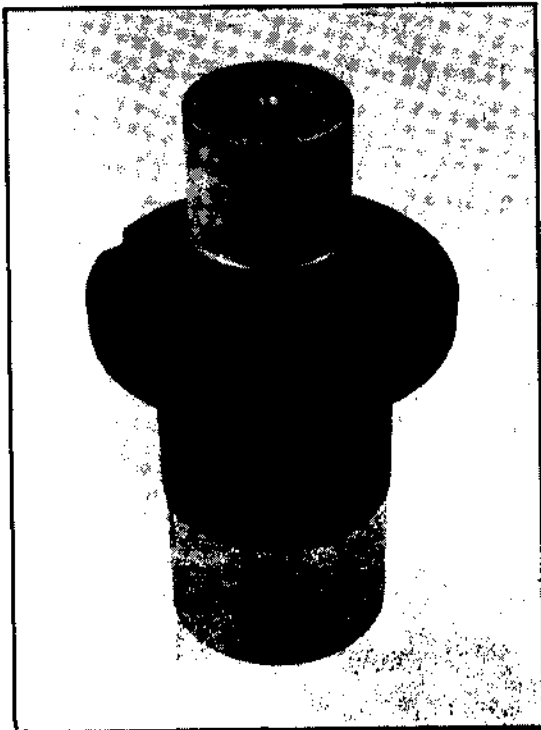
1. Obtain special bearing installer and remover tool assembly J-26504 and precision bearing insert IRT-2. Special tool assembly J-26504 can be purchased from:

Kent Moore Corporation
Tool Division
29784 Little Mac Avenue
Roseville, MI 48066
Attention: Order Department

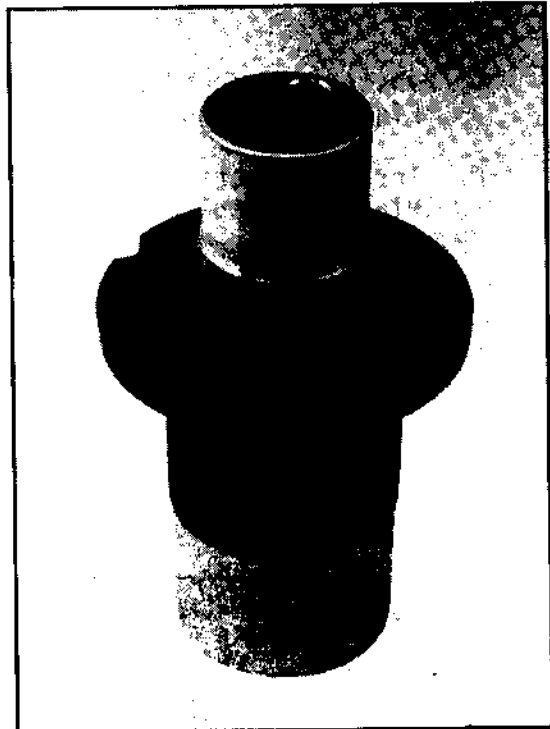
2. Place J-26504-10 support on the press. Insert either bearing head BRG-239 or BRG-292 on the support and place J-26504-6 remover tool into bearing. Note that the remover tool has an end with a hole and an insert pin (labeled installer) which is required to install the precision insert into the bearing head. The other end of the tool is required to remove the bored in place insert from the old style bearing head (see Figures 2 and 3).
3. Press insert from bearing assembly and discard insert.
4. Check the OD of the bearing housing to dimensions 2.6782 to 2.6787 inches and machine I.D. to dimensions 1.9067 inches concentric with-in .0005 inch to the OD (see Figure 4).

5. Install reworked bearing housing into J-26504-8 base plate (see Figures 5 and 6). Place in press.
6. Install insert IRT-2 onto the installer tool (use end with hole). Place the tool onto the positioning rod of the base plate (see Figure 6).
7. Press on installer tool until it bottoms out on base plate. Remove assembly.

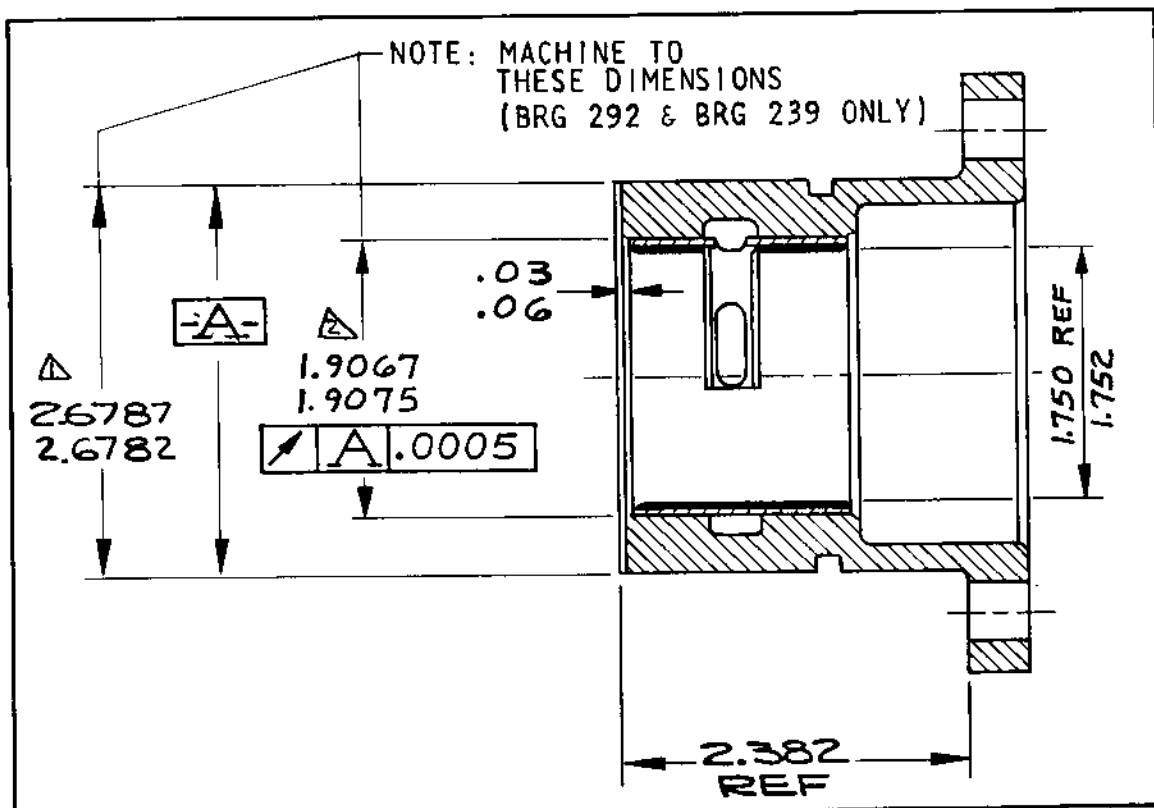




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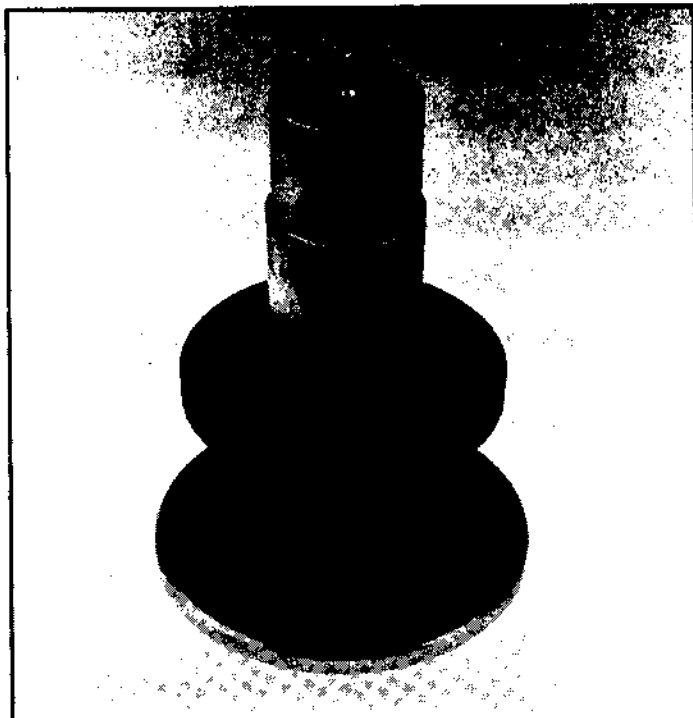
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