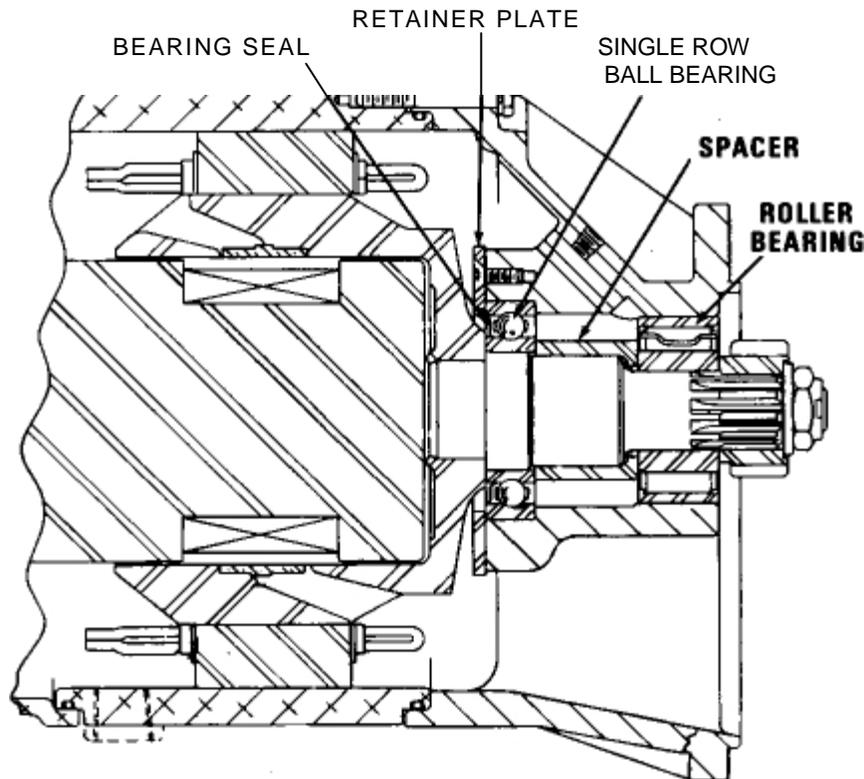


### INSTALLING BEARINGS IN 50DN OIL-COOLED GENERATORS

**WARNING!!!** ALWAYS USE PROPER EYE PROTECTION WHEN PERFORMING ANY MECHANICAL REPAIRS TO A VEHICLE – INCLUDING, BUT NOT LIMITED TO, ANY INSTALLATION AND OR REPAIRS TO THE DELCO REMY GENERATORS. FAILURE TO USE PROPER EYE PROTECTION CAN LEAD TO SERIOUS AND PERMANENT EYE DAMAGE.

Only perform the mechanical functions that you are properly qualified to perform. Mechanical repairs that are beyond your technical capabilities should be handled by a professional installation specialist.

1. Install single row ball bearing into drive end frame with seal toward rotor. Seat bearing into housing bore by pressing on **outer race only**. Assemble retainer plate and stake screws using center punch on edge of screw head.
2. Insert spacer; use hollow cylinder, 2.75"-2.62" Outside Diameter, 1.25"-1.50" Inside Diameter, and 2" long, to press roller bearing outer race about halfway into housing. Start roller bearing inner race by moving and rotating part until it enters and seats against the spacer. Finish pressing outer race with cylinders until it seats flush with inner race.  
**NOTICE:** Do not exert excessive force on roller bearing inner race because this will cause the ball bearing races to become brinelled, thus reducing the bearing life.  
**DO NOT** mix roller bearing races because they are **matched** for proper roller clearance.
3. Support inside of rotor with bar stock 2" diameter x 5" long on arbor press. With rotor shaft upright, press on inner race with cylinder used in Step 2 to press bearing and housing assembly onto shaft.



Technical support: USA 800 854 0076, Mexico 01 800 000 7378, Brazil 0800 703 3526, South America 55 11 2106 6510 or visit [delcoremy.com](http://delcoremy.com)

**NOTICE** - Only licensed Remy International, Inc. product and component parts should be used, and the use of other parts or modifications not approved by Remy International, Inc. will void all applicable warranties. The failure to carefully follow these Installation Instructions, set forth above, will void all applicable warranties. DELCO REMY is a registered trademark of General Motors Corporation, licensed to Remy International, Inc. Pendleton, IN 46064.