



CONTENTS

Preface	v
Chapter 1 Machining	01
Drilling	01
Drill Press Troubleshooting	02
Drill Sharpening	03
Drill Sizes and Decimal Equivalents	06
Screw Threads	09
Drilling and Tapping a Hole	12
Calculating a Tap Drill Size without a Table	15
Screw Thread—Drill and Tap Chart (UNC and UNF)	16
Taper Pipe—Drill and Tap Chart (NPT)	17
Screw Thread—Drill and Tap Chart (UNEF)	17
Metalworking Lubricants	18
Chapter 2 Metals	19
Thermal Expansion of Metals	19
Linear Expansion for Various Materials	21
Chapter 3 Repairs and Rebuilding	24
Stub Shaft Repair	24
Freeing Frozen Bolts	28
Removing Broken Bolts	30
Chapter 4 Machinery Inspection and Measurement	32
Reading a Micrometer	32
Using a Strobe Light	39
Vibration Measurement	44
Simple Vibration Severity Test	56
Vibration Calibration	57
Detecting a Bad Bearing	58
Chapter 5 Lubrication	59
Prepacking a Bearing with Grease	59
Calibration of a Grease Gun	60
How Much Grease to Add to a Bearing	62
Grease Relubrication Interval	64
Chapter 6 Bearings	69
Bearing Identification Numbers	69
Bearing Dimension Tables	74
Bearing Installation	78
Fitting of Antifriction Bearings	81
Bearing Bore and Shaft Seat Dimensions	83

iv ■ CONTENTS

Bearing OD and Housing Dimensions—100 Series	84
Bearing OD and Housing Dimensions—200 Series	85
Bearing OD and Housing Dimensions—300 Series	86
Bearing OD and Housing Dimensions—400 Series	87
Chapter 7 Shaft Alignment	88
Rough Shaft Alignment	88
Correcting Soft Foot	90
Shim Chart	93
Straightedge and Feeler Gage Alignment	94
Chapter 8 V-Belt Drives	95
V-Belt Drives	95
V-Belt Sheave Inspection	97
Sheave Speed Ratio Calculation	98
V-Belt Tensioning—Force Deflection Method	101
V-Belt Tensioning—Percent Elongation Method	105
Belt Length Calculation	108
Standard V-Belt Lengths	110
Chapter 9 Mechanical Bushings	113
Mechanical Bushings	113
Mechanical Bushings—QD Installation	114
Mechanical Bushings—Taper Lock Installation	117
Chapter 10 Electricity	118
The Laws of Electricity	118
Chapter 11 Electric Motors	122
Understanding and Troubleshooting Industrial Induction Motors	122
Improving Motor Bearing Life	125
Electric Motor Insulation Values	128
Industrial Motor Dimension Charts	129
Electric Motor Sleeve Bearing Wear	134
Industrial Motor Keyseat Dimensions and Horsepower Ratings	135
Adding a Wire to a Conduit	136
Chapter 12 Centrifugal Pumps	138
Understanding and Troubleshooting Centrifugal Pumps	138
Packing a Pump	144
Centrifugal Pump Affinity Laws Explanation	146
Chapter 13 Industrial Fans	155
Understanding and Troubleshooting Industrial Fans	155
Balancing a Fan	164
Chapter 14 Welding	174
Oxyacetylene Gas Welding	174
Chapter 15 Miscellaneous Information	178