

INSTALLATION

Locking assemblies are supplied ready for installation. However, if for some reason they have to be disassembled, make sure that in addition to lined-up slits in all collars, near and far-side clamp collars are not reversed. They are assembled correctly only if there are no holes or threads behind taps in clamp collar item no. 1. Likewise, there must be no threads behind taps in center collar item no. 3 as illustrated in fig. 2. The frictional torque capacity of these devices is based on a coefficient of friction of 0.12 for lightly oiled screw, taper, or shaft and bore contact areas. **Therefore, it is important not to use Molybdenum Disulfide, e.g., Molykote, Never-Seeze or similar lubricants in any locking assembly installation.**

1. Make sure shaft and bore contact areas are clean and lightly oiled.
2. Loosen all locking screws by a minimum of 2 turns and transfer at least 2 screws to push off threads in clamp collar item no. 1 and center collar item no. 3 in order to disengage tapers for easy installation of locking assembly (see fig. 2).
3. After installation of locking assembly, relocate locking screws used for separation of collars.
4. Hand tighten connection and assure that collar item no. 1 is parallel with face of part to be attached to shaft.
5. Use torque wrench and set it approximately 5% higher than specified tightening torque M_A . Torque screws in either a clockwise or counter clockwise sequence, using only 1/4 turns (It is not necessary to tighten in a diametrically opposite pattern) for several passes until 1/4 turns can no longer be achieved.
6. Still apply overtorque for 1 to 2 more passes. This is required to compensate for a system-related relaxation of locking screws since tightening of a given screw will always relax adjacent screws. Without overtorquing, an infinite number of passes would be needed to reach specified tightening torque.
7. Reset torque wrench to specified torque and check all locking screws. No screw should turn at this point, otherwise repeat step "6" for 1 or 2 more passes. It is not necessary to re-check tightening torque after equipment has been in operation.

NOTE: In installations subjected to extreme corrosion, the slits in clamp collars item "1" and "2" as well as in center collar item "3" should be sealed with a suitable caulking compound or otherwise.

LOCKING ASSEMBLY		SCREW SIZE Metric Din 912 Grade 12.9	Tight Torque M_A ft.-lb.
METRIC SIZES	INCH SIZES		
	1 to 1-3/16	M 6 x 35	12
	1-1/4 to 1-7/16	M 6 x 45	12
45 x 75 to 65 x 95	1-1/2 to 2-9/16	M 8 x 50	30
70 x 110 to 90 x 130	2-5/8 to 3-5/8	M 10 x 60	60
100 x 145 to 120 x 165	3-3/4 to 4-3/4	M 12 x 80	105
130 x 180 to 160 x 210	4-15/16 to 6	M 14 x 90	166
170 x 225 to 260 x 325	6-7/16 to 8	M 16 x 110	257
280 x 355 to 340 x 425		M 20 x 130	500
360 x 455 to 600 x 695		M 22 x 150	675

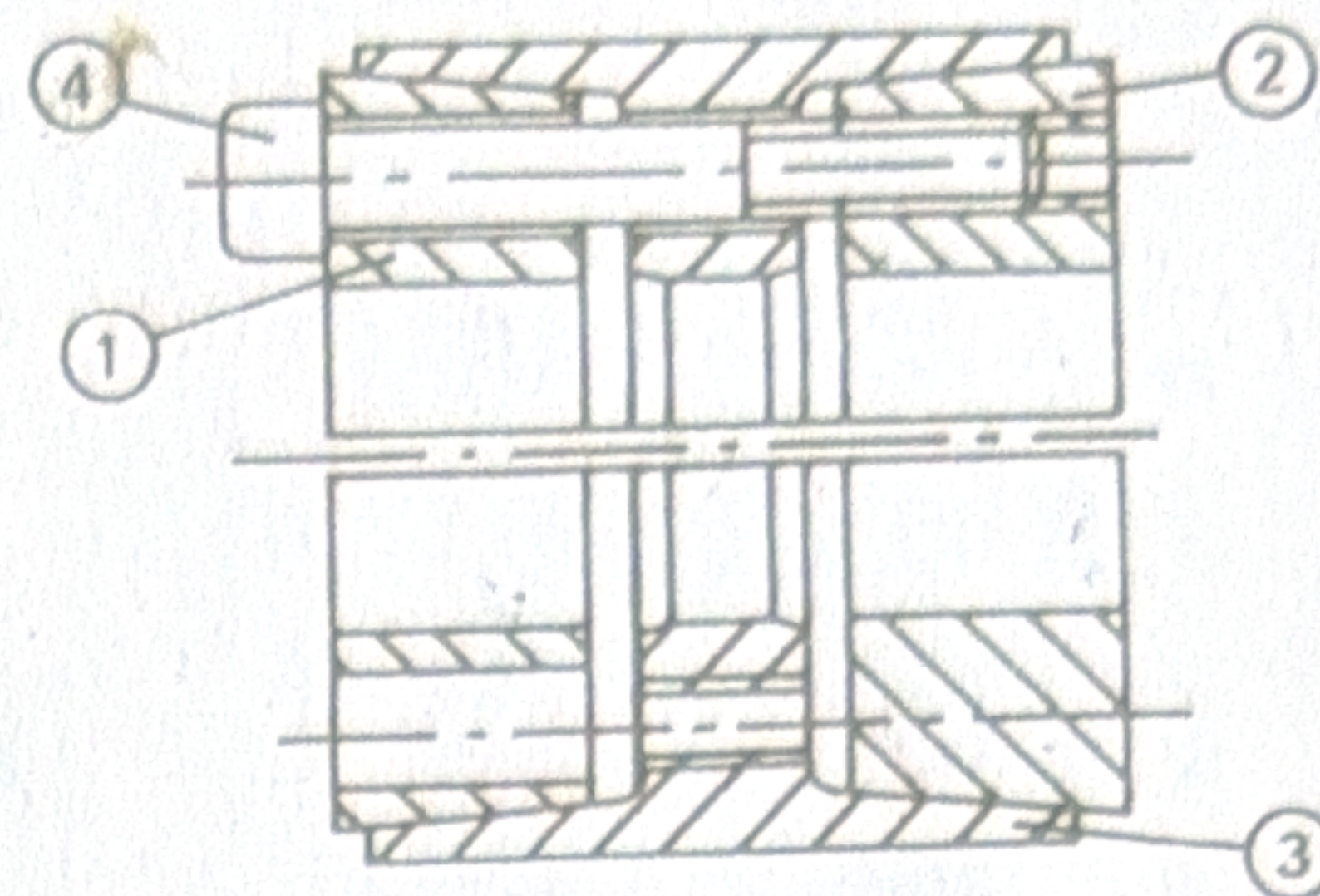


Figure 1

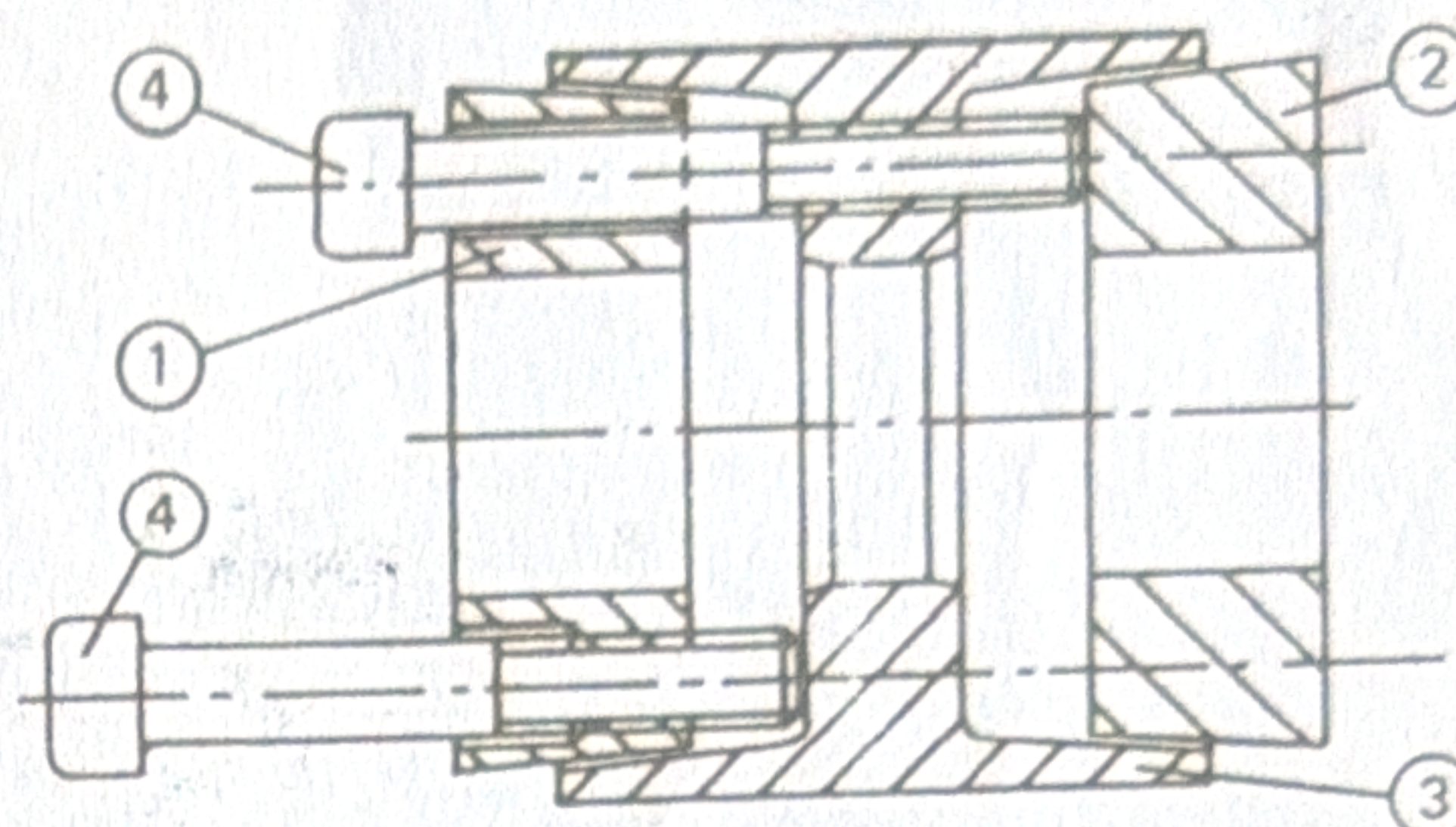


Figure 2

REMOVAL (refer to fig. 2)

IMPORTANT! Make sure ends of locking screws used for removal are ground flat and ends are slightly chamfered to eliminate damage to screw - and collar threads during push-off.

1. Check to assure that axial movement of clamp collars - necessary for release of connection - is not restricted.
2. Remove all locking screws and transfer some into all push-off threads in clamp collar item "1".
3. Release collar "1" by progressively tightening all push-off screws. Typically, the push-off screws appear to be completely tight after just one pass of tightening without any noticeable separation. Although it seems that screws can not be tightened further, several more rounds of torquing in a clockwise (or counter clockwise) sequence actually add more push-off force to the system and ultimately release part of the front collar. Afterwards, only the screws which are still tight, should be tightened further until complete dismounting is achieved.
4. Transfer locking screws used for dismounting of collar "1" to all push-off threads in center collar item "3". Release collar "2" by repeating procedures outlined in step 3.

HEX BIT SOCKET SIZES RECOMMENDED FOR ASS'Y & REMOVAL

SCREW SIZE	M6	M8	M10	M12	M14	M16	M18	M20	M22
S (mm)	5	6	8	10	12	14	14	17	17
DRIVE	1/4"		3/8"		1/2"		3/4"		

