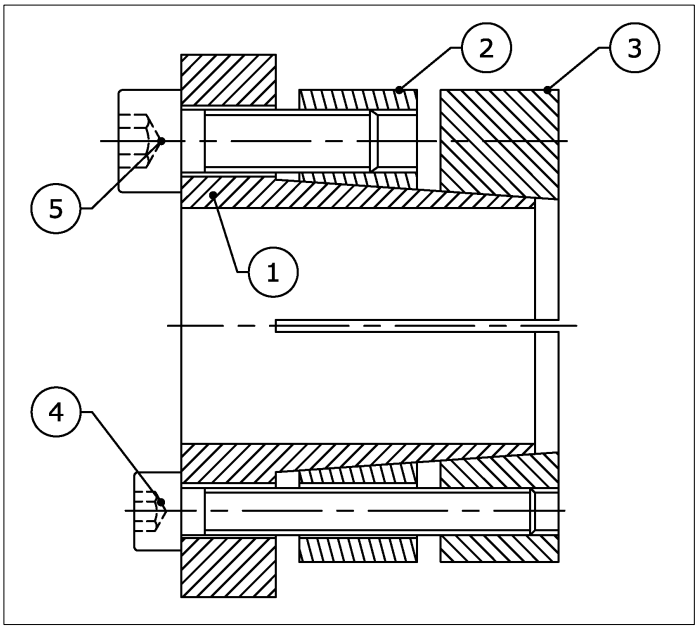
1.) About N7036 Function:

- N7036 Locking Assemblies are internal clamping device to provide backlash free mounting of hub on shaft.Torque is transmitted by contact pressure& friction between contact surface(s). Condition surface and proper tightening of screw is great importance.By appling torque to clamping screw(s),radial clamping force generated due to taper surface.The radial clamping force press outer ring into the hub bore and inner ring onto the shaft and create a friction connection at respective contact surfaces.

2.) Nomenclature:



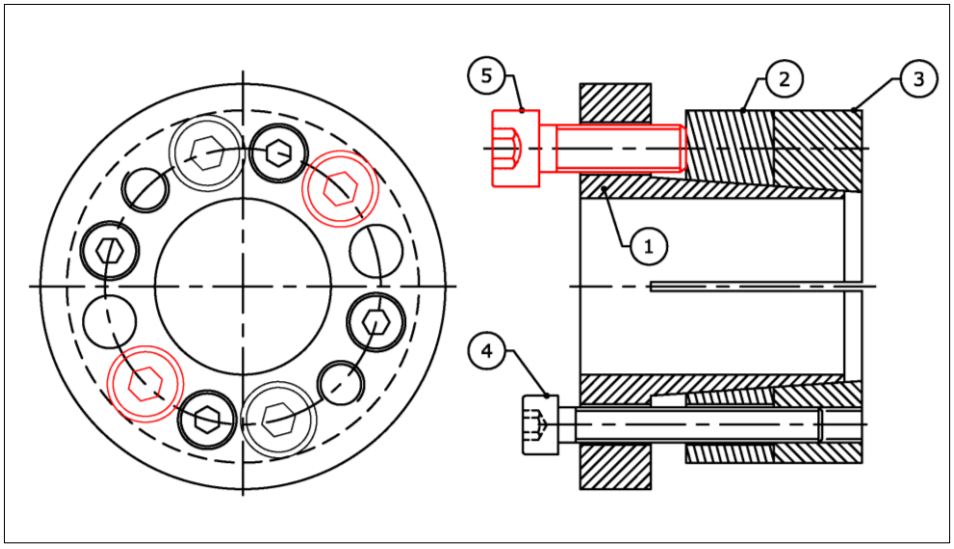
No.	Nomenclature
1	Inner Ring
2	Front nut
3	Rear nut
4	Clamping Screws – (4)
5	Clamping Screws – (5)

3.) Technical Requirement for safe operation:

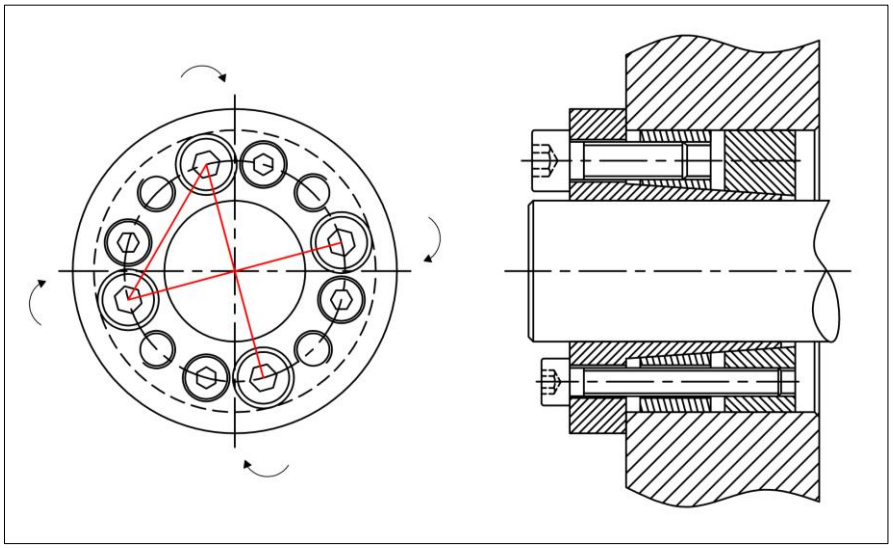
- A good surface finish by machine tool is sufficient. Maximum allowable surface finish: Ra max 3.2µm. Maximum permissible tolerances for hub H8 & Shaft h8.
- **Notes:**
    1) **Don't use oil containing molybdenum sulphide or high-pressure additives or grease of any kind. Apply light coat oil on the shaft & into hub ineer surface.**
    2) **During installation be ensure that Shaft and hub should be kept concentric and eliminate an effect of self-weight of Hub & Shaft upon the locking assembly by balancing them.**
    3) **For Tightening of screws, Torque wrench must be used. Do not use Allen key otherwise required Technical parameters will not be achieved.**

4.) Installation:

- Before Installation be ensure that hub bore and shaft are properly clean (No dust particles).
- Apply light coat oil into hub & on shaft at where Locking assembly is to be located.
- First of all loosen the clamping screw by hand.
- Now transfer at least 2 to 3 nos. of Clamping screw – (5) into Tapped Holes (Removal) in order to disengage taper for easy Installation of Locking Assembly.



- Slide the locking assembly onto the shaft & into hub and after confirming the correct position of locking assembly& confirm flange is parallel and in full contact with face of part to be attached then hand tighten all screws in diametrically opposed sequence.

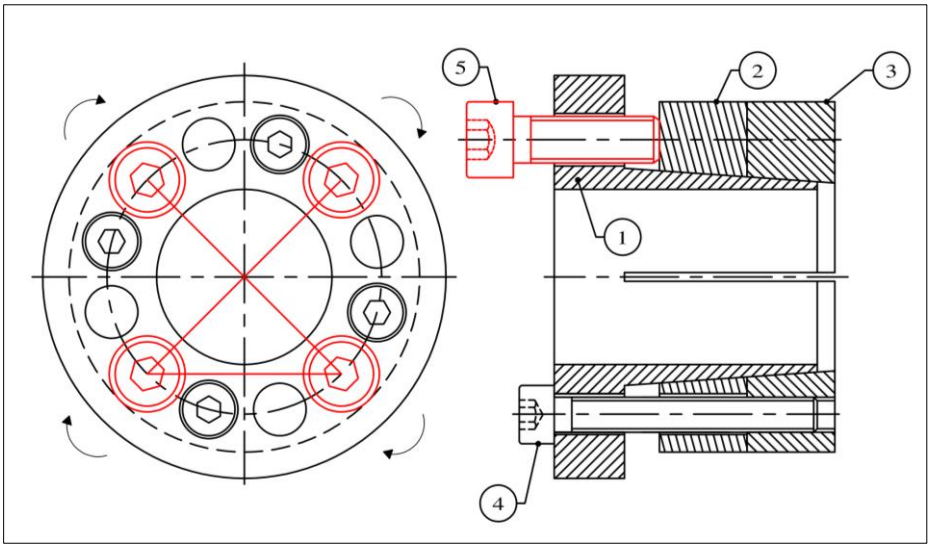


- Once the axial position of locking assembly is fixed then tighten first Clamping screws (5) one by one in diametrically opposed sequence by using torque wrench & then Clamping screws (4) in same manner. (As shown in above Fig.)
- At a time tighten screw(s) by 1/4 revolution with help of torque Wrench for several passes*(Set torque wrench for 1st pass : 1/3 Ta ; 2nd pass: 2/3 Ta ;3rd pass : Full Ta or 5% more)*.Where Ta= Tightening torque
- The tightening process is completed only when no one screw turn at specified tightening torque value.

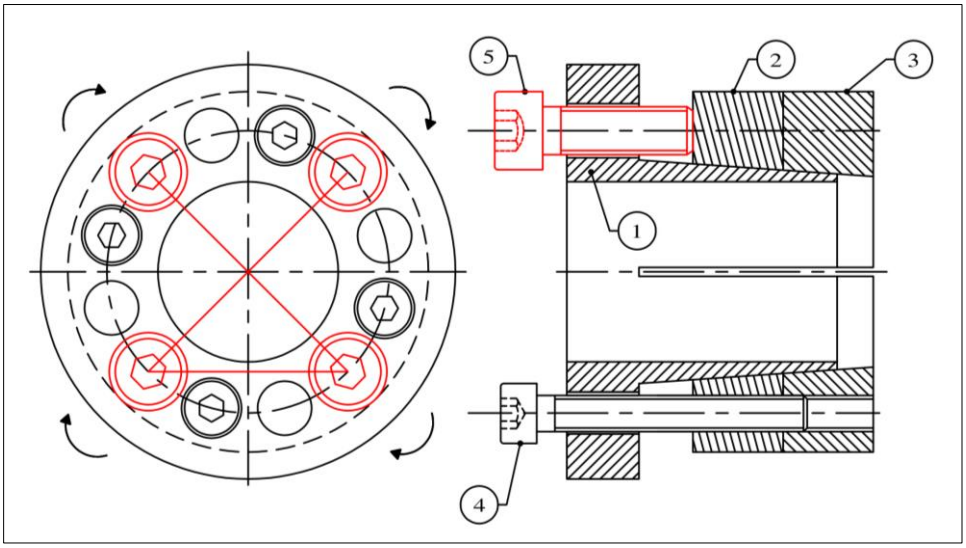
*(**IMPORTANT:**Improper installation generates uneven tension in tightening screws and ultimately Which transfers uneven pressure distribution at shaft and hub connection, Lead to Malfunctioning of locking assembly.)*

5.) Removal:

- Loosen the clamping screw – (5) uniformly one by one with the help of torque wrench in diametrically opposed sequence in multiple steps by 1/4 revolution& transfer all screws into Tapped holes (Removal holes).Don't loose single screw at a time, otherwise it may lead to tilt inner ring and outer ring and damage of locking assembly occurs.
- Release Front nut by tightening Clamping (removal) screws - (5) while Clamping screw – (4) will be in tightened condition.



- Now, loosen all Clamping scews – (4) & re – tighten all Clamping (removal) screws - (5) in crosswise pattern for several passes which will release Rear nut.



- Pull & remove the Locking assembly out of Shaft-hub.

6.) Reuse:

- For reuse of locking assembly, re-lubricate all Locking Assembly parts. If any damage found in parts of locking assembly,then replacement of whole assembly required. Before reuse of locking assembly's screws, please recheck screws length & if they have been elongated, during operating condition- can't reused,hense replace (with same size and grade).

7.) Maintenance:

- Locking assembly N7036 is maintenance free. We therefore recommend to check tightening Torque of the clamping screws every time maintenance is performed on the machine.

(All Figures shown in instructions are for easy understanding of installation and removal processes.)

8.) Storage Preservation and Instruction:

- Don't store in corrosive environment.
- Once the Locking assembly has been used then clean the all parts of it with clean cloth.
- Lubricate all parts with rust preventive oil S-VCI 415 or equivalent and assemble as it was & packed in plastic bag.
- After wrapping in plastic bag, Material is packed by S-VCI 131 or equivalent rust preventive paper & store.