Doc. No.: N-DD-IM-LA126	**Installation & Removal Instructions of Locking Assembly** *(N 8006 Model)*			
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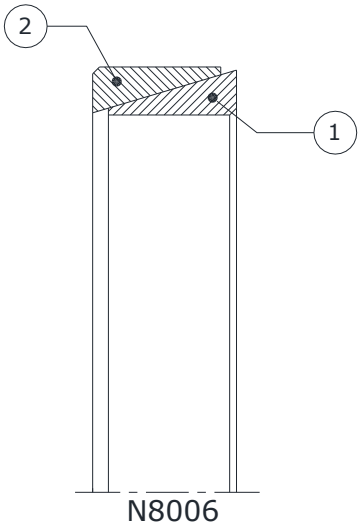
1.) About N8006 & Function:

- N8006 Locking Element are internal clamping element to provide backlash free mounting of hub on shaft.Torque or axial forces can be transmitted from shaft to cone clamping element to hub.surface condition 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	Outer Ring

3.) Technical Requirement for safe operation:

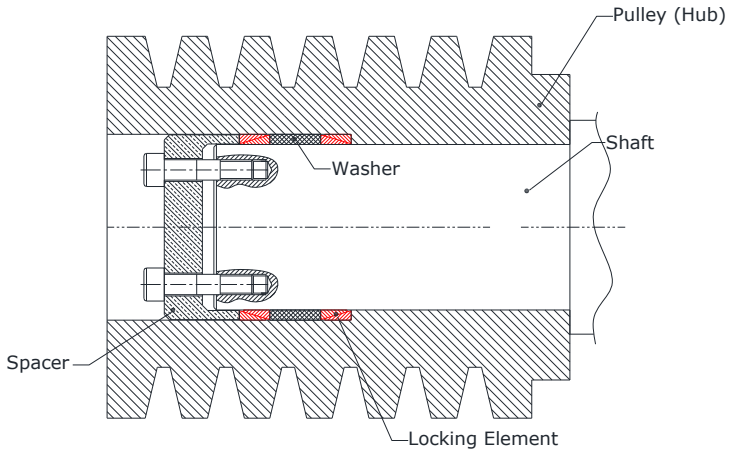
- A good surface finish by machine tool is sufficient. Maximum allowable surface finish: Ra max 3.2µm. Maximum permissible tolerances:

Hub	Shaft
H7	h6
H8	h8

4.) Installation:

- Before Installation be ensure that hub bore and shaft are properly clean (No dust particles).
- Apply light coat oil into hub & onto shaft at where Locking element is to be located.
- **Note : Don't use oil containing molybdenum sulphide or high-pressure additives or grease of any kind.**
- Push the hub onto the shaft & insert inner and outer ring and provide distance ring as per assmebly requirement.
- Attech thrust ring and lightly tighten the clamping screw and align the hub.
- Tighten diagonally opposite screws in serval stages with torque wrench to tightening torque Ta.
- **Note: Value of tightening torque is depand on customer application, hub material, shaft material, bolt size & grade etc.**
- N8006 locking element consists of inner ring with outside taper and outer ring with inside taper.
- Thrust ring needed for providing the clamping connection and clamp screws are to be provided by the customer.

- Radial clamping forces are generated due to taper surfaces which is depanded on tightening torque of the clamping screw, taper angle and friction coefficients at screws and conical surfaces.



- Due to radial clamping forces press the outer ring into hub bore and inner ring onto shaft and create friction connection at respective contact surfaces. By this, torque can be transmitted.
  *(**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 clamping screws in diagonally opposite sequence in such a way that thrust ring does not tilt.
- Release hub radially by lightly hammering with the help of fiber hammer.

6.) Reuse:

- For reuse of locking assembly, to re-lubricate inner ring and outer ring. If any damage found in parts of locking element,then replacement of whole element required. Before reuse of screws please check screws length because of during operating condition if they have been elongated so they cannot be used further so replace with same size and grade.

7.) Maintenance:

- Locking element N8006 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.