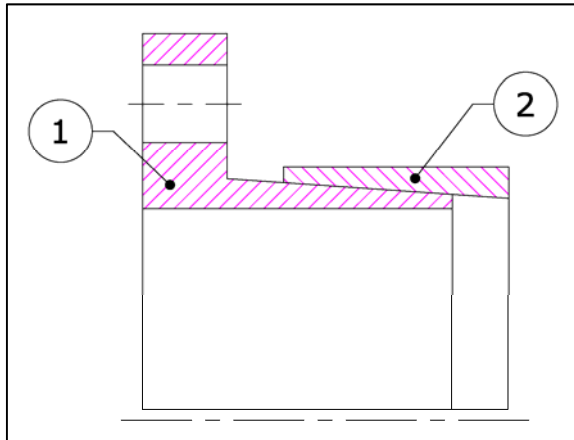


1.) About N2506 & Function:

- N2506 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. Surface condition and proper tightening of screw(s) is great importance. By applying torque to clamping screw, radial clamping force generated due to taper surface.

2.) Nomenclature:



No.	Nomenclature
1	Inner Ring
2	Outer Ring

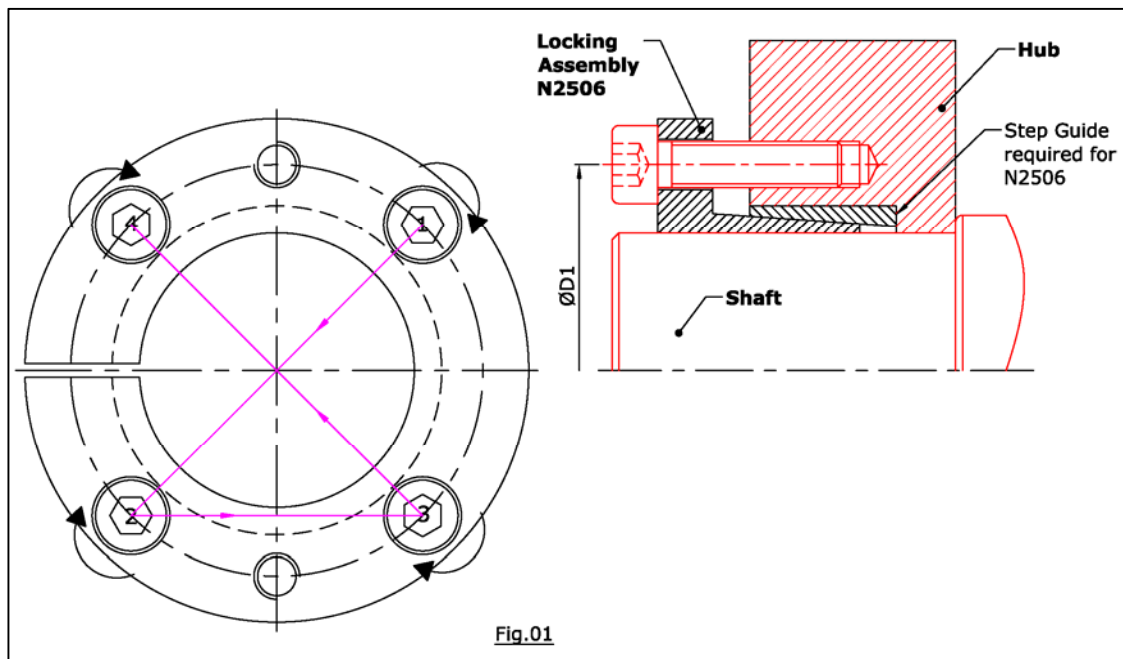
Note: **Clamping screws for N2506 Model arrange by Buyers.**
(For Size of Allencap screw for follow NMTG locking assembly catalogue_N2506 Model or given drawing).

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 bore is H8 & Shaft is h8.
- Note :**
 - Don't use oil containing molybdenum sulphide or high-pressure additives or grease of any kind.
 - 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.

4.) Installation:

- Before Installation be ensure that hub bore and shaft are properly clean (No dust particles).
- Apply light coat oil onto hub, shaft at where Locking assembly is to be located.
- Slide the locking assembly onto the shaft & into hub and clamp the installed clamping screws to fix in hub. (Note: follow given drawing or NMTG Locking Assembly Catalogue_N2506 model for take tapping size & "D1" dimension into hub).



- Once the axial position of locking assembly is fixed then tighten all screws one by one in diametrically opposed sequence by using **Torque Wrench**. (Fig. 1)
- At a time tighten screws 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.)

Torque wrench torque	No. of Pass	Bolt Sequence	Tightening of screws
1/3 Ta	P ₁ , P ₂ , P ₃ , P ₄ ,...n	1,2 ,3 ,4, ...	By 1/4 Revolution
2/3 Ta	P ₁ , P ₂ , P ₃ , P ₄ ,...n	1,2 ,3 ,4, ...	By 1/4 Revolution
Ta or 5% more	P ₁ , P ₂ , P ₃ , P ₄ ,...n	1,2 ,3 ,4, ...	By 1/4 Revolution

Tightening Torque:

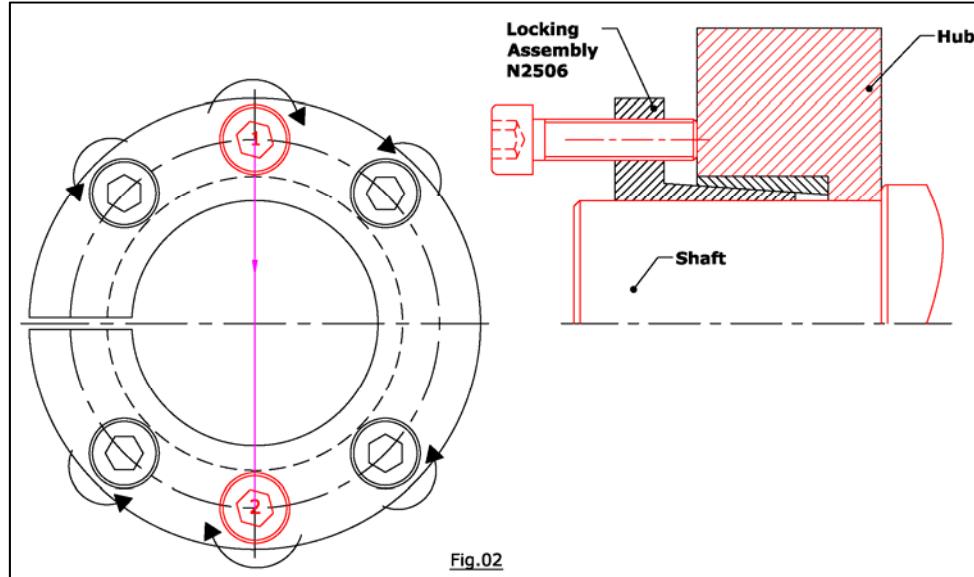
- Clamping screws of N2506 is in customer scope.

N2506	
Screw size	Ta(Nm)
M4	4.9
M5	10
M6	17
M8	41

- Above mention value of tightening torque is maximum. Please refer drawing for actual value of tightening torque as per your application.
- Replace missing or damaged clamping screw with screw of quality grade 12.9 grade only.

5.) Removal:

- Loose the clamping screws several turns & insert the Clamping screw in Removal hole
- Loosen the clamping screws uniformly one by one with the help of torque wrench in diametrically opposed sequence in multiple steps by 1/4 revolution (As shown in Fig. 2) for each step to Prevent misalignment of the clamping surfaces and breaking of screws. 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.
- After insert Clamping screw, Tight several turns each removal screws in Cross squanese. The locking assembly should be lose from hub and released.



6.) Reuse:

- For reuse of locking assembly, to re-lubricate inner ring, outer ring and clamping screws. If any damage found in parts of locking assembly, then replacement of whole assembly required. Before reuse of locking assembly's 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 assembly N2506 is maintenance free. We therefore recommend to check the 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 & Instruction:

- NMTG Product is supplied with an oil film as Rust & Corrosion Protection as per below instruction for Short term storage.
- This protection is renewed at regular intervals which depends on Environmental condition at Storage site. (Temperature, Atmosphere, etc.)

➤ **Maximum Storage period is 6 Months for Short-term Storage.**

Please follow Instruction for Preservation & Storage of NMTG Products:

- Once NMTG Product is used then clean all its parts with clean cloth.
- Lubricate all parts with rust preventive oil S-VCI 415 or equivalent & 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.
- Keep it in dry place and free from dust.
- Do not expose to open or corrosive environment.
- Keep away from direct Sunlight.
- Avoid Mechanical Shock & Vibration.
- Storage Temperature: -10 to +60°C.
- Relative Humidity: Maximum 95%, non-condensing.

For Long term Storage (1 Year):

Please follow Instruction for Preservation & Storage of NMTG Products:

- Once NMTG Product is used then clean all its parts with clean cloth.
- Lubricate all parts with rust preventive oil S-VCI 415 or equivalent & assemble as it was & packed in special Vacuum bag.
- After wrapping in Vacuum bag, Material is packed & store.
- Keep it in dry place and free from dust.
- Do not expose to open or corrosive environment.
- Keep away from direct Sunlight.
- Avoid Mechanical Shock & Vibration.
- Storage Temperature: -10 to +60°C.
- Relative Humidity: Maximum 95%, non-condensing.