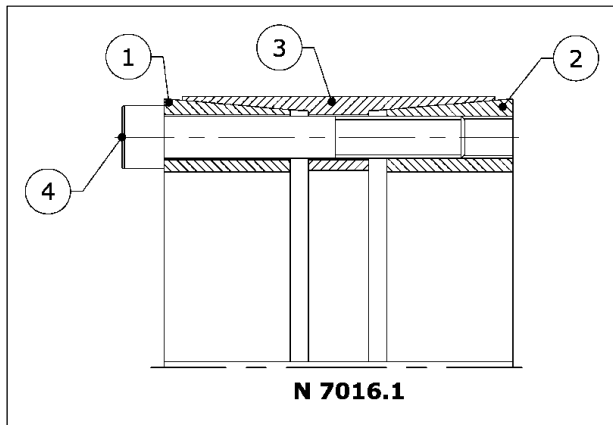


1.) About N7016.1 & Function:

- N7016.1 Locking Assembly is 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 is great importance. By applying torque to clamping screw, radial clamping force generated due to taper surface.

2.) Nomenclature:



No.	Nomenclature
1	Front Nut
2	Rear Nut
3	Outer Ring
4	Allencap Screw

3.) Technical Requirement for safe operation:

- A good surface finish by machine tool is sufficient. Maximum allowable surface finish: $Ra \leq 3.2 \mu m$. Maximum permissible tolerances for hub H8 & Shaft h8.
- Note :**
 - Don't use oil containing molybdenum sulphide or high-pressure additives or grease of any kind.
 - For Tightening of screws, Torque wrench must be used. Do not use Allen keys otherwise required Technical parameters will not be achieved.
 - 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:

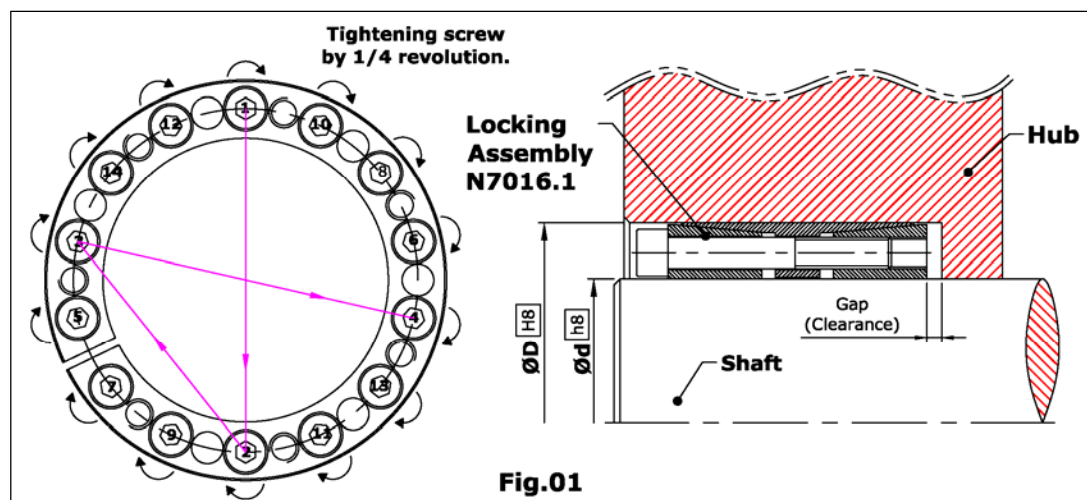


Fig.01

- 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.
- Assure that necessary space for axial movement of front & rear nut is available. Loosen the clamping screw by hand.
- Slide the locking assembly onto the shaft & into hub and after confirming the correct position of locking assembly in respect of hub then hand tighten all screws.
- Once the axial position of locking assembly is fixed then tighten all screws one by one in diametrically opposed sequence by using torque wrench. (As shown in Fig. 01)
- 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).
- The tightening process is completed only when no one screw turn a single round 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.)

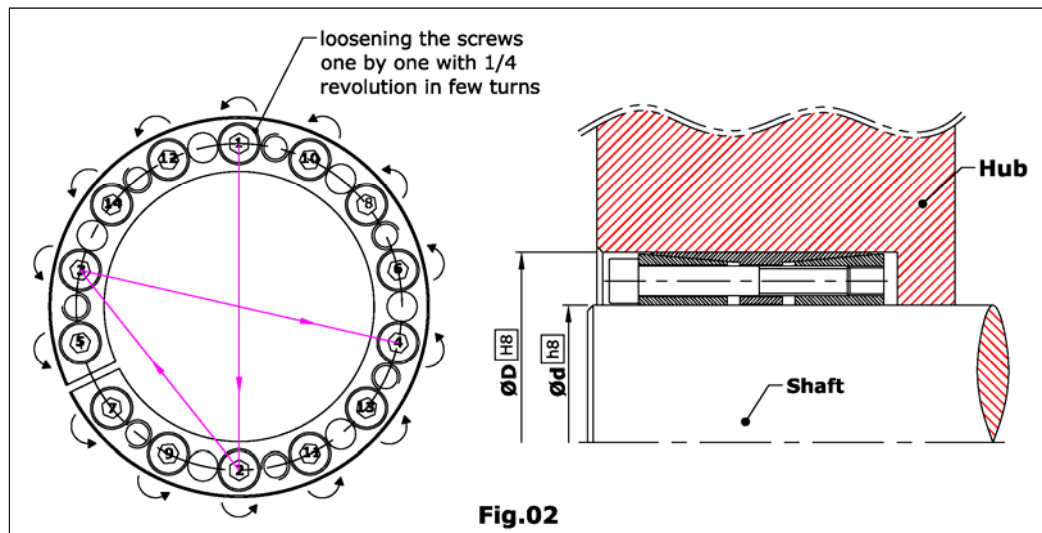
Torque wrench torque	No. of Pass	Bolt Sequence	Tightening of screws
1/2 Ta	P ₁ , P ₂ , P ₃ , P ₄ ,...n	1,2 ,3 ,4, ...	By 1/4 Revolution
2/3 Ta	P ₁ , P ₂ , P ₃ , P ₄ ,...n	1,2 ,3 ,4, ...	By 1/4 Revolution
Ta or 5% more	P ₁ , P ₂ , P ₃ , P ₄ ,...n	1,2 ,3 ,4, ...	By 1/4 Revolution

Tightening Torque:

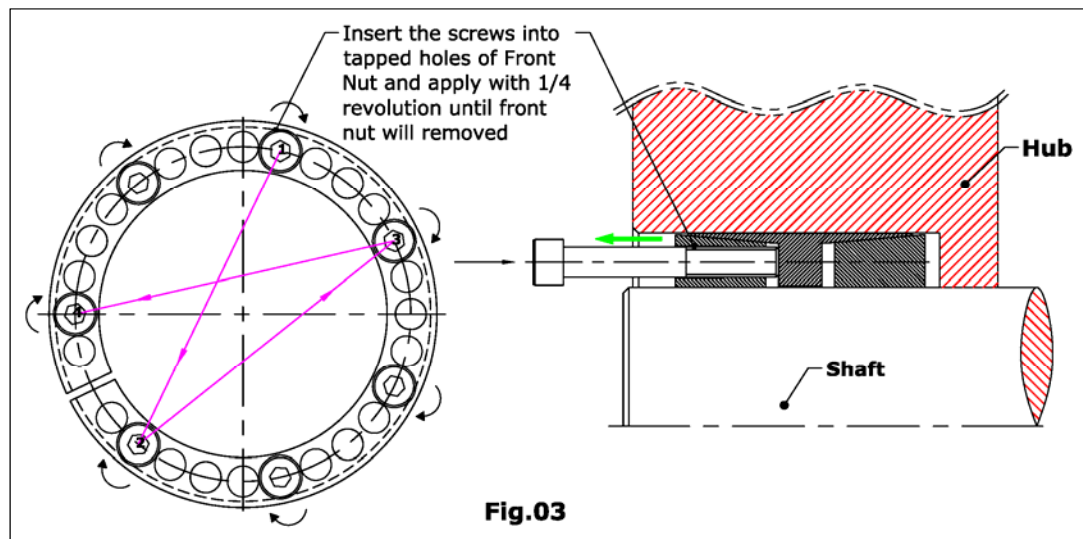
General Application	
Screw Size	Ta(Nm)
M6	17
M8	41
M10	83
M12	145
M14	230
M16	355
M20	690
M22	930

- 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 as per DIN 912 – 12.9 Grade Only.

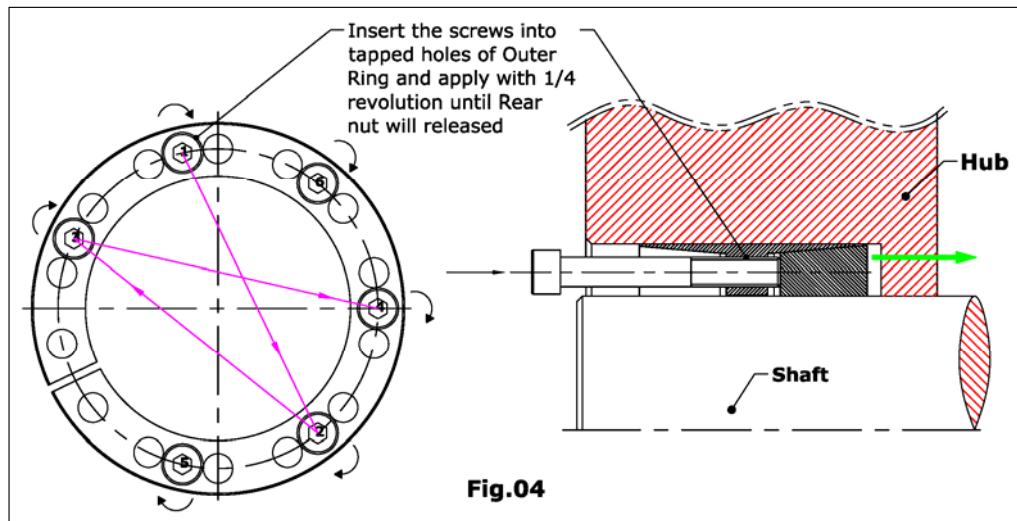
5.) Removal:



- 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 for each step (As shown in Fig.02) to Prevent misalignment of the clamping surfaces and breaking of screws. If completely loosen of single screw at a time take place, then it may lead to tilt inner ring & outer ring and damage of locking assembly occurs.
- For easy jacking process, grind and apply grease on faces of threads and on threads also to reduce friction loss.



- N 7016.1 model is not self-releasing. So after loosening of all screw locking assembly should not automatically release. For removal, transfer screws into removal hole (Type – A) which have been provided on front nut (As shown in Fig. 03). By tightening of some screws into removal holes which lead to jacking of front nut.
- For removal of rear nut, transfer some screw into removal hole (Type – B), Which has been provided on rear nut (As shown in Fig. 04). By tightening of some screw into removal hole which lead to pressing of rear nut.



6.) Reuse:

- For reuse of locking assembly, 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 recheck screws length & if they have been elongated, during operating condition- can't be reused, hence replace (with same size and grade).

7.) Maintenance:

- Locking assembly N7016.1 is maintenance free. We therefore recommend to check tightening torque of the clamping screws each 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:

- NMTG Product is supplied with an oil film as Rust & Corrosion Protection as per below instruction.
- 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.