

Locking Assembly - Model N7014

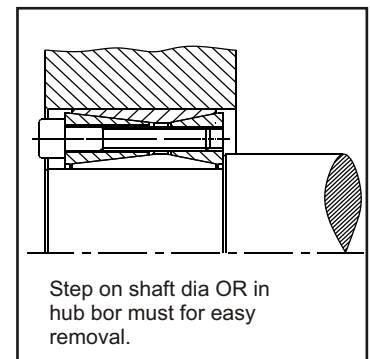


Features:

High transmissible torque. Self centering. Wide double taper design. Fixed axial hub position during assembly. Easy to assemble & disassemble.

Installation:

Make sure shaft and bore contact area(s) are clean and slightly oiled. Loosen all screws by minimum 2 turns and transfer some [2 to 4] screws to push off threads in front thrust nut item [2] to disengage taper seat for easy installation of locking assembly. After insertion of assembly on to shaft & into hub, relocate locking screws used for disengage taper seat. Hand tighten screws slightly and adjust assembly as required. Use torque wrench and set it approximately 5% higher than specified tightening torque (Ma). Tighten screws in diametrically opposite sequence, using only 1/4 turns for several passes, til no screw turn more. Since tightening of a screw will always relax adjacent screws, apply over torque for 1 to 2 more passes (F) to compensate for a system-related relaxation of locking screws. Reset torque wrench to specified torque and check all locking screws. No screw should turn, otherwise repeat step "F" for one or more time.

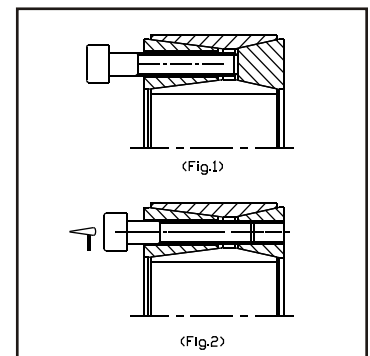


Note: The transmission torque & axial force are in fact directly proportional to the sum of of the pull of the tightening screws and as a consequence, the tightening torque of screw i.e.Ma of screw.

Removal:

IMPORTANT:- Make sure end of removal screws are ground flat & chamfered to eliminate damage to removal threads during push-off. Assure that necessary space for axial movement of front nut is available.

Loosen all screws. Remove & transfer some screws into threads in front thrust nut . Release front & rear nut by progressively tightening screws in diametrically opposite sequence. On several round of tightening screws, complete removal will be achieved. In case of still found difficult to remove assembly, push or hammer the tightening screws (fig. 2) to release rear thrust nut. Remove locking assembly from hub & shaft. Remove all screws from removal threads & reassemble as was. Oil & store assembly.



Tolerances, surface finish:

A good surface finish by machine tool is sufficient. Maximum allowable surface finish : Rt max 16um (0.016mm). Maximum permissible tolerances for hub H8 & for shaft h8.