

INSTALLATION and REMOVAL instruction 1008 & 4061 series

INSTALLATION

Locking assemblies are supplied ready for installation. However, if for some reason they have to be disassembled, make sure that in addition to lined-up slits in all collars, near and far-side clamp collars are not reversed. They are assembled correctly only if there are no holes or threads behind taps in clamp collar item [2]. Likewise, there must be no threads behind taps in center collar item [3] as illustrated in fig. 1-2-3. The frictional torque capacity of these devices is based on a coefficient of friction of $\mu=0,12$ for slightly oiled screws, taper, or shaft and bore contact areas.

- 1 - Make sure shaft and bore contact areas are clean and slightly oiled.
- 2 - Loosen all screws by minimum 2 turns and transfer at least 2 screws to push off threads in clamp collar item [2] and center collar item [3] in order to disengage tapers for easy installation of locking assembly (see fig. 1).
- 3 - After installation of locking assembly, relocate locking screws used for separation of collars.

Locking Devices MAV4061 - MAV1008		Screws DIN 912 class 12.9	Torque Ma (Nm)
Metric Sizes	Inch Sizes		
24 x 55 to 35 x 60	1 to 1-7/16	M 6	17
45 x 75 to 65 x 95	1-1/2 to 2-9/16	M 8	41
70 x 110 to 90 x 130	2-5/8 to 3-5/8	M 10	83
100 x 145 to 120 x 165	3-3/4 to 4-3/4	M 12	145
130 x 180 to 160 x 210	4-15/16 to 6	M 14	230
170 x 235 to 260 x 325	6-1/2 to 8	M 16	355
280 x 355 to 340 x 425		M 20	690
360 x 455 to 600 x 695		M 22	930

NOTE: For installations subjected to extreme corrosion, the slits in clamp collars item [2] and [4] as well as in center collar item [3] should be sealed with a suitable caulking compound or otherwise.

REMOVAL (refer to Fig. 2 and Fig. 3)

IMPORTANT! Make sure ends of locking screws used for removal are ground flat and ends are slightly chamfered to eliminate damage to screw and collar threads during push-off.

- A - Check to assure that axial movement of clamp collars necessary for release of connection is not restricted.
- B - Remove all locking screws and transfer some into all push-off threads in clamp collar item no.[2].
- C - Release collar no. [2] by progressively tightening all push-off screws. Typically, the push-off screws appear to be completely tight after just one pass of tightening without any noticeable separation. Although it seems that screws can not be tightened further, several more rounds of torquing in a clockwise (or counter clockwise) sequence actually more push-off force to the system and ultimately release part of the front collar. Afterwards, only the screws which are still tight, should be tightened further until complete dismantling is achieved.
- D - Transfer locking screws used for dismantling of collar no.[2] to all push-off threads in center collar item no.[3]. Release collar no.[4] by repeating procedures outlined in step number 3.

WARNING: it is important not to use Molybdenum Disulfide, e.g. Molykote, Never-Seeze or similar lubricants in any locking assembly installation.

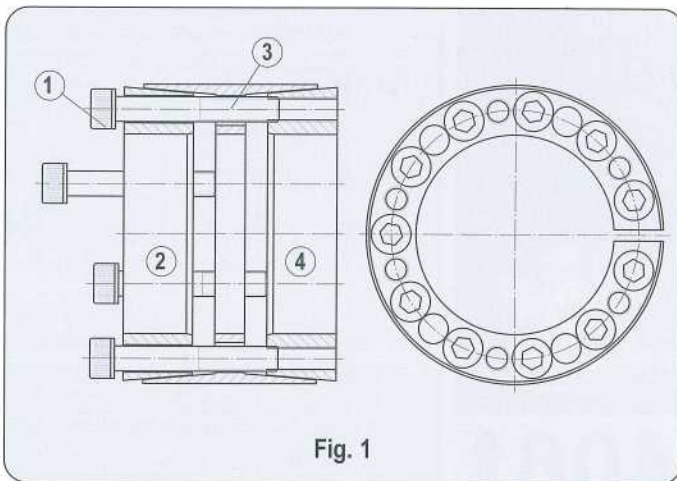


Fig. 1

- 4 - Hand tighten connection and assure that collar item (2) is parallel with face of part to be attached to shaft.
- 5 - Use torque wrench and set it approximately 5% higher than specified tightening (Ma). Torque screws in either a clockwise or counter clockwise sequence, using only 1/4 turns (it is not necessary to tighten in a diametric pattern) for several passes until 1/4 turns can no longer be achieved.
- 6 - Still apply overtorque for 1 to 2 more passes. This is required to compensate for a system-related relaxation of locking screws since tightening of a given screw will always relax adjacent screws. Without overtorquing an infinite number of passes would be needed to reach specified tightening torque.
- 7 - Reset torque wrench to specified torque and check all locking screws. No screw should turn at this point, otherwise repeat step "6" for one or more times. It is not necessary to recheck tightening torque after equipment has been in operation.

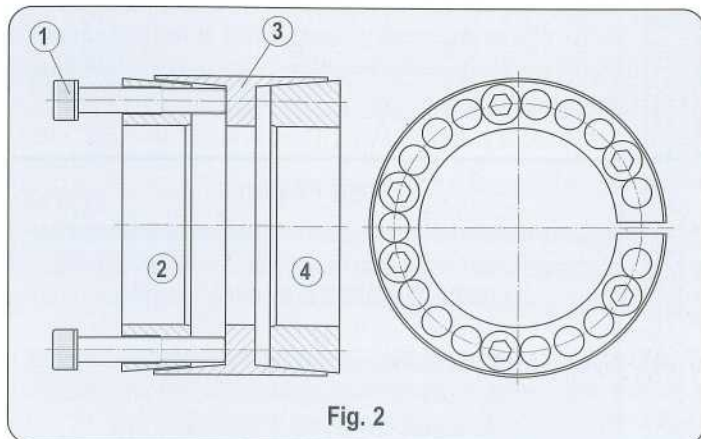


Fig. 2

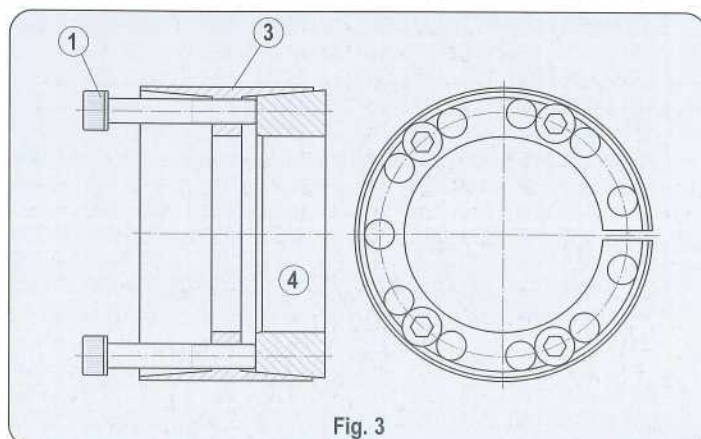


Fig. 3