

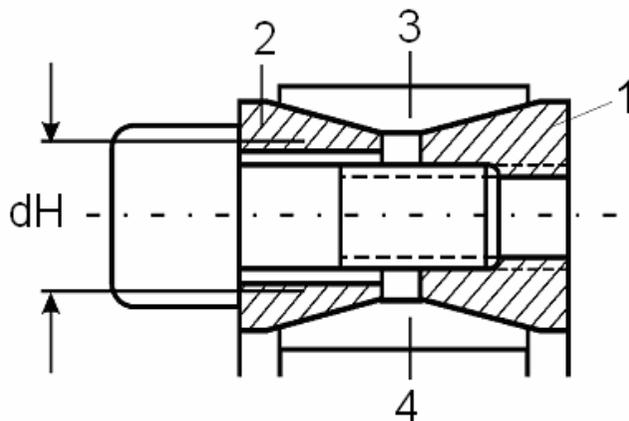
Z2

FITTING AND REMOVAL OF Z-LOCK LOCKING ASSEMBLY

Fitting:

1. All contact surfaces, including threads and heads of locking screws, have to be clean and covered with an oil film. Shaft, Hub and Locking Assembly are to be assembled in this condition.
2. Tighten locking screws lightly and position hub.
3. Tighten locking screws evenly crosswise up to the nominated torque (tighten in 2-3 stages).
4. Re-check the tightening torque of the locking screws all the way round. When no screw can be tightened further with the torque wrench set to the tightening torque M_a , the fitting process is completed.

Note: Used Locking Assemblies, prior to fitting, must be cleaned and lightly oiled, then re-assembled as shown in **Figure 1**. The cadmium plated screws are to be placed through tapped holes of front thrust ring (see dH).

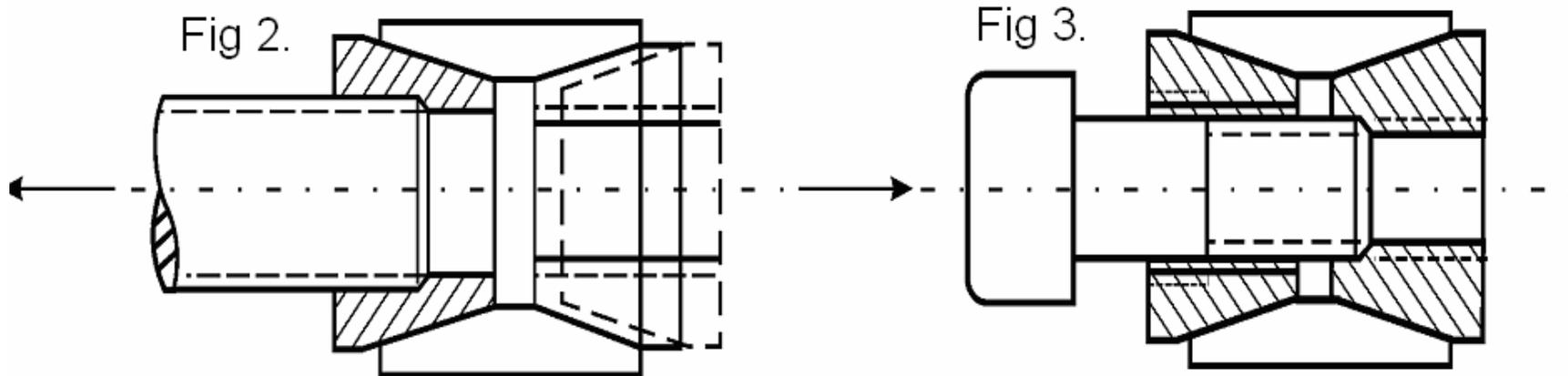


Fig,1

- 1 = Rear thrust ring
- 2 = Front thrust ring
- 3 = Outer ring
- 4 = Inner ring

Removal:

1. Loosen all screws crosswise several turns.
2. Now the loosened connection can be dis-assembled. If necessary, the front and rear thrust ring can be dis-assembled as shown in **Figures 2 and 3.**



Tightening Torques

for screws Gr. 12.9 DIN 912

Screw	M6	M8	M10	M12	M14	M16	M18	M20	M22	M24
Torque Ma(Nm)	17	41	83	145	230	355	485	690	930	1200
dH	M8	M10	M12	M16	M18	M20	M22	M24	M27	M30