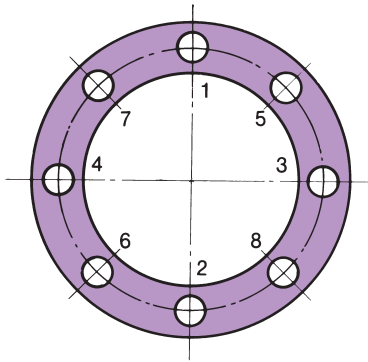


## Mounting and Removal

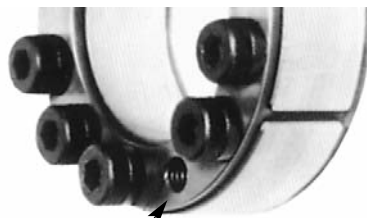
### Mounting

- 1) Clean and lightly oil or grease the shaft and hub bore. (Do not use oil or grease containing molybdenum disulphide.)
- 2) Remove the locking bolts from the POWER-LOCK® and clean and lightly oil, or grease the contact surfaces. Threads and seats of the locking bolts must also be sufficiently lubricated.
- 3) Slip the POWER-LOCK and hub onto the shaft, tighten the locking bolts by hand until a slight positive contact is felt, and set them at the predetermined position, just as you would tighten lug bolts on a car wheel. When it is difficult to slip on, loosen the bolts. (Do not strike with a hammer.)
- 4) Next, determine the relative positioning between the hub and shaft (on the circumference and shaft line), and tighten the four bolts positioned diagonally with 1/4 of the required tightening torque. Proceed to tighten the remaining bolts in the same manner.
- 5) Increase the tightening torque to half of  $M_A$  and tighten the bolts in the same way as in Step 4.
- 6) Increase tightening torque to  $M_A$  and tighten the bolts.
- 7) Check the tightening torque of the locking bolts in sequence. This completes the mounting procedure.

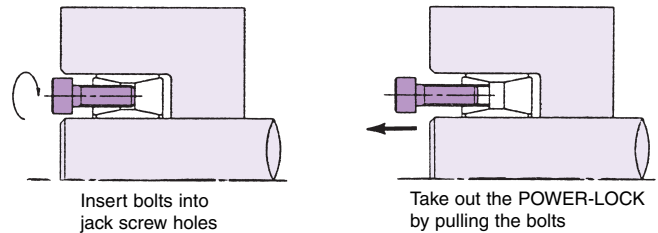


### Removal

- 1) Make sure that no torque or thrust is being applied to the shaft and hub. When shaft and hub are heavy, take them off the shaft carefully.
- 2) After completing Step 1, loosen the locking bolts. (No definite sequence is required.)
- 3) If the POWER-LOCK is still locked even after loosening the bolts, insert bolts into the jack screw holes (see photo below) and screw them in until it unlocks.



Jack Screw Holes for Removal



### Tightening Torque of Locking Bolts

Locking Bolt Size	POWER-LOCK® Model Number (inch)	* Tightening Torque $M_A$ (ft./lbs.)
M6	PL3/4 ~ PL1 1/2	12.3 (10.1)
M8	PL1 5/8 ~ PL2 9/16	29.7 (24.6)
M10	PL2 5/8 ~ PL3 3/4	60.1 (50.5)
M12	PL3 15/16 ~ PL6	105 (87.0)
M14	PL6 1/2 ~ PL8	167
M16	PL8 1/2 ~ PL10 1/2	257
M18	PL11 ~ PL11 13/16	351

Locking Bolt Size	POWER-LOCK® Model Number (metric)	* Tightening Torque $M_A$ (ft./lbs.)
M6	PL019X047 ~ PL040X065	12.3 (10.1)
M8	PL042X075 ~ PL065X095	29.7 (24.6)
M10	PL070X110 ~ PL095X135	60.1 (50.5)
M12	PL100X145 ~ PL160X210	105 (87.0)
M14	PL170X225 ~ PL200X260	167
M16	PL220X285 ~ PL260X325	257
M18	PL250X355 ~ PL300X375	351

\* Figures above in parentheses indicate the tightening torque  $M_A$  for stainless steel bolts, which can be supplied upon request.

### Use a Torque Wrench to Tighten Locking Bolts

The POWER-LOCK ensures transmissible torque ( $M_t$ ) and thrust ( $P_{ax}$ ) only when the locking bolts are tightened to the proper torque. For this reason, use a torque wrench to tighten the locking bolts and thus obtain maximum performance from the POWER-LOCK.

