



OPERATION & MAINTENANCE

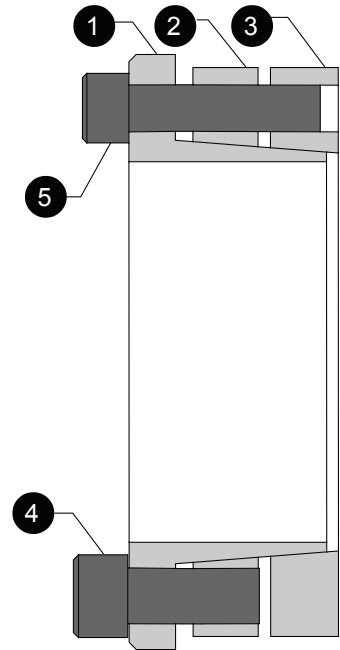
KEYLESS LOCKING ASSEMBLIES FOR RBZ INSTALLATION INSTRUCTIONS

PPI RBZ hubs are manufactured for all pulley types. RBZ hubs are suitable for use with B-Loc B117, MAV 6002, or RFN 7006.2 keyless locking assemblies.

Locking assemblies are supplied ready for installation. They are self-centering and fit straight-thru hub bores. The extended flange results in an axially fixed hub position during assembly. The torque capacity of these devices is based on a coefficient of friction of 0.12 for lightly oiled screws, tapers, shaft and hub contact area. Therefore, it is important NOT to use Molybdenum Disulfide in any locking assembly installation. For example, Molykote, Never-Seeze or similar lubricants.

INSTALLATION

1. Make sure that locking screws, rings, shaft and hub contact surfaces are clean and lightly oiled and that all collar slits are aligned.
2. Loosen all screws by minimum two turns and transfer at least two larger screws [4] to push-off threads in clamp collar item 1 in order to disengage tapers for easy installation of locking assembly.
3. After installation of locking assembly, relocate locking screws used for separation of parts 1, 2, and 3.
4. Hand tighten connection and assure that flanged collar [1] is parallel and in full contact with face of part to be attached to the shaft.
5. Use torque wrench and set it approximately 5% higher than specified tightening torque (Ma), for large screws [4]. Torque large screws in a crosswise pattern sequence, using only 1/4 turn (i.e. 90° for several passes until 1/4 turns can no longer be achieved).
6. Continue to apply over-torque for 1-2 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 over-torquing an infinite number of passes would be needed to reach specified tightening torque.
7. Repeat steps 5 and 6 for smaller locking screws [5], but setting 5% higher of specified tightening torque Ma for the smaller screws.
8. Reset torque wrench to specified torque (Ma) and check all large locking screws and then reset torque wrench Ma and check all small locking screws. No screw should turn at this point, otherwise repeat step 6, 7 and 8. It is not necessary to re-check tightening torque after equipment has been in operation.



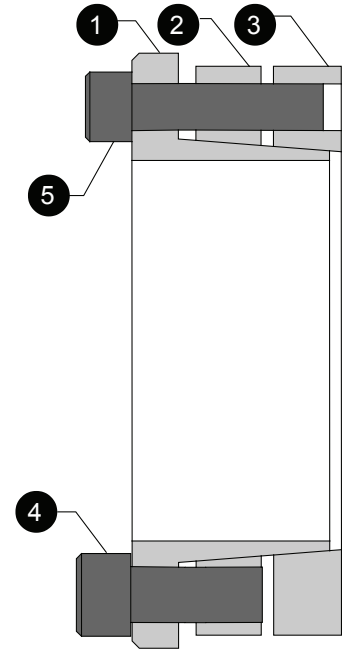
For installation subjected to extreme corrosion, the slits in clamp collars item [2] and [4] as well as in center collar [1] should be sealed with a suitable caulking compound or equivalent. Likewise, push-off threads should also be protected from corrosion.

REMOVAL

Prior to initiating the following removal procedure, check to ensure that no torque or thrust loads are acting on the Locking Assembly, shaft or any mounted components.

It is important the user ensures that ends of locking screws used for removal are ground flat and slightly chamfered to prevent damage to screws and collar threads during push-off. Screws with ground flat and chamfered end are not supplied.

1. Check to ensure that axial movement of clamp collars – necessary for release of connection – is not restricted. Likewise, ensure that push-off threads are in good conditions.
2. Loosen smaller diameter screws [5], but keep in place to secure all collars together.
3. Remove larger diameter locking screws [4] and transfer into all push-off threads in clamp collar [1].
4. Release collar item [2] by tightening all push-off screws in a diametrically opposite sequence, not exceeding 1/4 turns for several passes.
5. Once collar [2] is free, keep tightening all push off screws to push collar [2] into collar [3].
6. Once clearance between collar [2] and [3] is removed, tightening all push-off screws in a crosswise pattern, not exceeding 1/4 turns for several passes.



Bolt sizes and torques for keyless locking assemblies used in PPI RBZ hubs are listed in the table below:

RBZ	Bolt Size	BOLT 1			BOLT 2			Hex Size (mm)
		Bolt Torque (Ma)		Hex Size (mm)	Bolt Size	Bolt Torque (Ma)		
		(ft-lbs)	(N-m)			(ft-lbs)	(N-m)	
80-90	M12	105	142	10	M10	60	81	8
100-120	M14	166	225	12	M12	105	142	10
130-160	M16	257	348	14	M14	166	225	12
170-260	M20	500	678	17	M16	257	348	14
280-600	M24	870	1180	19	M20	500	678	17



CORPORATE OFFICE • P.O. Box 287 • Pella, IA 50219
800.247.1228 • 641.628.3115 • 641.628.3658 FAX