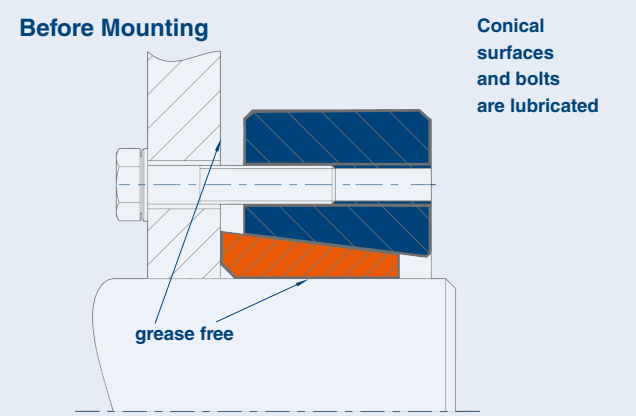
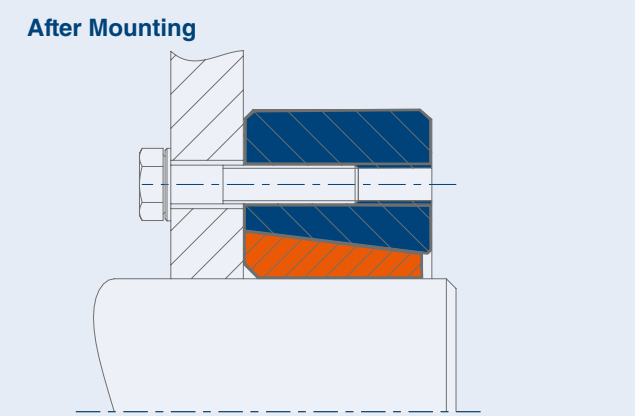
Mounting and Removal Instructions for

STÜWE® Locking Unit AS





Mounting

The STÜWE® locking units AS are supplied ready to be mounted. Therefore they should not be dismantled prior to employing the unit for the first time.

1. Using a solvent, degrease the shaft, bores and faces of the inner ring and the pressure contact faces of the component. Safe torque transmission substantially depends on this procedure. Dirty solvent or cleaning clothes should not be used for degreasing.
2. Lubricate the threads and the heads of the tightening bolts with a suitable bolt lubricant.
3. Bolt component and locking unit together easily and push locking unit onto the shaft.

Do not tighten the tightening bolts before the shaft is mounted.

4. Tighten four bolts evenly distributed over the circumference by reduced torque (approx. 50 to 70 % of maximum tightening torque).
5. Afterwards tighten all tightening bolts uniformly, one by one, over several revolutions with the maximum torque.
   - Series 12: Tighten all tightening bolts until the side surfaces of the outer ring and inner ring abut against the component. This indicates that the full transmissible torque is achieved.
   - Series 22/23: Tighten all tightening bolts until the outer ring hits the inner ring and until the bolts can not be tightened with the max. torque anymore. A gap between outer ring and component can remain.
6. Check each tightening bolt twice for the required tightening torque.

Dismounting

1. Loosen all locking bolts uniformly one by one, initially not more than a quarter turn per bolt, until it is observed that the outer ring has released from the inner ring.

Under no circumstances should the locking bolts be completely removed as this could be dangerous and result in injury.

2. Should the outer ring not-self release from the inner ring, this can be assisted in the series 22 and 23 by removing those locking bolts adjacent to the tapped holes provided for jacking purposes and screwing them into these tapped holes. The jacking procedure must continue until release of the outer ring is achieved.
3. Remove component from locking unit and locking unit from shaft. Remove rust which may have formed on the shaft.

Cleaning and greasing

Dismantled locking unit does not have to be taken apart and regreased before remounting.
The locking unit has to be cleaned and regreased only if employed in dirty environment.

Use a solid containing lubricant with a high content of MoS_2 and a coefficient of friction of μ = 0,04 for the conical surfaces. Usually a combination of bonded coating and paste is chosen.

Examples:

Lubricant	Source
Molykote D 321 R (bonded coating)	Dow Corning
Aema-Sol MO 84-K (bonded coating)	A.C. Matthes
Molykote G Rapid + (paste)	Dow Corning
Aema-Sol M 19 P (paste)	A.C. Matthes

The bolts have to be renewed if possible.
The bolts are lubricated with commercially availabe bolt lubricants (μ = 0,1)

STÜWE®
Stüwe GmbH & Co. KG - Zum Ludwigstal 35 - 45527 Hattingen - Germany
Tel. +49 2324 394-0 - Fax +49 2324 394-30 - www.stuewe.de - info@stuewe.de