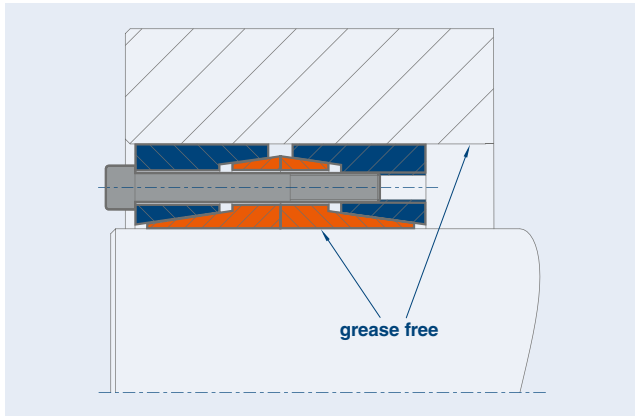


# Mounting and Removal Instructions for **STÜWE® Locking Unit IS**



## Mounting

The STÜWE® locking units IS are supplied ready to be mounted. Therefore they should not be dismantled prior to employing the unit for the first time. Do not use additional Lubricant!

1. Degrease shaft and hub bore.
2. Slightly oil hub bore hole and shaft with hydraulic oil (e.g. HLP 46 or HLP 68).
3. Loosen the tightening bolts, but do not remove them completely. Screw a minimum of three bolts into the additional tap-holes. By doing this a good fit will be achieved and canting of the locking unit will be avoided.
  - When using Type IS 4 or IS 4.1 three bolts each have to be fitted into the jacking tap-holes of the external and the internal pressure ring.
4. Mount the locking unit and align the complete arrangement.
5. Relocate the tightening bolts to the tightening tap-holes.



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

6. Tighten all tightening bolts uniformly, crosswise one by one, over several revolutions. All bolts have to be tightened until the correct full tightening torque is achieved. Check the correct full tightening torque of all bolts one after the other by means of a torque wrench. All bolts must be tightened correctly.

## Dismounting

1. Loosen all tightening bolts in repeated steps, initially not more than a quarter turn per bolt, crosswise one after the other. Do not completely loosen the bolts.



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

2. Dismount as many bolts as jacking tap-holes are present and screw the bolts into them.
3. Fasten the jacking bolts, crosswise one after the other, until the connection is loose.
4. Jacking bolts on both sides of a slot have to be fastened consecutively.

## Re-mounting

1. Control the complete locking until for wear and tear before re-using it.
2. When using Type IS 4 make sure to assemble the locking unit in correct order.
3. When disassembled completely clean and degrease all parts properly, then slightly oil them with hydraulic oil (e.g. HLP 46 or HLP 68).
4. Reassemble the locking unit.
5. Continue as described under "Mounting"