

Posi-Lok® Keyless Bushing Instructions

PSL-G(-C)

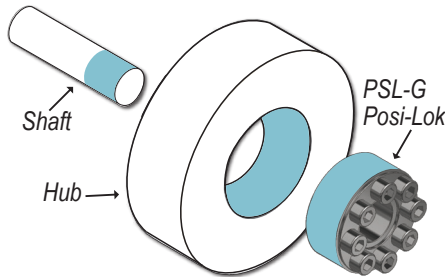
Installation Instructions for PSL-G(-C) Series

Tools Required

- Calibrated torque wrench
- Cleaning cloth
- Caliper

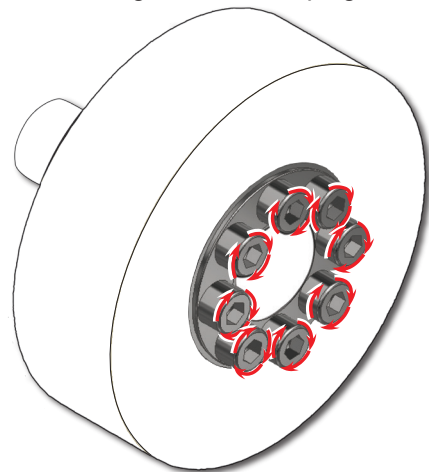
- These instructions are for standard Posi-Lok G-series keyless shaft bushings with normal running and environmental conditions. Special models or conditions may require different instructions.

- Verify shaft and hub dimensions are within the specified range. Wipe rust, dust, and oil completely off of all mating surfaces on the shaft, hub, and Posi-Lok. Do not disassemble Posi-Lok parts. Never allow oil containing molybdenum



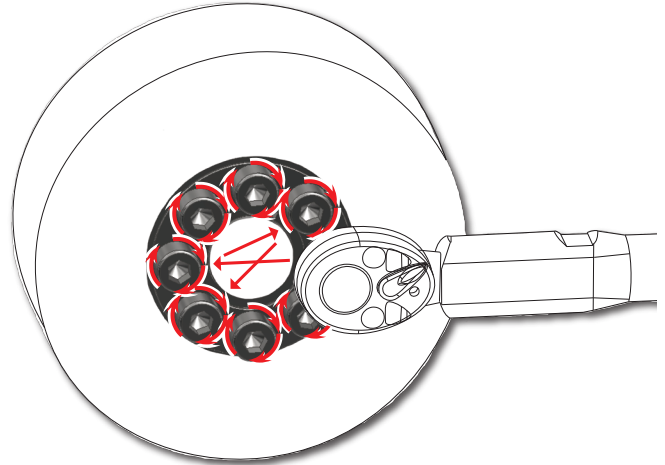
disulfide or grease to contact these surfaces as it will affect the coefficient of friction.

- Do not tighten the clamping screws before installation. Slide the Posi-Lok onto the shaft and slide the hub being mounted over the outside diameter of the Posi-Lok. Loosen the clamping screws slightly if necessary. Position the Posi-Lok assembly to the desired location, making sure both the shaft and the hub engage the



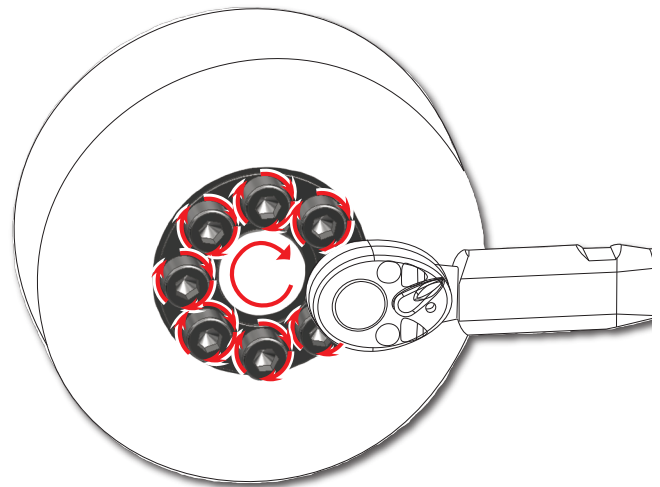
full length of the bushing. Hand tighten each clamping screw lightly to gently grip the hub and shaft.

- Using a calibrated torque wrench, tighten the clamping screws gradually and evenly in a diagonal pattern. For best results it is recommended to use at least (4) tightening iterations to reach the specified tightening



torque (see page 2), evenly increasing the tightening torque each iteration (for example, 25% each time if using 4 iterations).

- Make a final tightening of all clamping screws in a sequential pattern to the specified torque using a



calibrated torque wrench. Do not over tighten. Check the tightening torque again periodically after operating.

⚠ Caution: Rotating equipment is potentially dangerous and should be properly guarded. It is the responsibility of the machine builder, user, or operator to follow all applicable safety codes and provide a suitable guard. Make sure the machine is “locked out” and cannot be accidentally started during installation or maintenance of bushing.

Posi-Lok® Keyless Bushing Instructions

PSL-G(-C)

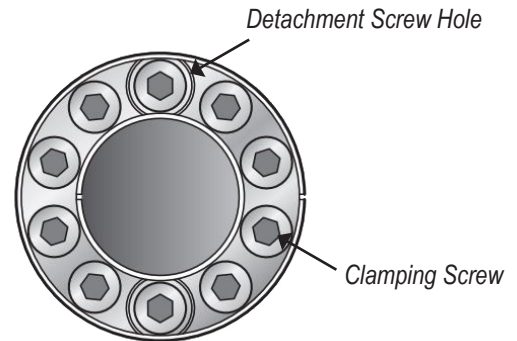
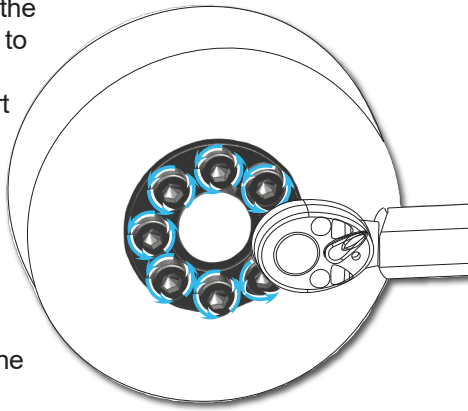
Clamping screw tightening torque

PSL-G(-C)	Clamping Screw Quantity	Clamping Screw Size	Tightening Torque [in-lb]	Detachment Screw Size
19-25(-C)	8	M6	150	M8
28-30(-C)	10	M6	150	M8
32-35(-C)	12	M6	150	M8
38-40(-C)	14	M6	150	M8
42-50(-C)	12	M8	363 (30 ft-lb)	M10
55-60(-C)	14	M8	363 (30 ft-lb)	M10
65	16	M8	363 (30 ft-lb)	M10
70-80	14	M10	726 (61 ft-lb)	M12
85-90	16	M10	726 (61 ft-lb)	M12
95	18	M10	726 (61 ft-lb)	M12
100-110	14	M12	1,257 (105 ft-lb)	M14
120	16	M12	1,257 (105 ft-lb)	M14

Removal Instructions for PSL-G(-C) Series

REMOVAL

- Make sure there is no torque or load applied to the Posi-Lok. Ensure safety.
- Gradually loosen each clamping screw to release the Posi-Lok.
- Do not forcibly remove the Posi-Lok as it may cause damage to the shaft, hub, and/or body. If necessary, first tap the heads of the clamping screws to release the rear taper. Next, insert screws into the detachment screw holes (which are one size larger than the clamping screws), tighten evenly, and tap the screw heads to release the front taper.



⚠ Caution: The Posi-Lok bushing is designed to release immediately when clamp screws are loosened

/////// ZERO-MAX®