

Posi-Lok® Keyless Bushing Instructions PSL-K(-B/-C/-F)

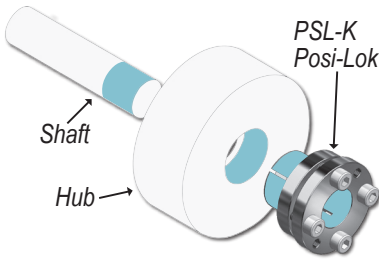
Installation Instructions for PSL-K(-B/-C/-F) Series

TOOLS REQUIRED

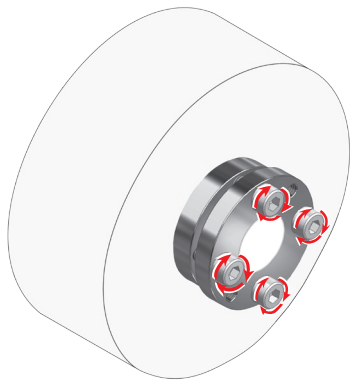
- Calibrated torque wrench
- Cleaning cloth
- Caliper

INSTALLATION

- These instructions are for standard Posi-Lok K-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 sleeve of the Posi-Lok. Loosen the clamping screws slightly if necessary, keeping the flanges attached. Position the Posi-Lok assembly to the desired location, making sure that the shaft engages the full length of the bushing and that the hub engages the full length of the bushing sleeve. Hand tighten each clamping screw lightly to gently grip the hub and shaft.



⚠ 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.

- Using a calibrated torque wrench, tighten the clamping screws gradually and evenly in a continuous diagonal pattern until the specified tightening torque is reached (see page 2). Special attention may be required if high accuracy mounting in the axial direction is desired. When the hub is assembled as shown below in Figure 1, the outer sleeve and hub will move slightly in the axial direction when tightening. When the hub is assembled as shown below in Figure 2, the outer sleeve and hub will not move in the axial direction when tightening; however, the rated torque, thrust, and contact pressures decrease to approximately 70% of specified values.

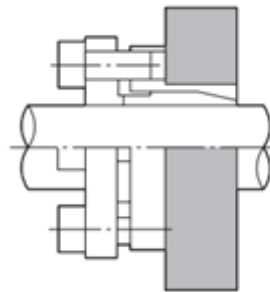
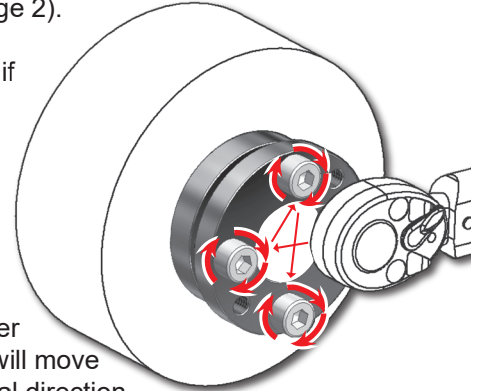


Figure 1

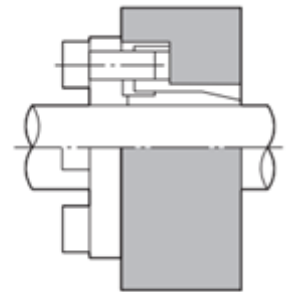
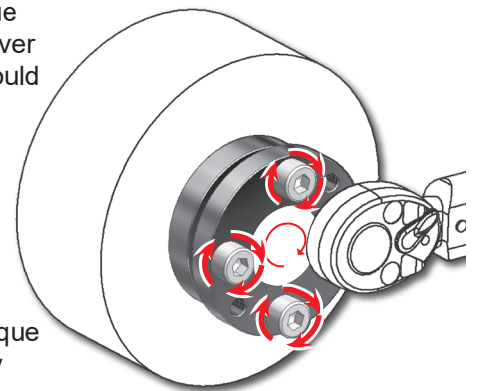


Figure 2

NOTE: The clamping screws of the PSL-K-F are made of stainless steel and can be easily damaged. Careful handling and slow tightening are required to prevent damage. Make sure to use PSL-K-F tightening torque values (Table 2).

- 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. There should be some space between the flanges of the inner and outer sleeve when installation is complete. Check the tightening torque again periodically after operating.



Posi-Lok® Keyless Bushing Instructions

PSL-K(-B/-C/-F)

Clamping screw tightening torque

Table 1

PSL-K(-B/-C)		Clamping Screw Quantity	Clamping Screw Size	Tightening Torque [in-lb]	Detaching Screw Size
6-7	1/4	2	M4	18	M4
8-14	3/8, 1/2	3	M4	35	M4
15-20	5/8*, 3/4*	4	M5	71	M5
22-25	7/8*, 1*	6	M5	71	M5
28-32		6	M6	124	M6
35-42		8	M6	124	M6

*-C Only

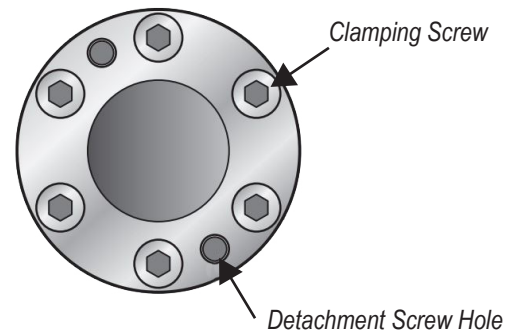
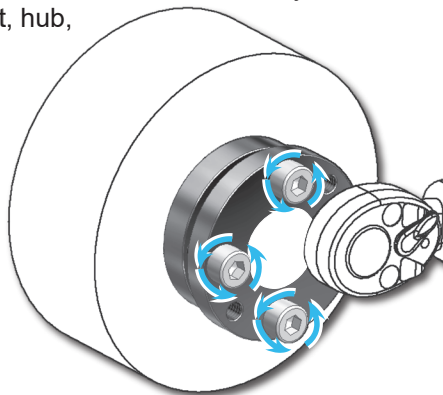
Table 2

PSL-K-F		Clamping Screw Quantity	Clamping Screw Size	Tightening Torque [in-lb]	Detaching Screw Size
6-7	1/4	2	M4	18	M4
8-14	3/8, 1/2	3	M4	31	M4
15-20		4	M5	62	M5
22-25		6	M5	62	M5
28-32		6	M6	106	M6
35		8	M6	106	M6

Removal Instructions for PSL-K(-B/-C/-F) Series

REMOVAL

- Make sure there is no torque or load applied to the Posi-Lok. Ensure safety.
- Gradually loosen each clamping screw to open a gap between the flange and clamping screw surface of about 2mm to release the Posi-Lok. Do not completely unscrew the clamping screws making sure the flanges remain attached.
- Do not forcibly remove the Posi-Lok as it may cause damage to the shaft, hub, and/or body. If the Posi-Lok has not released after loosening the clamping screws, insert screws into the threaded detachment screw holes and tighten evenly to release the connection.



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

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