

## Posi-Lok® Keyless Bushing Instructions PSL-M Series

### Installation Instructions for PSL-M Series

#### TOOLS REQUIRED

- Calibrated torque wrench
- Cleaning cloth
- Caliper

#### INSTALLATION

- These instructions are for standard Posi-Lok M-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. Install the hub being mounted over the outside sleeve of the Posi-Lok and carefully slide the Posi-Lok onto the shaft. Loosen the clamping screws slightly if necessary.
- Position the Posi-Lok assembly to the desired location, making sure that the shaft engages the full length of the

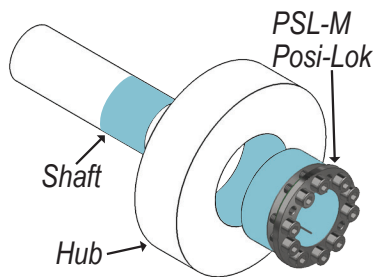
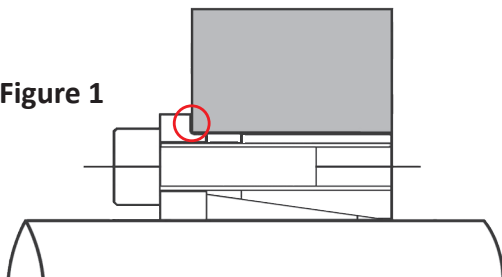


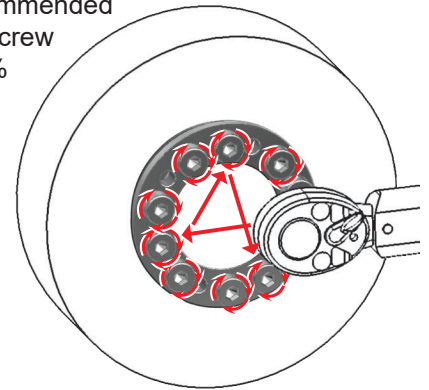
Figure 1



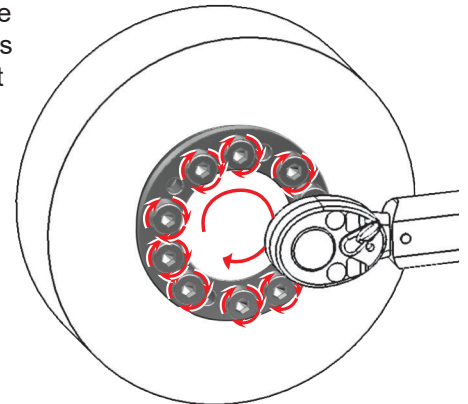
bushing, that the hub engages the full length of the bushing sleeve, and that the flange pilot is in tight contact (no space) with the end of the hub (see Figure 1).

- **Note:** Be sure to leave a space of 1mm or more from the back of the hub to any step surface, and also proper clearance at the bottom of the hub bore if using a counter-bore.

- Using a calibrated torque wrench, tighten the clamping screws gradually and evenly in a diagonal pattern. For best results it is recommended to first tighten each screw to approximately 25% of the specified torque, (see page 2) then 50% of the specified torque, then finally to the specified torque continuing in the diagonal pattern for each iteration.



- Make a final tightening of all clamping screws in a sequential pattern to the specified torque using a calibrated torque wrench. Repeat as necessary. 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-M Series

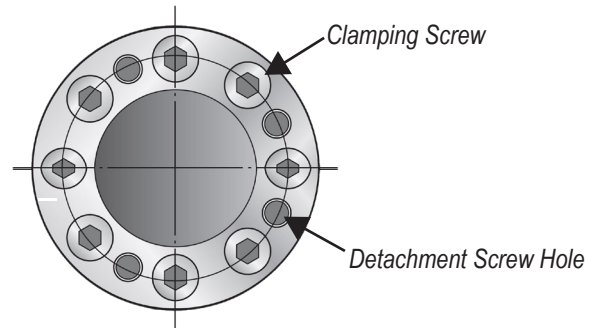
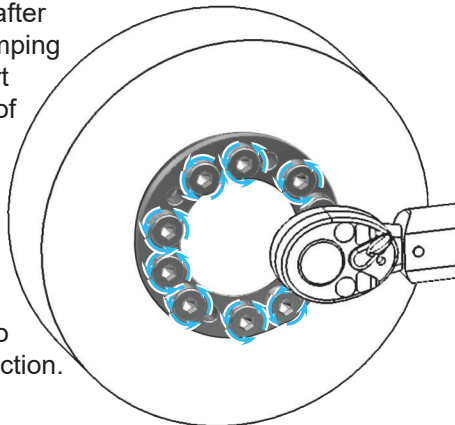
## Clamping screw tightening torque

PSL-M	Clamping Screw Quantity	Clamping Screw Size	Tightening Torque [in-lb]	Detaching Screw Size
20-25	8	M5	78	M5
28-32	10	M5	78	M5
35	8	M6	139	M6
38-48	10	M6	139	M6
48	12	M6	139	M6
50	14	M6	139	M6

## Removal Instructions for PSL-M Series

### REMOVAL

- Make sure there is no torque or load applied to the Posi-Lok. Ensure safety.
- Gradually loosen each clamping screw in sequential order 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 the Posi-Lok has not released after loosening the clamping screws, next insert screws into each of the threaded detachment screw holes and tighten them gradually and evenly in a diagonal pattern to release the connection.



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

**ZERO-MAX**