

## Posi-Lok® Keyless Bushing Instructions PSL-D(-C)

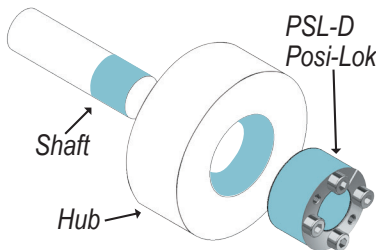
### Installation Instructions for PSL-D(-C) Series

#### TOOLS REQUIRED

- Calibrated torque wrench
- Cleaning cloth
- Caliper

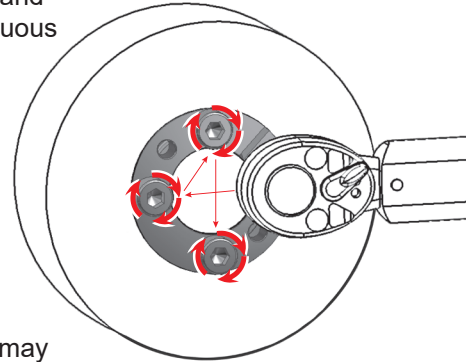
#### INSTALLATION

- These instructions are for standard Posi-Lok D-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.

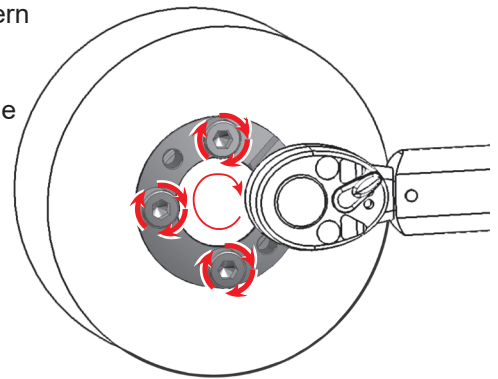


Loosen the clamping screws slightly if necessary. Position the Posi-Lok assembly to the desired location, making sure both the shaft and the hub engage the full length of the bushing. Hand tighten each clamping screw lightly to gently grip the hub and shaft.

- Using a calibrated torque wrench, tighten the clamping screws gradually and evenly in a continuous diagonal pattern until the specified tightening torque is reached (see page 2). The hub will move slightly in the axial direction when tightening. Special attention may be required if high accuracy mounting in the axial direction is desired.



- 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-D(-C)

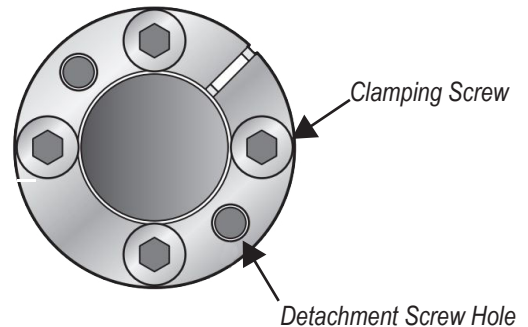
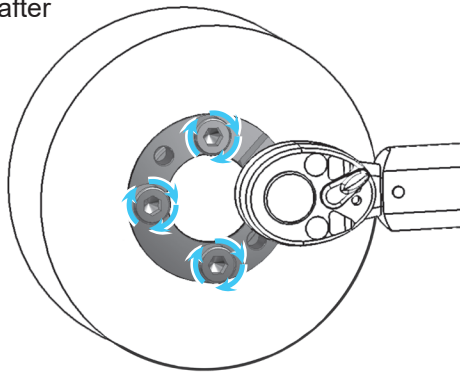
### Clamping screw tightening torque

PSL-D(-C)	Clamping Screw Quantity	Clamping Screw Size	Tightening Torque [in-lb]	Detaching Screw Size
6-8	3	M2.5	9	M2.5
9-12	4	M2.5	9	M2.5
14-15	4	M3	18	M3
16-19(-C)	4	M4	35	M4
20-22(-C)	4	M5	71	M5
24-25(-C)	4	M6	124	M6
28-32(-C)	6	M6	124	M6
35-40(-C)	8	M6	124	M6
42-45(-C)	6	M8	301 (25 ft-lb)	M8
48-50(-C)	8	M8	301 (25 ft-lb)	M8

### Removal Instructions for PSL-D(-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 the Posi-Lok has not released after loosening the clamping screws, next 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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