

## **Phas-Lok Adjusting Hubs**

# Installation Instructions for Phas-Lok Adjusting Hub Assemblies

#### TOOLS REQUIRED

- Calibrated torque wrench with sockets for hub locking bolts
- Hex drive bits for phase-adjusting screws and hub setscrew
- · Cleaning cloth
- These instructions are for standard series Phas-Lok Adjusting Hubs with normal running conditions. Special Phas-Lok Adjusting Hubs may have different drawings or instructions.

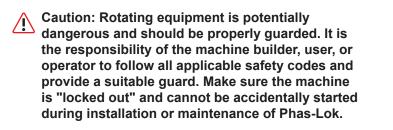
#### INSTALLATION

- Inspect shaft, Phas-Lok Hub, bore, key, and keyway making sure there are no burrs. Clean hub bore, shaft, and disc mounting face with a cleaning cloth. Clean bore and mating surface of mounted component (sprocket, timing pulley, gear, etc.).
- Machine bore of mounted component (sprocket, timing pulley, gear, etc.) to provide a clearance-fit with the Phas-Lok Hub pilot diameter, see Table 6. Mount the machined component to the Phas-Lok Disc with grade-5 or better screws, tightening to the specifications listed in Table 3. These screws are customer-supplied.
- Mount Phas-Lok Adjusting Hub Assembly onto shaft with installed key, leaving set-screw loose for the moment. Attach Phas-Lok Disc to Phas-Lok Hub, making sure disc post is clear, then loosely install locking bolts to maintain hold of disc to hub.
- Position Phas-Lok Hub Assembly linearly on the shaft to align with driver/driven component. Tighten hub setscrew to shaft according to torque requirements listed in Table 4. Alternately, when using a QD or Browning Bushing, install according to the manufacturer's instructions.
- Use hex drive bit and wrench to alternately tighten/ loosen phase-adjusting screws as needed to obtain the desired phase adjustment ('clocking'). Next, use a torque wrench to tighten hub clamping screws according to recommended torque specifications listed in Table
  Lastly, tighten phase adjusting screws against disc post to the specifications shown in Table 5 to prevent loosening during operation.



#### REMOVAL

 Disconnect power from machine and lockout/ tagout. General removal process is the reverse of the installation process.



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#### **Recommended Minimum Sprocket Size**

Minimum Sprocket Size (# Teeth)									
Chain	25	35	41	40	50	60	80	100	120
Series A	35	25	19	20	16	15	*	*	*
Series B	52	32	24	24	21	19	15	13	*
Series C	84	54	39	40	32	27	23	20	18

\*Not recommended

Table 1

## Screw Sizes and Tightening Torque

Table 3

Hub

Series

А В

С

Table 2					
Hub Series	SAE Grade 5 Hub Clamping Cap Screw(s)	Tightening Torque			
А	1/4-20 UNC	95 IN-LB			
В	1/4-20 UNC	95 IN-LB			
С	1/2-13 UNC	840 IN-LB			

#### Table 4

Hub Series	Hub Set-Screw Size	Tightening Torque
А	1/4-20 UNC	45 IN-LB
В	1/4-20 UNC	45 IN-LB
С	3/8-16 UNC	120 IN-LB

Table 5				Table 6			
Hub Series	Phase-Adjusting Screw Size	Tightening Torque		Hub Series	Hub Pilo O.D.		
А	1/4-20 UNC	40 IN-LB		А	1.250"		
В	5/16-18 UNC	60 IN-LB		В	2.125"		
С	1/2-13 UNC	200 IN-LB		С	3.500"		

SAE Grade 5

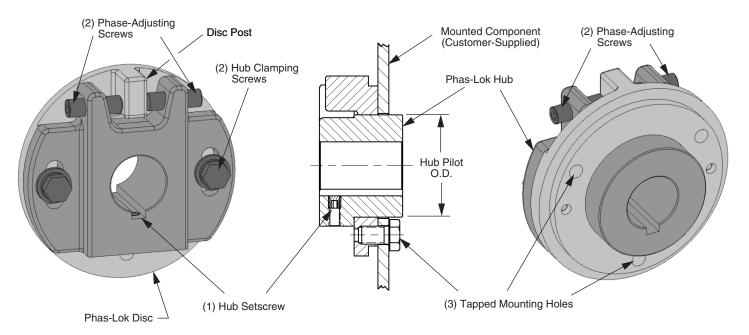
**Component-Mounting** 

Cap Screw(s)

1/4-20 UNC

1/4-20 UNC

1/2-13 UNC





13200 Sixth Avenue North, Plymouth, MN 55441-5509 Phone 763.546.4300 = Fax 763.546.8260 = TOLL FREE 1.800.533.1731 = www.zero-max.com Disc

Threaded

**Hole Depth** 

0.500 MAX

0.485 MAX

0.750 MAX

ıb Pilot O.D.

Tightening

Torque

95 IN-LB

348 IN-LB

840 IN-LB