

FITTING AND REMOVAL OF TAS 3003/3006 LOCKING ASSEMBLIES

N. B. Do not use any molybdenum disulphide.

The locking assemblies are delivered by the manufacturers oiled and are ready to be fitted.
Additional hub centring arrangements are not absolutely necessary as the concentricity is 0.02 to 0.04 mm.

Fitting:

1. At least 3 screws, evenly spaced around the circumference, must be screwed into the flanges' lifting screw holes which are protected by plastic plugs. As a result, the bushes and rings are held apart due to the stopping effect of the taper and cannot tilt during fitting.
2. Tighten locking screws delicately and carefully until the locking assembly is located in place without any play. Remove lifting screws and tighten with the remaining screws.
3. Tighten all screws evenly by tightening them crosswise covering the whole circumference several times, until the given torque has been reached for each screw. Make sure that the screws to the left and right of the slot are tightened one after the other.

Removal:

Loosen all locking screws several turns and insert one screw into each of the bush's lifting screw holes after removing the plastic plugs. Tighten these screws crosswise to loosen the connection. Tighten the screws to the left and right of the slot one after the other.

Tightening torques in Nm for DIN 912 screws

DIN 912		M 6	M 8	M 10	M 12	M 14	M 16	M 18	M 20	M 22
10.9	$\mu = 0.14$	14	35	69	120	190	295	405	580	780
	$\mu = 0.125$	13	32	64	110	180	275	390	540	720
12.9	$\mu = 0.14$	17	41	83	145	230	355	485	690	930
	$\mu = 0.125$	16	39	77	135	215	330	455	650	870

N. B.

Screws which are re-oiled on fitting should be tightened to a reduced torque ($\mu_{scr.} = 0.125$) to avoid possible overloading, especially in the case of screws of 12.9 quality.

TAS 3003



TAS 3006

