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INSTALLATION AND REMOVAL INSTRUCTIONS FOR CANTO-LOCK LOCKING ASSEMBLY SERIES C - 1020

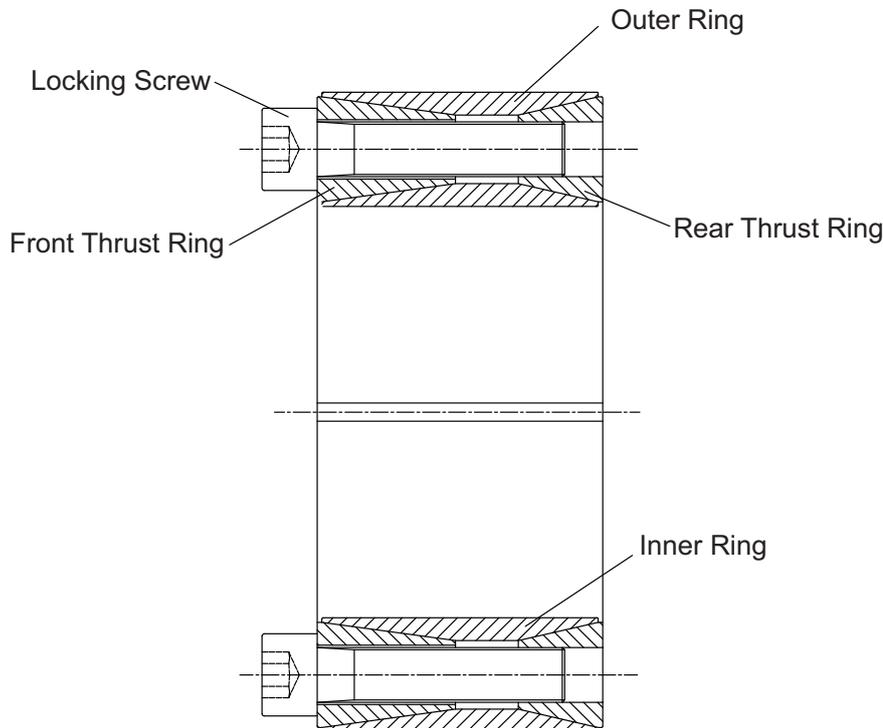
CANTO-LOCK C - 1020 Locking Assembly is supplied ready for installation. The torque capacity of this device is based on a coefficient of friction of $\mu=0.12$ for lightly oiled screws, tapers, shaft and hub contact areas. Therefore, it is important NOT to use Molybdenum Disulfide (e.g., Molykote, Never-Seeze or similar lubricants) in any Locking Assembly installation.

The hub must be provided with a centering face to allow good concentricity connection, as the Locking Assembly is not self-centering.

INSTALLATION

1. Make sure that locking screws, rings, shaft and hub contact surfaces are clean and lightly oil ed.
2. After positioning Locking Assembly between shaft & hub, successively hand tighten the screws in a clockwise pattern, so that most of the play is taken up but still leaving Locking Assembly free to move.
3. After confirming correct hub position, successi vely hand tighten the screws following a clockwise pattern, until the assembly is locked.
4. Use torque wrench and set it approximately 5% higher than specified tightening torque (Ts). Torque screws in a clockwise pattern, using only 1/4 turns for several passes until 1/4 turns can no longer be achieved.
5. Still apply overtorque for 1-2 more passes. This is required to compensate for a system-related relaxation of locking screws since tightening of a given screw will always relax adjacent screws. Without overt orquing an infinite number of passes would be needed to reach specified tightening torque.
6. Reset torque wrench to specified torque (Ts) and check all locking screws. No screw should turn at this point, otherwise repeat step 5 for 1 or 2 more passes. It is not necessary to re-check tightening torque after equipment has been in operation.

NOTE : for installation subjected to extreme corrosion, the slits in inner and outer rings should be sealed with a suitable caulking compound or equivalent.



REMOVAL

NOTE : Prior to initiating the following removal procedure, check to ensure that no torque or thrust loads are acting on the Locking Assembly, shaft or any mounted components.

1. Loosen all locking screws in several stages. CANTO-LOCK C - 1014 series feature self-releasing tapers, meaning thrust rings should release automatically. If for some reason the thrust rings jam, a light tap on 3 equally spaced heads of loosened locking screws will release the connection
2. Hub and Locking Assembly are normally removed together . Removal of Locking Assembly only from deep counterbores is accomplished by inserting pull -off screws or threaded bars (not provided) into threads located under zinc plated locking screws. These threads are NOT to be used for high pulling forces