



This assembly and operating manual is a significant component of the HKN clamping hub system.

Keep the manual complete and always readily available close to the clamping hub. All personnel working on assembling, operating, servicing and maintaining equipment should have read and understood the manual.

Follow all instructions and the corresponding legal safety protection measures about technical working media (equipment safety law)!

Integration of the clamping hub may only be performed by authorized personnel and drive elements may only be used exclusively for their intended use and within the specified technical operating limitations.



1. Delivery condition

Clamping hubs are delivered as complete assemblies.

2. Inspection

- Dimensional control of the shaft: Diameter and peak to valley roughness max. RZ16
- Dimensional control of the hub according to drawing
- Joining areas must be free of any damage

3. Assembly

The clamping hubs must not be tightened without the proper shaft!

- Joining surfaces (hub bore and shaft) must be thoroughly degreased. Do not touch again after degreasing. Even small amounts of lubrication or grease can negatively affect the torque to be transmitted!
- Push the hub onto the shaft and position the clamping hub to the adapter.
- Tighten the tensioning screws with a torque wrench using approx. 10 % of the defined tensioning torque (NOT diagonally). Several passes with the same torque must be applied during this, until there is no more movement detected in the screws. Only then apply the desired torque to the screws.
- Check concentricity and run-out and align if necessary.
- Tighten the tensioning screws as described above with approx. 20 % of the defined tightening torque. Here too, as described above, several passes with the same torque must be applied.
- Repeat this process with 30 %, 40 %, etc. of the torque until the defined torque is applied to all screws.



Rotating clamping hubs are hazardous locations. The operator must ensure appropriate safety measures. Do not reach into the working area of the clamping hub if it is still rotating. Secure the machine against unintended switch on during assembly work.

4. Inspection

The clamping ring must be flush with the hub.

5. Disassembly

The design characteristic of the integrated press-fit technology also enables removal by the tensioning screws. By loosening the tensioning screws (in sequence, NOT diagonally), the clamping ring is automatically loosened and pressed from the conical seat.

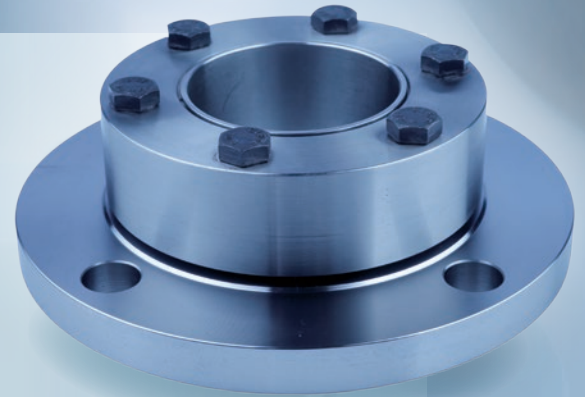
As with the assembly, always only loosen the screws in small steps.

6. Reassembly (after a longer period of time)

If reassembly is required, then it is recommended to completely unscrew the clamping ring, degrease both cone surfaces and clean the threads of the screws.

The cone surface, the threads of the tightening screws and the contact surfaces of the screw heads must be regreased with Weicon Anti-Seize-Standard.

Reassemble as described in point 3.



Declaration of manufacturer

Clutches are not machines in the sense of the Machine Directive (2006/42/EG Appendix IIB), but rather components to be integrated into machines. Startup is prohibited until, by or after integration into the end product, the requirements of the Machine Directive are fulfilled.