

INSTALLATION AND REMOVAL INSTRUCTIONS FOR B-LOC® WK RIGID COUPLING

Please follow these **INSTALLATION AND REMOVAL INSTRUCTIONS** carefully to ensure proper performance of this B-LOC® unit.

ⓘ WARNING ⓘ

When installing or removing **B-LOC®** products, always adhere to the following safety standards:

1. Lockout/Tagout all energy sources and assure all stored energy has been released.
2. Approved eye protection is recommended.

INSTALLATION (Refer to Figure 1)

B-LOC® WK Rigid Couplings are supplied ready for installation. For increased torque transmission, see *Special Considerations*.

Important: Never tighten locking screws before shaft installation, as the WK Rigid Coupling inner ring (3) can be permanently deformed even at relatively low tightening torques.

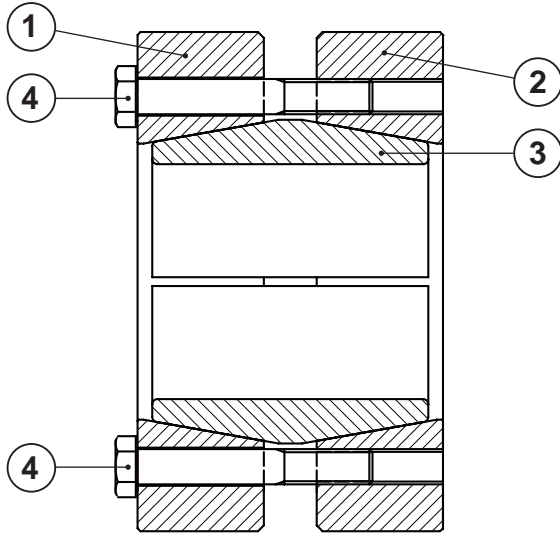


Figure 1

1. Using a non-petroleum based solvent, carefully clean shafts of any lubricants prior to mounting coupling on shafts. **This step is critical, as any contaminants on the shafts may alter the performance of a B-LOC® WK Rigid Coupling connection.**
2. Center coupling over shaft ends. Hand-tighten three or four equally spaced locking screws (4) assuring outer collars (1, 2) of WK Rigid Coupling are parallel. Hand-tighten remaining locking screws.
3. Use a torque wrench set to the overtorque valued listed in the chart. This value is ~5% higher than specified install torque, M_a . Tighten locking screws in either a clockwise or counterclockwise sequence, using approximately 1/4 (i.e., 90°) turns (even if initially some locking screws require a very low tightening torque to achieve 1/4 turns) for several passes until 1/4 turns can no longer be achieved.
4. Continue to apply overtorque for one to two 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 overtorquing, an infinite number of passes would be needed to reach specified install torque.
5. Reset torque wrench to specified install torque (M_a) and check all locking screws. No screw should turn at this point, otherwise repeat Step 3 for one or two more passes. It is not necessary to recheck tightening torque after equipment has been in operation.

REMOVAL (Refer to Figure 1)

ⓘ WARNING ⓘ

Prior to initiating the following removal procedure, check to ensure that no torque or thrust loads are acting on the WK Rigid Coupling, shaft or any mounted components.

ⓘ WARNING ⓘ

DO NOT completely remove locking screws (4) before outer collars (1, 2) are disengaged from inner ring (3). A sudden release of the outer collars involves high separating forces and could result in permanent injury or death. Be certain that outer collars are disengaged from inner ring before completely removing locking screws. **Refer to Figure 1.**

Loosen all locking screws in several stages by using approximately 1/2 turns, following either a clockwise or counterclockwise sequence, until the WK Rigid Coupling can be moved on the shafts. The WK Rigid Coupling will return to its original clearance fit.

REINSTALLATION OF WK RIGID COUPLINGS

In relatively clean operating conditions, WK Rigid Couplings can be reused without prior cleaning. WK Rigid Couplings used under severe conditions, however, require thorough cleaning. Relubricate screws and tapers with Dow Corning® Molykote® G-n Metal Assembly Paste or equivalent. Lightly coat the remainder of the unit with standard machining oil. Upon doing so, install following **INSTALLATION** portion of this document.

SPECIAL CONSIDERATIONS

If your application requires increased torque transmission and/or thrust, in addition to using a non-petroleum based solvent to clean the shafts (as stated in step 1), the bore of the WK Rigid Coupling needs to be cleaned with a non-petroleum based solvent to produce an oil free connection. This in turn will result in up to a 20% increase in M_t and T_h performance values.

LOCKING SCREW SIZES & SPECIFIED INSTALL TORQUE M_a

Screw Type	M6	M8	M10	M12
Overtorque (ft lb)	9.1	23	46	78
Install Torque (ft lb)	8.7	22	44	74
Wrench Size Across Flats (mm)	10	13	16	18

These Screw Sizes Are Installed on the Following WK Series:

M6 – WK 15, 20, 25, 30
M8 – WK 40, 50, 60
M10 – WK 70
M12 – WK 80, 90, 100

Contact Fenner Drives Applications Engineering at ae@fennerdrives.com for additional details.