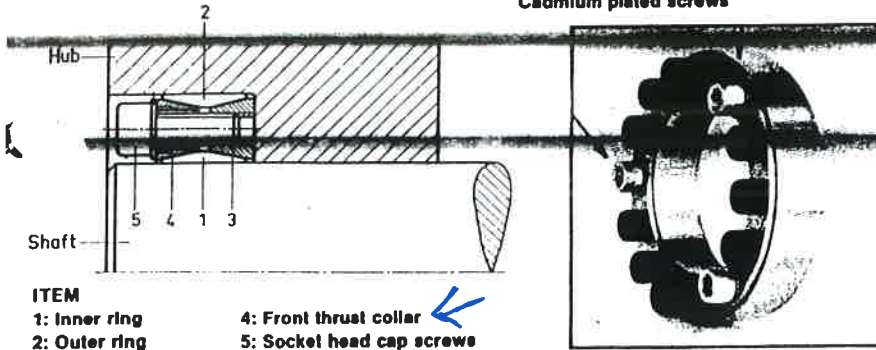


# INSTALLATION & REMOVAL INSTRUCTIONS FOR BIKON LOCKING ASSEMBLIES

Cadmium plated screws

METRIC SERIES 4000

INCH SERIES 4000-IN



- ITEM**  
 1: Inner ring  
 2: Outer ring  
 3: Rear thrust collar

- 4: Front thrust collar  
 5: Socket head cap screws

The BIKON LOCKING ASSEMBLY is a keyless shaft-hub connector providing mechanically the same characteristics as a shrink fit. It is, however, easily adjustable and removable thus facilitating simple assembly and disassembly. Since torque is transmitted by friction between functional surfaces, condition of contact surfaces and proper tightening of the locking screws are of great importance.

**IMPORTANT:** To insure satisfactory performance and easy installation read first and then follow all instructions carefully.

## INSTALLATION

Locking Assemblies are supplied ready for installation. However, used units — after thorough cleaning — should be lightly oiled, including bore, threads and screwhead contact area.

**Do not use Molybdenum-Disulfide, e.g., Molykote or Never-Seeze.**

1. Insert Locking Assembly into hub counterbore prior to shaft installation.
2. After checking correct hub position, handtighten 3 or 4 equally spaced locking screws till initial contact is established.
3. Tighten all locking screws in a diametrically opposite sequence. Initially use approximately 25% of specified tightening torque or even less on the first turns. Gradually increase tightening torque to MA as specified on subsequent tightening passes.

**NOTE:** To compensate for torque reduction due to setting of screws adjacent to a screw just being torqued, a tightening torque approximately 5% higher than specified is recommended for the final round.

4. Reset torque wrench and make sure that no screw will turn any more at specified tightening torque MA.

**NOTE:** It is not necessary to check locking screw tightening torque again after operation of machine!

## REMOVAL

1. Loosen locking screws in several stages by using approx. ¼ turns, following a diametrically opposite sequence.

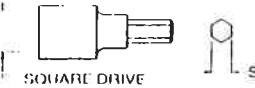
**NOTE:** Locking assemblies feature self releasing tapers. However, if for some reason thrust rings jam, a light tap on 3 equally spaced heads of loosened screws will positively release connection.

2. Although hub and Locking Assembly are normally removed together, removal of Locking Assembly only from deep counterbores is accomplished by inserting pull out screws in threads located under cadmium plated locking screws.

| Locking Assemblies    |                        | Tight. Torque<br>MA<br>ft-lb. | Screw<br>Size | Hex<br>Key<br>Size (s)<br>mm | Square<br>Drive<br>Size | Pull<br>Out<br>Thread<br>(d <sub>B</sub> )* |
|-----------------------|------------------------|-------------------------------|---------------|------------------------------|-------------------------|---|
| Metric Series<br>4000 | Inch Series<br>4000-IN |                               |               |                              |                         |   |
| 20x47 to 40x65        | 1 to 1½                | 11                            | M 6           | 5                            | ¼"                      | M 8   |
| 45x75 to 65x95        | 1 5/8 to 2 9/16        | 26                            | M 8           | 6                            | ¼"                      | M 10  |
| 70x110 to 95x135      | 2 3/4 to 3 3/4         | 51                            | M 10          | 8                            | ¾"                      | M 12  |
| 100x145 to 160x210    | 3 15/16 to 6           | 91                            | M 12          | 10                           | ¾"                      | M 14  |
| 170x225 to 200x260    | 6 1/2 x 7 7/8          | 138                           | M 14          | 12                           | ½"                      | M 16  |
| 220x285 to 260x325    |                        | 214                           | M 16          | 14                           | ½"                      | M 20  |
| 280x355 to 300x375    |                        | 293                           | M 18          | 14                           | ½"                      | M 22  |
| 320x405 to 340x425    |                        | 420                           | M 20          | 17                           |                         | M 24  |
| 360x455 to 420x515    |                        | 565                           | M 22          | 17                           | ¾"                      | M 27  |
| 440x545 to 1000x1110  |                        | 725                           | M 24          | 19                           | ¾"                      | M 30  |

\*d<sub>B</sub> pull out thread, provided only underneath cadmium plate screws of front thrust collar to facilitate Locking Assembly removal.

Hex Bit Socket



**BIKON CORPORATION**

West Mombasha Road  
 RD-1 Box 660  
 Monroe, NY 10950

(914) 782-5650

CAN WE GET  
 #4 - front thrust collar only or do  
 we have to buy the whole piece?