

## SETB28 INSTALLATION INSTRUCTIONS

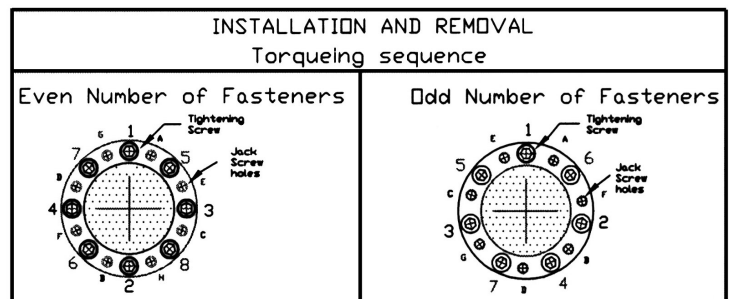
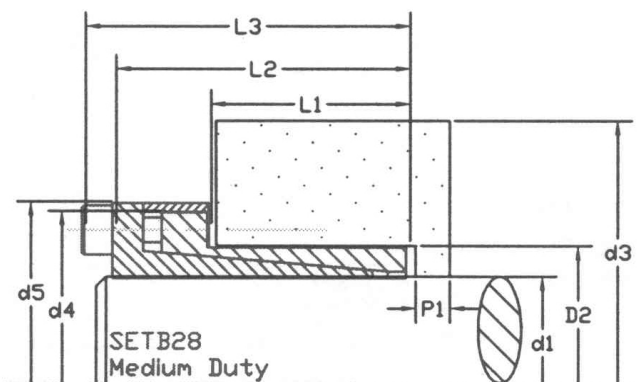
Remove any burrs or raised metal on the shaft and all mating parts. Clean and lightly oil the shaft, hub bore contact area, and the contact areas of the SETB bushing.

**Warning: never use Molybdenum Disulfide, Molykote, Grease or Antiseize on the shaft or parts of the SETB bushing-reduces required friction and can cause a failure!**

1. Loosen all locking screws a minimum of two revolutions. For large installations, transfer several screws to the jack-screw position, snug screws to collar to ensure that the wedges do not prematurely engage during positioning.
2. Slide the SETB bushing onto the shaft, into the bore of the hub and into position.
3. By hand, begin to snug four (4) screws in a star pattern (6, 12, 3 & 9 o'clock for even number), see Fig. 30. To maintain concentricity do not over-tighten. (Gradually disengage jack-screws if used). Snug remaining screws to the collar, do not tighten
4. Verify that the hub is correctly positioned!
5. Set torque wrench at 50% of final torque. Start at 12 o'clock position, begin to evenly tighten, in a clockwise sequence, each screw a maximum of 1/4 revolution. Several passes will be required to achieve the specified screw torque. Note: as the next screw is tightened the previous screw tightened will relax.
6. Continue to make complete passes around the SETB bushing until the torque wrench turns less than 1/8 revolution. Increase the "Final Torque" rating by 5% to compensate for the neighboring screw relaxing.
7. Set torque wrench at the Final Torque specification, randomly check several screws torque. If any screw moves more than 1/16 of a revolution, repeat step 6.

**Removal:**

1. With a star pattern, loosen screws 1/4 turn for five complete passes or until all screws are loose.
2. Transfer screws to the jack-screw position and tighten as in step 5 & 6 above. Do not tighten the jack-screws more than 1/4 turn per pass!
3. If the unit is corroded, a light tapping on the heads of the jack-screws can help the unit release.



### Maximum Tightening Torques

12.9 Socket Head Cap Screw Torque, per DIN 912

Screw Size	M6	M8	M10	M12	M14	M16	M18	M20	M22	M24	M27	M30
"s" mm bit	5	6	8	10	12	14	14	17	17	19	19	22
Drive	1/4"		3/8"			1/2"			3/4"			
Torque Nm	18	42	87	149	240	365	500	709	960	1219	1809	2449
Torque lb-ft	13	31	64	110	177	269	368	523	708	899	1334	1806