

# Clamping assemblies

## Technical information

### Principle of operation

These parts operate on the basis of an interference fit between two conical rings screwed together. The outer ring expands and exerts a pressure on the part being held whilst the inner ring exerts a pressure on a shaft.

### Assembly

Carefully clean all the component parts and then apply a light coating of oil to the contact surfaces. Place one part in the hub and insert the shaft, then tighten the screws in a uniform fashion until the prescribed torque is reached. The Torque ( $T$ ) and Axial Force ( $F_{ax}$ ) figures in the tables have been calculated for an oiled assembly.

### Note:

Do not use Molybdenum Bisulphate based oils or greases as these can significantly reduce the frictional torque.

### Dismantling

Unscrew the screws, inserting them in the extraction holes and increasing the pressure in a gradual and uniform manner until the cones are released. When re-using the pieces, ensure that the screws and threaded holes are oiled.

### Tolerance

A good machine-finish is sufficient.

### Roughness

Maximum admissible roughness:  $R_t \text{ max } 16\mu\text{m}$

### Recommended assembly tolerances

