SHOELOK RETAINING DEVICES
INSTALLATION INSTRUCTIONS

Ideal Tools:

Hex wrench and a torque screwdriver or torque wrench with hex driver for tightening the set screws
SLAS Assembly Socket or Whittet-Higgins PAS Spanner Wrench for preloading the bearing

Assembly instructions:

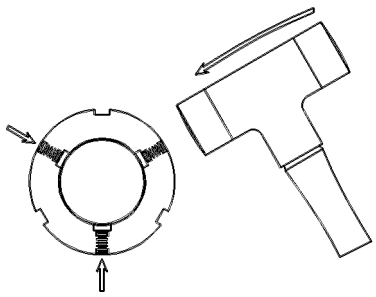
1) Check the SHOELOK retaining device. If an anaerobic compound is desired on the set screws, remove the screws, apply the adhesive, and replace them in the SHOELOK.
2) Make sure the three set screws are seated against the brass shoes by rotating them with **light** finger pressure on hex wrench until contact is made. **Do not apply any torque to the screws at this time as the brass shoes could be forced out of position and interfere with the assembly**.
3) Assemble the SHOELOK onto the shaft threads. The bearings or other retained components can now be adjusted or preloaded using a spanner wrench or socket and torque wrench.
4) After the assembled components are correctly adjusted or preloaded, begin to secure the SHOELOK by tightening each of the set screws using approximately **one half** of the torque (see Table 1). Then tighten each set screw up to or slightly less than the **maximum** torque listed. Do not over-torque.
5) **Double check** the torque reading on each set screw. If accurate, a proper and effective assembly is now completed.

TABLE 1

SHOELOK SIZE	SET SCREW	TORQUE In-lb.
NSH(M)04-NSH(M)05	8-32	20
NSH(M)06-NSH(M)16	1/4-20	80
NSH(M)17-NSH(M)22	5/16-18	150
NSH(M)24-NSH(M)30	3/8-16	270
NSH(M)32-NSH(M)40	7/16-14	400

Disassembly instructions:

1) Remove the torque on the set screws by loosening them 1/2 of a turn.
2) Re-set the brass keys into the SHOELOK by tapping the SHOELOK in three places just above each set screw, using a non-marring hammer (see sketch below).
3) The SHOELOK should now be able to rotate freely and can be removed from the shaft threads by hand. If the SHOELOK does not freely rotate, repeat steps 2 and 3 above until the SHOELOK rotates easily. **This free rotation is critical in order that the SHOELOK retaining device can be re-used**



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