TANGENTLOK 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 TANGENTLOK retaining device. If an anaerobic compound is desired on the set screws, remove the screws, apply the adhesive, and replace them in the TANGENTLOK.
2) Make sure the three set screws are seated against the segments above the bearing thread 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 threads will be squeezed and interfere with the assembly**.
3) Assemble the TANGENTLOK 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 TANGENTLOK 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

TANGENTLOK SIZE	SET SCREW	TORQUE In-lb.
TLN00-TLN06	10-32	24
TLM00-TLM06	10-32	24
TLN065-TLN14	1/4-28	48
TLM064-TLM14	1/4-28	48
TLN15	5/16-18	96
TLM15	5/16-18	96

Disassembly instructions:

1) Remove the torque on the set screws by loosening them 1/2 to 1 turn.
2) The TangentLok should now be loose and easily removed. If it does not rotate easily, lightly tap the TangentLok in three places just above each set screw using a non-marring hammer and it should now be able to rotate freely.

Whittet-Higgins Company Central Falls, RI 02863 Telephone 401-728-0700 Fax 401-728-0703