



## INSTRUCTIONS FOR FITTING PRECISION LOCK NUTS SFERO LR/LF - LRE/LFE - LRP - LX

Precision lock nuts are mechanical components usually used to pre-load angular contact ball bearings and tapered roller bearings and to adjust the play of cylindrical roller, tapered bore bearings.

This note gives advice on fitting our precision lock nuts.

### PREPARATION

For the best results:

- ensure that the components to be assembled (nuts, bearings, rings, shafts, etc) must be clean,
- check the shaft thread (the tolerance and surface condition should conform to the specifications).

### FITTING

Check that the set screws on the lock nut are slackened so that the clamping strip is not under pressure.

- Screw the lock nut until it is in contact with the part.
- Tighten the lock nut to the nominal torque determined by calculation or tests on this assembly using an appropriate ring nut wrench on the holes on the outside of the ring or on the face.
- The set screws should be tightened to the torque given in the documentation. It is preferable to use a torque wrench or hex key in good condition to avoid damaging
- the screw head.

For LF/LFE lock nuts, tighten both screws on each clamping strip in the following order:

Clamping: First tighten the screw at the free end of the clamping strip and then tighten the other screw.

Releasing: First slacken the screw at the free end of the clamping strip and then slacken the other screw.

Our lock nuts should not be used if the shaft has a keyway.

We can supply torque wrenches for the clamping set screws.

We can also supply ring nut / wrench adapters for special requirements.

*Tip: If an assembly is subject to vibration, the set screws can be locked with a drop of Loctite.*