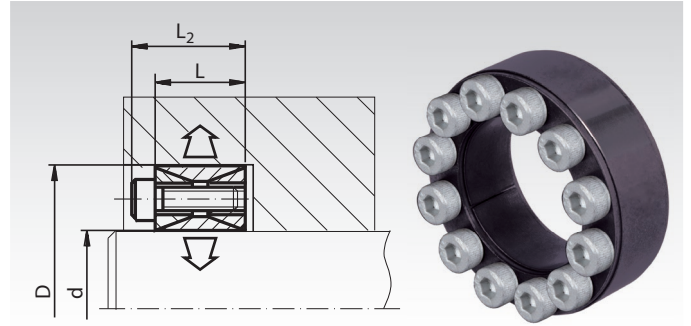


Locking Assemblies COM-A, QPQ-Coated

Material: Steel.

- For fixing a hub (e.g. V-belt pulley or similar) on a shaft.
- **QPQ coated:** High corrosion resistance, improved fatigue strength, primarily food safe (further information see below).
- For medium high torques.
- Not self-centering.
- Self-releasing at dismounting.
- No axial movement during mounting.



Ordering Details: e.g.: Product No. 615 775 14, Locking Assembly COM-A QPQ, 14 mm

Product No.	d mm	D mm	L mm	L ₂ mm	T Nm	F _{ax} kN	P _w N/mm ²	P _N N/mm ²	Screw 12.9* Number x Size	T _A Nm	Weight kg
615 775 14	14	42	20	26	180	26	291	97	8 x M6 x 18	15	0,18
615 775 15	15	42	20	26	200	27	282	101	8 x M6 x 18	15	0,18
615 775 16	16	44	20	26	205	26	251	99	8 x M6 x 18	15	0,18
615 775 17	17	44	20	26	220	26	240	93	8 x M6 x 18	15	0,18
615 775 18	18	47	20	26	230	25	195	82	8 x M6 x 18	15	0,22
615 775 19	19	47	20	26	270	28	221	93	8 x M6 x 18	15	0,22
615 775 20	20	47	20	26	290	28	232	98	8 x M6 x 18	15	0,22
615 775 22	22	47	20	26	290	30	200	90	8 x M6 x 18	15	0,21
615 775 24	24	50	20	26	380	32	216	103	8 x M6 x 18	15	0,21
615 775 25	25	50	20	26	400	33	200	100	8 x M6 x 18	15	0,23
615 775 28	28	55	20	26	520	36	208	104	10 x M6 x 18	15	0,27
615 775 30	30	55	20	26	520	37	183	99	10 x M6 x 18	15	0,26
615 775 32	32	60	20	26	690	43	209	112	12 x M6 x 18	15	0,28
615 775 35	35	60	20	26	770	44	196	113	12 x M6 x 18	15	0,30
615 775 38	38	65	20	26	940	49	202	116	14 x M6 x 18	15	0,33
615 775 40	40	65	20	26	980	49	190	115	14 x M6 x 18	15	0,32
615 775 45	45	75	24	32	1700	74	216	127	12 x M8 x 22	37	0,55
615 775 50	50	80	24	32	1830	75	196	118	12 x M8 x 22	37	0,56

* Screws with special coating.

More sizes up to d=1,000mm for 1,980,000Nm are available.
Price and delivery time on request.

T = transmittable torque at F_{ax} = 0.
F_{ax} = transmittable axial force at T = 0.
P_w = surface pressure onto the shaft.
P_N = surface pressure onto the hub.
T_A = fastening torque of the screws.

What is QPQ Nitro Carburising?

Q = Quench (nitrocarburising followed by oxidising cooling process).
P = Polish (mechanical polishing up to desired surface finish before nitrocarburising).
Q = Quench (Oxidising to increase the corrosion resistance).
Salt-bath nitro carburising is, in many cases, a good alternative to other surface layer treatments as case hardening or hard plating.

QPQ Surface Properties

Very good corrosion resistance, better than hard chrome or chem. nickel. Corrosion resistance in the salt spray test SS CASS in accordance with DIN 50021.
Improved wear resistance, no fretting corrosion, no cold shut.
Increased endurance strength, sometimes up to 100% higher.
Is completely safe to use with food as long as there is no contact with any acidic substances with a pH-value of ≤ 4.

Fit

Shaft h8, Hub H8.
Surface roughness max. 12.5µm.

Mounting

Slightly oil the locking assembly before mounting, do not use molybdenum disulphide or grease. Tighten the screws evenly and crosswise in several steps.

Demounting

Due to the cone angle, the locking assembly is usually released once all screws have been fully unfastened. There are three large auxiliary threads cut into the front ring, which serve to remove this ring.