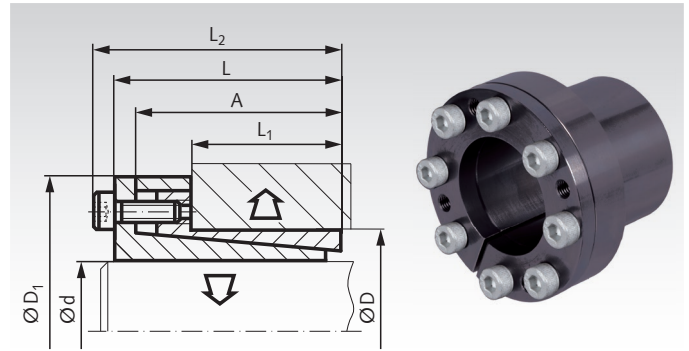


Locking Assemblies COM-B, QPQ-Coated

Material: Steel.

- For fixing a hub (e.g. timing belt pulley or similar) on a shaft.
- **QPQ coated:** High corrosion resistance, improved fatigue strength, primarily food safe (further information see below).
- For medium torques.
- Also suitable for small hub diameters.
- Self-centering.
- Self-locking.
- No axial movement during mounting.

Ordering Details: e.g.: Product No. 615 776 06, Locking Assembly COM-B QPQ, 6 mm



Product No.	d mm	D mm	L mm	A mm	L ₁ mm	L ₂ mm	D ₁ 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
615 776 06	6	14	21	18,5	10	24	25	12	4	185	80	3 x M3 x 10	2	0,05
615 776 07	7	15	25	22	12	29	27	24	7	223	111	3 x M4 x 12	5	0,07
615 776 08	8	15	25	22	12	29	27	29	7	207	111	3 x M4 x 12	5	0,07
615 776 09	9	16	26	23	14	30	28	42	10	197	110	4 x M4 x 12	5	0,07
615 776 10	10	16	26	23	14	30	28	48	10	179	112	4 x M4 x 12	5	0,07
615 776 11	11	18	26	23	14	30	32	51	10	165	102	4 x M4 x 12	5	0,07
615 776 12	12	18	26	23	14	30	32	55	10	152	100	4 x M4 x 12	5	0,08
615 776 14	14	23	26	23	14	30	38	68	10	130	80	4 x M4 x 12	5	0,11
615 776 15	15	24	36	29	16	42	45	133	18	194	121	3 x M6 x 18	17	0,22
615 776 16	16	24	36	29	16	42	45	140	18	180	118	3 x M6 x 18	17	0,22
615 776 17	17	26	38	31	18	44	47	180	22	190	125	4 x M6 x 18	17	0,25
615 776 18	18	26	38	31	18	44	47	200	22	180	125	4 x M6 x 18	17	0,23
615 776 19	19	27	38	31	18	44	49	210	22	172	121	4 x M6 x 18	17	0,25
615 776 20	20	28	38	31	18	44	50	220	22	160	115	4 x M6 x 18	17	0,26
615 776 22	22	32	45	38	25	51	54	250	22	113	78	4 x M6 x 18	17	0,35
615 776 24	24	34	45	38	25	51	56	270	22	106	76	4 x M6 x 18	17	0,36
615 776 25	25	34	45	38	25	51	56	280	22	101	76	4 x M6 x 18	17	0,34
615 776 28	28	39	45	38	25	51	61	450	32	130	93	6 x M6 x 18	17	0,42
615 776 30	30	41	45	38	25	51	62	500	32	133	95	6 x M6 x 18	17	0,43
615 776 32	32	43	45	38	25	51	65	540	35	115	86	6 x M6 x 18	17	0,49
615 776 35	35	47	52	45	32	58	69	800	44	106	81	8 x M6 x 18	17	0,55
615 776 40	40	53	52	45	32	58	75	900	45	92	68	8 x M6 x 18	17	0,64
615 776 45	45	59	70	62	45	78	86	1800	80	105	81	8 x M8 x 22	41	1,05
615 776 50	50	65	70	62	45	78	92	2020	81	96	72	8 x M8 x 22	41	1,26

* Screws with special coating.

More sizes up to d=130mm for 24,800Nm 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 R_z max. 12.5 μm .

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

Remove all tensioning screws and screw them into the (usually unused) forcing thread of the front flange, until the flange is released.