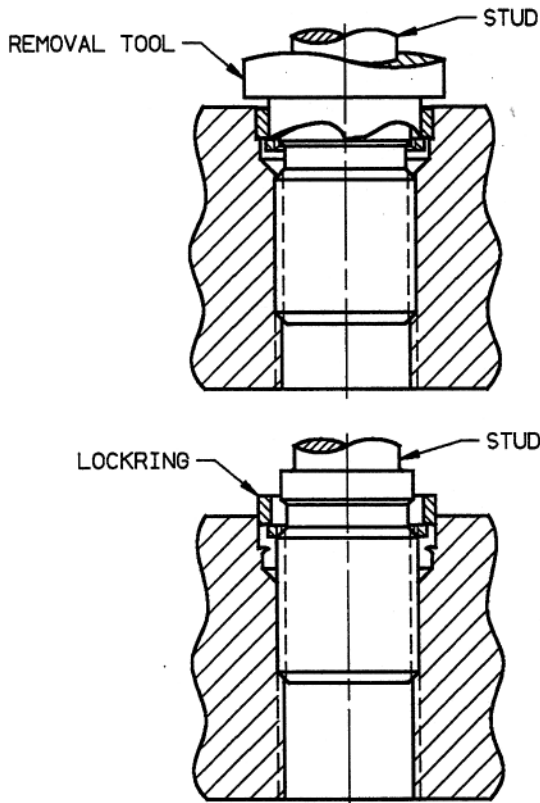


1. Parent material must be prepared in accordance with applicable stud hole preparation sheet, MS51994 or MS51996.
2. Using applicable wrench, install stud to depth shown.
3. Using applicable locking drive tool, drive lockring into parent material until drive tool bottoms against the top of parent material surface. This will set lockring to proper depth.



## REMOVAL

1. Securely clamp part from which stud is to be removed to drill press table, after carefully aligning axes of stud and drill press spindle. Set spindle speed at 300 to 700 RPM.
2. Secure removal tool in chuck and lower over stud shank before starting motor.
3. Without raising spindle, start motor. Mill through lockring, raising tool every 1/2 second to allow chips to clear cutting teeth. Best results will be obtained by not milling completely through lockring.
4. Apply removal torque to stud. When stud thread flanks bear against lower surface of lockring, continued removal torque will cause the lockring to be jacked out. Stud removal may thus be completed.
5. If lockring has been drilled completely through and fails to lift out with stud, the remaining portion may be collapsed with a punch and removed.

### NOTES:

Replacement of Rosan stud and lockring is made with same size parts as removed and is installed in the same manner as original installation. Rotate new lockring if necessary, before driving to a position in which the external serrations are aligned with those in the parent material.

## INSTALLATION AND REMOVAL, STUD - RING LOCKED