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FORM
8449
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Chain Coupling Installation Instructions



⚠ WARNING

Disconnect power before installation and maintenance. Failure to do so can result in severe injury or death.

Mounting:

1. Remove dirt and grease from coupling bore, shaft, and bushing (if bushed coupling). Do not use antigalling or antiseizing compounds when installing hubs or bushings to each other or onto the shaft. Make sure there are no burrs on the shaft, bore, key, or keyway.

2. Install Sprockets

Finished bore sprockets: If using a cover, place seal rings on shafts. (Refer to Table 1 for correct seal selection). Place each shaft key in place and slide each coupling sprocket into place on shafts. Tighten setscrews to the torque specified in Table 4.

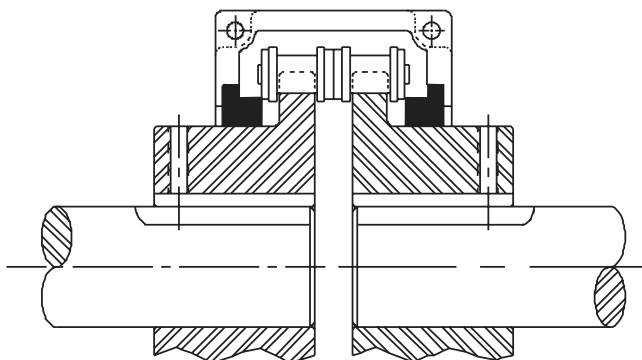
Bushed bore sprockets: If using a cover, place seal rings on shafts. (Refer to Table 1 for correct seal selection). Place bushings (and external keys if applicable) into sprockets and start screws. Place assemblies on shafts so that bushing barrels are approximately flush with the end of the shafts. Install shaft key if applicable. Tighten bushing screws as specified by bushing instructions. **See back page for TBF and TBH Hub Installation.**

**Table 1
 Seal Selection**

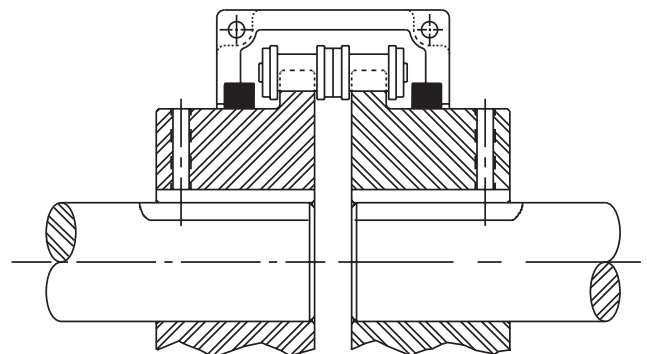
Finished Bore		Minimum Bore		Bushed Bore	
Coupling	Seal Assy	Coupling	Seal Assy	Coupling	Seal Assy
C4012	A	C40B12	A	C4020XH	A
C4016	B	C40B16	B	C5016XH	A
C5016	A	C50B16	A	C5018XP	B
C5018	B	C50B18	B	C6018XP	A
C6018	A	C60B18	A	C6020XB	B
C6020	B	C60B20	B	C8018XQ	A
C8018	A	C80B18	A	C10018XR	A
C8020	B	C80B20	B	*C4016 x 1108	B
C10018	A	C100B18	A	*C5018 x 1610	B
C10020	B	C100B20	B	*C6020 X 2012	B
				*C8020 x 3020	B
				*C10020 x 3535	B

* Style TBF and TBH use the same seal.

Seal Assembly "A"



Seal Assembly "B"



Note: Seals for Assembly "A" and Assembly "B" are shipped with each housing, discard unused seal assembly.



3. Align Shafts

Since some misalignment usually develops because of shifting, wear, and settling, the sprockets should be aligned as well as possible to increase coupling life. Move the equipment to align the sprockets. Check angular and parallel misalignment with a magnet base dial indicator as follows. Maintain sprocket spacing as indicated in Table 2. Maximum allowable runouts are given in Table 3.

A. Angular Alignment: Mount the indicator base on one hub face, or side of sprocket for large sprockets. Place the pointer on the corresponding location on the other sprocket and rotate the indicator. Adjust the machines until there is little or no runout. Alternatively, a feeler gauge can be used between the two sprockets at 90° intervals. This reading should be the same at all four locations.

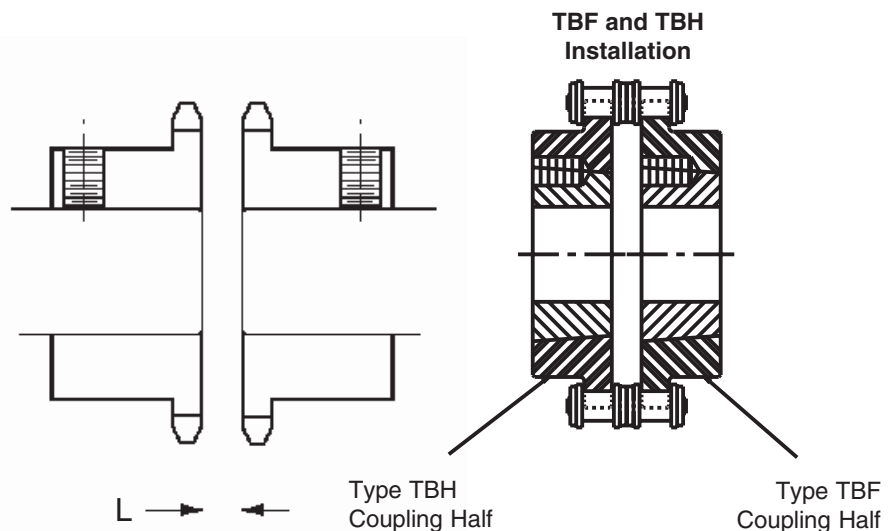
B. Parallel Alignment: Mount the indicator base on the outside diameter of one sprocket hub. Place the pointer on the O.D. of the other hub. Rotate the indicator. Adjust the machines until there is little or no runout.

Tighten foundation bolts and re-check alignment.

Coupling Ref. No.	Spacing, L	Max. Cover rpm
C4012, C4016	5/16	4775
C4020	5/16	3727
C5016, C5018	3/8	3727
C6018, C6020	7/16	2996
C8018, C8020	9/16	2333
C10018, C10020	3/4	1886

Setscrew	Torque in. lbs.
10-24 x 1/4	33
10-24 x 3/8	33
1/4-20 x 1/4	87
1/4-20 x 3/8	87
3/8-16 x 3/8	290

Coupling No.	Parallel	Angular
4012	.010	.014
4016	.010	.020
4020	.010	.025
5016	.012	.025
5018	.012	.032
6018	.015	.035
6020	.015	.039
8018	.020	.046
8020	.020	.052
10018	.025	.058
10020	.025	.065




4. Cover Assembly

Wrap coupling chain around sprocket teeth and install connecting link. Apply a small amount of medium duty bearing grease to each seal and slide seals onto coupling hubs. Place cover halves around coupling, position gaskets, install and tighten cover screws. Be careful to maintain proper seal position.


5. Lubrication

Remove the two pipe plugs from the cover. Install a grease fitting in one of the holes. Slowly fill the coupling with medium duty bearing grease having a minimum melting point of the 260 degrees F. until grease comes out the other hole. Remove the grease fitting and replace the two pipe plugs. Do not use cup grease. Regrease at regular intervals or when necessary by repeating procedure.



⚠ WARNING

Do not exceed maximum speeds listed in Table 2. Failure to do so could result in equipment damage, serious injury or death.



⚠ WARNING

Operating drives without guards in place can result in severe injury or death.