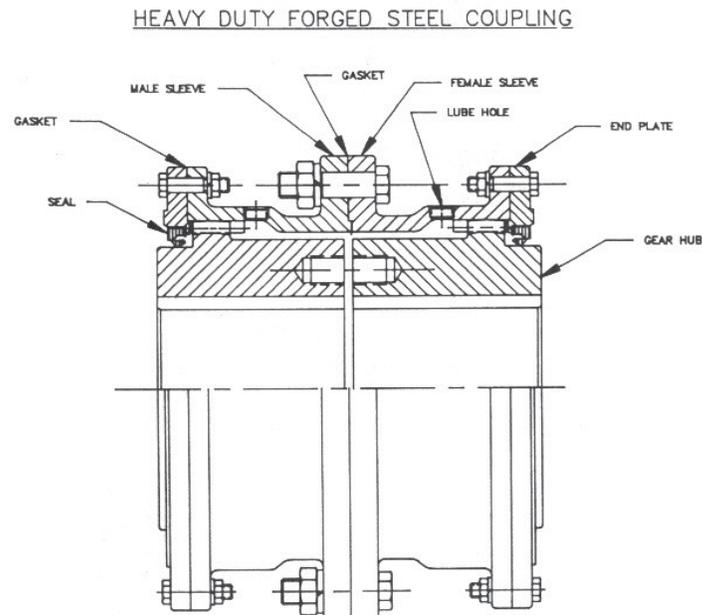


**Important Notice:** Because of the possible dangers to person(s) or property from accidents which may result from the use of it is important that correct procedures be followed. Product must be used in accordance with the engineering information specified in the catalog. Proper installation, maintenance, and operation procedures must be observed. The instructions in the instruction manual must be followed. Inspection should be made as necessary to assure safe operation under prevailing conditions. Proper guards and other suitable safety devices or procedures as may be specified in safety codes should be provided and are neither provided by TB Wood's Incorporated nor are the responsibility of TB Wood's Incorporated.

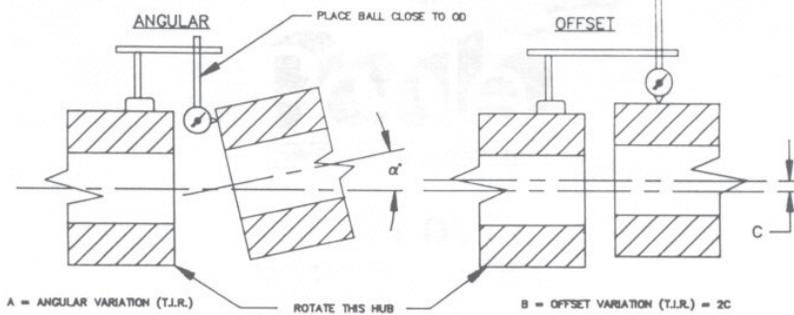
**Installation:**

1. Inspect all parts to be clean.
2. Install end plates, with seals , on shafts.
3. Fit keys to shafts and hubs - mark for reference.
4. Install keys in shaft.
5. Heat hubs to approximately 300 degrees F above ambient and install on shafts with puller holes flush with shaft ends. A good press or shrink fit is essential.
6. Install sleeves on hubs, making sure end plate gasket is in place, and bolt-up.
7. Install driver and driven units on foundation and line-up shafts using the procedure outlines in the "Alignment" section of this manual.
8. Rotate shafts until bolt holes in sleeves line-up.
9. Wipe off flanges and insert center flange gasket and bolt together.
10. Remove lube plugs , and add the proper amount of lube (See chart).
11. Reinstall lube hole plugs.
12. Properly guard.

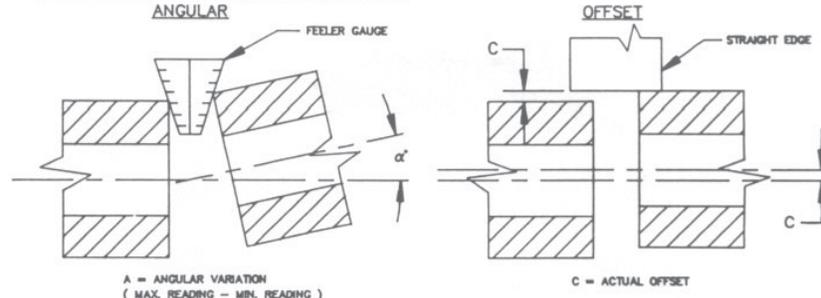


## METHODS OF CHECKING ANGULAR AND OFFSET ALIGNMENT

### 1. USING DIAL INDICATOR



### 2. USING FEELER GAUGE AND STRAIGHT EDGE



### 3. TO FIND $\alpha'$ WHEN L=CENTER LINE TO CENTER LINE OF GEAR TEETH D=ALIGNING DIA.

$$\alpha' = \frac{57.3 \times A}{D} = \tan^{-1} \left( \frac{A}{D} \right) \quad \alpha' = \frac{57.3 \times B}{2L} = \tan^{-1} \left( \frac{B}{2L} \right) = \frac{57.3 \times C}{L} = \tan^{-1} \left( \frac{C}{L} \right)$$

MAXIMUM RECOMMENDED ALIGNMENT VALUES BASED ON 0.1° ANGULAR MISALIGNMENT.

	601	701	801	901	1001	1101	1201	1301	1401	1501	1601	1701
<b>A</b>	.017	.021	.023	.026	.029	.033	.035	.038	.041	.045	.047	.050
<b>B</b>	.033	.037	.043	.048	.053	.058	.065	.070	.075	.080	.086	.092
<b>C</b>	.016	.018	.021	.024	.027	.030	.033	.035	.038	.040	.043	.046
<b>D</b>	10.00	11.75	13.25	14.75	16.50	18.75	20.25	21.50	23.50	25.50	27.00	28.50
<b>L</b>	9.38	10.50	12.25	13.75	15.25	17.00	18.75	20.00	21.50	23.00	24.75	26.25
<b>LUBE (GAL)</b>	.13	.25	.50	.75	1.00	1.25	1.50	1.75	2.00	2.50	7.00	3.25

	1801	1901	2001	2101	2201	2301	2401	2501	2601	2701	2801	2901	3001
<b>A</b>	.062	.057	.058	.062	.065	.067	.071	.074	.076	.079	.083	.086	.088
<b>B</b>	.093	.095	.105	.114	.120	.126	.130	.135	.140	.146	.144	.142	.139
<b>C</b>	.047	.047	.052	.057	.060	.063	.065	.068	.070	.073	.072	.071	.089
<b>D</b>	30.00	32.75	33.50	35.50	37.00	38.50	40.50	42.25	43.50	45.50	47.50	46.50	51.00
<b>L</b>	26.75	27.13	30.00	32.75	34.25	36.00	37.25	38.75	40.00	41.75	41.25	40.75	38.75
<b>LUBE (GAL)</b>	8	4	10	4.5	12	5.5	14.5	7	17	20	21	22	13

BOLT DIA	1/2	5/8	3/4	7/8	1	1 1/4	1 1/2	1 3/4	2	2 1/2	3
<b>DRY WRENCH TORQUE (FT LBS)</b>	80	160	290	460	700	1220	2130	2400	3600	7200	13000



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