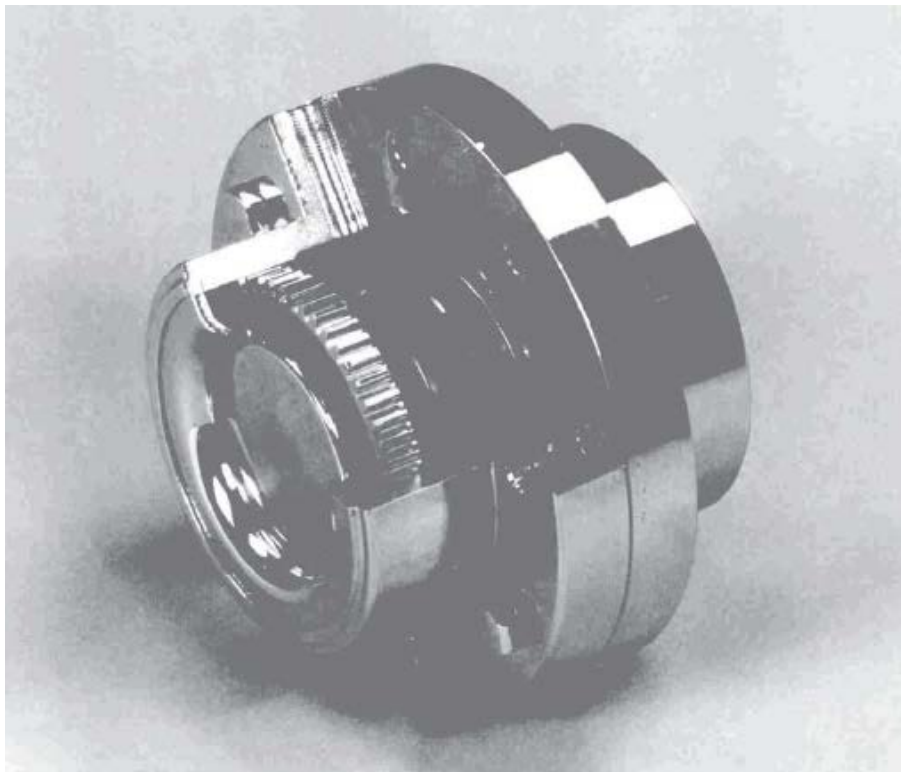


# K100 Series Gear Coupling

## Installation & Maintenance Manual

P-5046-TBW  
Form 1248

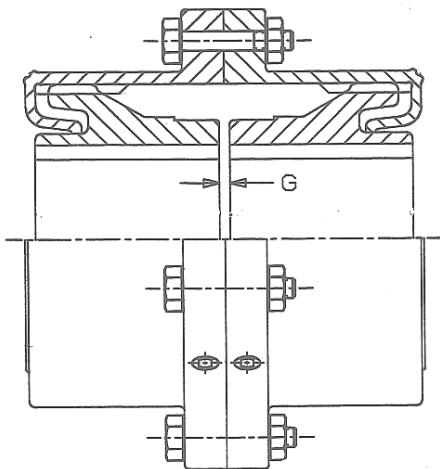


# K100 Coupling Installation And Maintenance Instructions

 **WARNING: Cancer - [www.P65Warnings.ca.gov](http://www.P65Warnings.ca.gov)**

## Installation:

1. Be sure all components are present and free of burrs or chips.
2. Place the sleeves over the shaft ends. Slide the sleeve back enough not to interfere with the installation of the hubs.
3. Install the hubs on the respective shafts. Interference fit hubs often require heating the hubs in hot oil or an oven to 320° F prior to installation. The hub faces should be flush with the shaft ends.
4. Locate the driver and driven machinery to maintain the G dimension between the driver and driven hub ends.

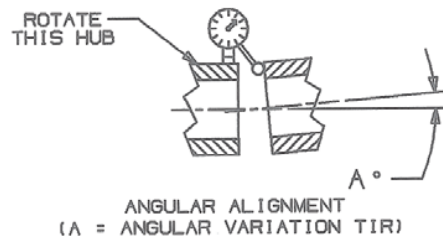


Size	"G"
1-1/2K	0.13
2K	0.13
2-1/2K	0.19
3K	0.19
3-1/2K	0.25
4K	0.25
4-1/2K	0.31
5K	0.31
5-1/2K	0.31
6K	0.31
7K	0.38

5. Using a dial indicator check the angular and parallel alignment of the hubs.

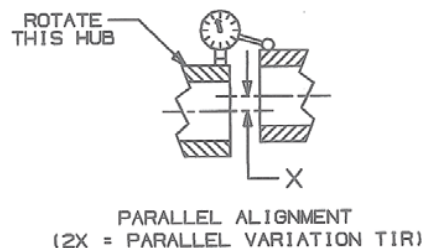
### Angular Method

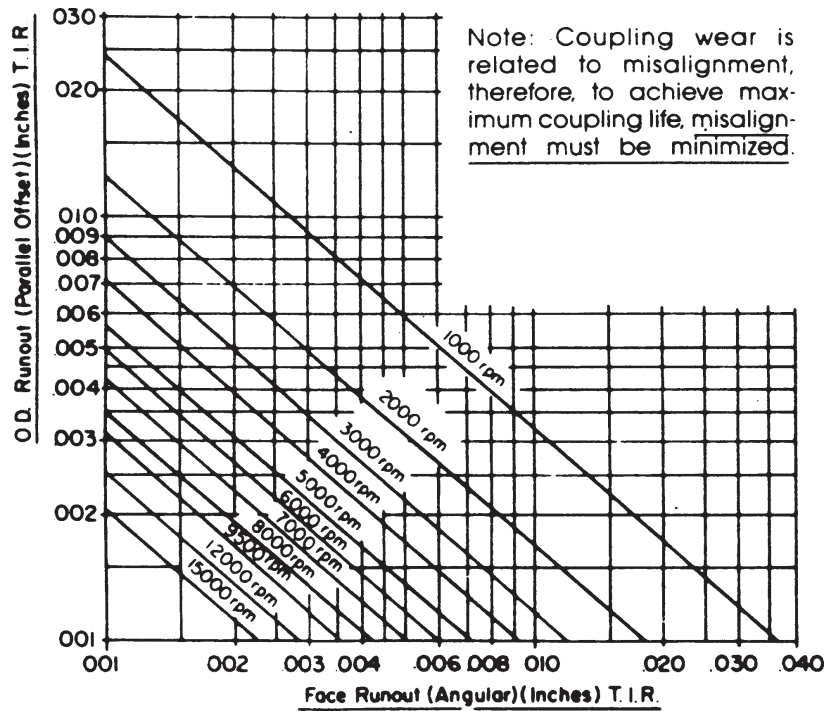
Attach the dial indicator to the base of one hub and the indicator needle against the face of the other hub. Rotate the hub on which the indicator base is attached, check the dial at 90° intervals. All four point should be the same reading on the dial.



### Parallel Method

Attach the dial indicator to the base of one hub and the indicator needle against the OD of the other hub. Rotate the hub on which the indicator base is attached, check the dial at 90° intervals. All four point should be the same reading on the dial.





6. If the coupling is to be grease lubricated, coat all gear tooth areas with grease. Wood's suggest a grease complying to AGMA9001-B97.

7. Slide the sleeves over the hubs and install the gasket between the two sleeves.

8. Install and progressively tighten the bolts with a torque wrench until the proper torque value is met.

Torque (In Lbs)	1-1/2K	2K	2-1/2K	3K	3-1/2K	4K
Exposed Bolt	425	940	1750	1750	2650	2650
Shrouded Bolt	425	425	940	940	1750	1750

Torque (in Lbs)	4-1/2K	5K	5-1/2K	6K	7K
Exposed Bolt	2650	3650	3650	3650	4850
Shrouded Bolt	1750	2650	2650	*	*

9. Remove lubrication plugs in each sleeve, add grease until filled.

*NOTE: If RPM is below minimum, use SAE 90 oil in lieu of grease.*

Size	1-1/2K	2K	2-1/2K	3K	3-1/2K	4K
Grease Cap. (oz.)	5-1/2	7-1/4	15	22	33	55
Minimum RPM	463	411	380	348	321	301

Size	4-1/2K	5K	5-1/2K	6K	7K
Grease Cap. (oz.)	66	88	140	184	240
Minimum RPM	285	268	257	240	227

10. Install a proper coupling guard.

## **Maintenance:**

1. It is recommended that the coupling be completely flushed and relubricated after an initial break-in period of 3 million revolutions. (80 Hr @ 600 RPM)
2. Under normal industrial conditions the coupling should be disassembled, cleaned, and inspected every year. More severe applications may require more frequent inspection and relubrication.
3. During any inspection of the coupling when gear tooth wear is evident of excessive leaking, it is recommended to replace the worn parts.
4. Upon reassembly after inspection always refer to the installation section for proper installation and wrench torques. Always regrease the coupling after inspection. Wood's recommends the use of grease which complies with AGMA9001-B97.



## TB Wood's Facilities

### North America

#### USA

440 North Fifth Avenue  
Chambersburg, PA 17201 - USA  
888-829-6637 \* 717-264-7161  
*Belted Drives and Elastomeric Couplings*

**Customer Service**  
1-888-829-6637 (Press #5)

**For Application Support**  
1-888-829-6637 (Press #7)

2000 Clovis Barker Road  
San Marcos, TX 78666 - USA  
1-888-449-9439  
*General Purpose Disc Couplings*

**Customer Service**  
1-888-449-9439

4970 Joule St  
Reno, NV 89502 - USA  
775-857-1800

#### Canada

9779 45 Ave NW  
Edmonton, AB T6E 5V8 - Canada  
+1 780-439-7979

6305 Danville Road  
Mississauga, ON L5T 2H7 - Canada  
1-800-829-6631

1073 Rue Bégin  
Saint-Laurent, QC H4R 1V8 - Canada  
+1 514-332-4812

#### Mexico

Comisión Federal de Electricidad 850,  
Industrial San Luis,  
San Luis, S.L.P., 78395 - Mexico  
+52 444 137 1500

### Europe

Merchant Drive, Hertford  
Hertfordshire SG13 7BL - England  
+44(0)1992 501900  
*Elastomeric Couplings*

## The Brands of Altra Motion

### Couplings

**Ameridrives**  
[www.ameridrives.com](http://www.ameridrives.com)

**Bibby Turboflex**  
[www.bibbyturboflex.com](http://www.bibbyturboflex.com)

**Guardian Couplings**  
[www.guardiancouplings.com](http://www.guardiancouplings.com)

**Huco**  
[www.huco.com](http://www.huco.com)

**Lamiflex Couplings**  
[www.lamiflexcouplings.com](http://www.lamiflexcouplings.com)

**Stromag**  
[www.stromag.com](http://www.stromag.com)

**TB Wood's**  
[www.tbwoods.com](http://www.tbwoods.com)

### Linear Systems

**Thomson**  
[www.thomsonlinear.com](http://www.thomsonlinear.com)

**Warner Linear**  
[www.warnerlinear.com](http://www.warnerlinear.com)

### Geared Cam Limit Switches

**Stromag**  
[www.stromag.com](http://www.stromag.com)

### Engineered Bearing Assemblies

**Kilian**  
[www.kilianbearings.com](http://www.kilianbearings.com)

### Electric Clutches & Brakes

**Matrix**  
[www.matrix-international.com](http://www.matrix-international.com)

**Stromag**  
[www.stromag.com](http://www.stromag.com)

**Warner Electric**  
[www.warnerelectric.com](http://www.warnerelectric.com)

**Deltran**  
[www.thomsonlinear.com](http://www.thomsonlinear.com)

### Belted Drives

**TB Wood's**  
[www.tbwoods.com](http://www.tbwoods.com)

### Heavy Duty Clutches & Brakes

**Twiflex**  
[www.twiflex.com](http://www.twiflex.com)

**Stromag**  
[www.stromag.com](http://www.stromag.com)

**Svendborg Brakes**  
[www.svendborg-brakes.com](http://www.svendborg-brakes.com)

**Wichita Clutch**  
[www.wichitaclutch.com](http://www.wichitaclutch.com)

### Gearing & Specialty Components

**Bauer Gear Motor**  
[www.bauergears.com](http://www.bauergears.com)

**Boston Gear**  
[www.bostongear.com](http://www.bostongear.com)

**Delevan**  
[www.delevan.com](http://www.delevan.com)

**Delroyd Worm Gear**  
[www.delroyd.com](http://www.delroyd.com)

**Nuttall Gear**  
[www.nuttallgear.com](http://www.nuttallgear.com)

### Engine Braking Systems

**Jacobs Vehicle Systems**  
[www.jacobsvehiclesystems.com](http://www.jacobsvehiclesystems.com)

### Precision Motors & Automation

**Kollmorgen**  
[www.kollmorgen.com](http://www.kollmorgen.com)

### Miniature Motors

**Portescap**  
[www.portescap.com](http://www.portescap.com)

### Overrunning Clutches

**Formsprag Clutch**  
[www.formsprag.com](http://www.formsprag.com)

**Marland Clutch**  
[www.marland.com](http://www.marland.com)

**Stieber**  
[www.stieberclutch.com](http://www.stieberclutch.com)

Neither the accuracy nor completeness of the information contained in this publication is guaranteed by the company and may be subject to change in its sole discretion. The operating and performance characteristics of these products may vary depending on the application, installation, operating conditions and environmental factors. The company's terms and conditions of sale can be viewed at <http://www.altramotion.com/terms-and-conditions/sales-terms-and-conditions>. These terms and conditions apply to any person who may buy, acquire or use a product referred to herein, including any person who buys from a licensed distributor of these branded products.

©2019 by TB Wood's LLC. All rights reserved. All trademarks in this publication are the sole and exclusive property of TB Wood's LLC or one of its affiliated companies.



[www.tbwoods.com](http://www.tbwoods.com)

2000 Clovis Barker Road  
San Marcos, TX 78666  
512-353-4000