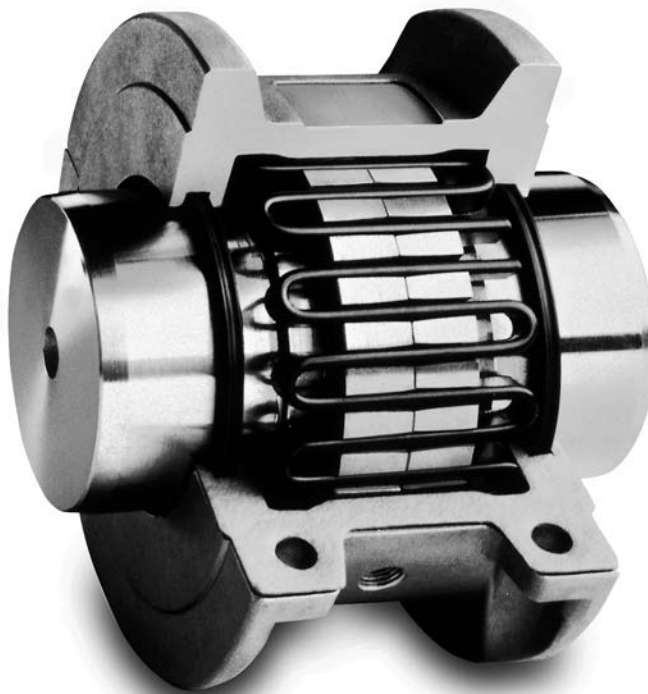


# G-Flex Coupling

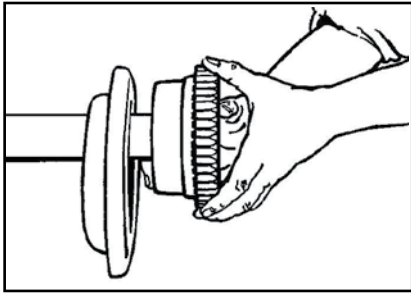
## Service & Installation Instructions

P-5020-TBW  
Form 1445



# General Guidance for the installation of TB Wood's grid couplings

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



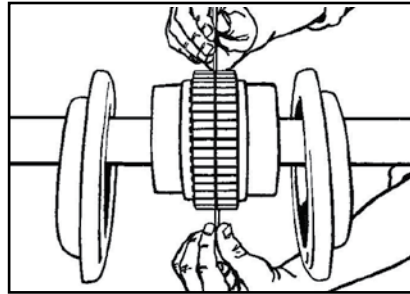
## 1. MOUNT SEALS AND HUBS

1000T10 (horizontally split cover): Lightly smear seals with grease and place on shafts before mounting hubs.

1000T20 (vertically split cover): Vertical covers are NOT axially split and MUST be placed over shaft before fitting hubs. Check to verify that half covers have been placed correctly on shafts. Mount hubs, usually with the hub face flush with shaft end. Where supplied, tighten set screws.

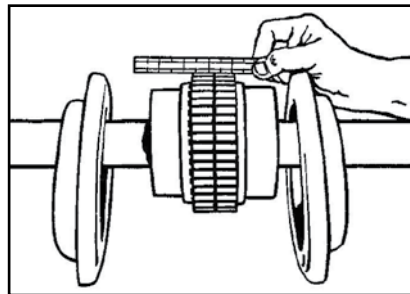
## 2. ALIGNMENT

Satisfactory alignment can be achieved with the use of a straight edge and feeler gauge, although a dial indicator would generally improve accuracy.



## 3. GAP AND ANGULAR ALIGNMENT

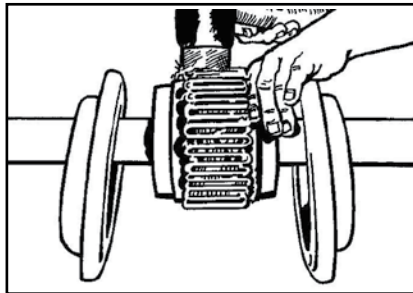
Set gap using a spacer bar equal in thickness to the hub gap specified in the table on page 4. With the spacer bar inserted to the same radial depth, measure clearance between bar and hub face at 90° intervals using feelers.



## 4. PARALLEL OFFSET ALIGNMENT

Use a straight edge and feelers, or dial indicator, over the tops of the coupling teeth, taking measurements at 90° intervals. Error should not exceed offset limit specified in the table on page 4.

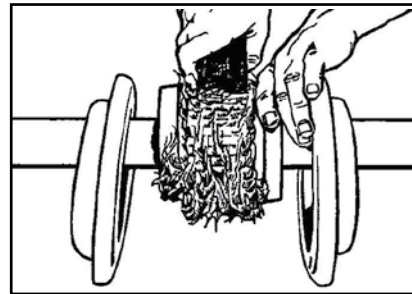
**5. TIGHTEN ALL EQUIPMENT BASED MOUNTING FASTENERS. REPEAT STEPS 3 & 4 AND IF NECESSARY RE-ALIGN**



**6. GRID ASSEMBLY**

1000T20 (vertically split cover), insert gasket through the gap and support on either hub or shaft. Before inserting the grid segments, thoroughly pack the grooves with NGLI #2 lubricant. A list of recommended lubricants can be found on the page 4.

When grids are supplied in two or more segments assemble so the cut ends at a segment joint extend in the same direction. Spread the grid slightly so that it will pass over the coupling teeth, and tap all the rungs into the respective slots with a soft mallet.



**7. COVER ASSEMBLY**

Pack the spaces around the grid with lubricant and wipe off the excess flush with top of grid.

1000T10 (horizontally split cover):

Position seals on hubs so that they line up with grooves on cover. Position gaskets on lower cover half and assemble covers so that match marks are on the same side. If using the coupling in any position other than horizontal, assemble cover halves with the lug and match mark up, or on the high side. Fasten the cover halves to the torque specified in the table on page 4.

Series 1000T20 (vertically split cover):

Remove lube plugs to ease cover assembly. Slide cover halves, complete with seal, onto hubs. Position lube holes at 180° apart. Align cover and gasket bolt holes and fasten flanges together using the bolts provided, tightening to the torque specified in the table on page 4.

**MAINTENANCE**

Check coupling misalignment every year and adjust if required. Excessive misalignment, high ambient temperatures and/or frequent rapid reversing may necessitate more frequent inspections.

If quantity of lubricant appears low, check for leaks and change seals. If necessary, replenish lubricant.

Clean coupling of all old lubricant and replace annually.

**TABLE 1 – Misalignment & End Float**

| SIZE  | Installation Alignment Limits |        |          |        |             |        | Operation Alignment Limits |        |          |        | Cover Bolt Tightening Torques |         |      |         |         |      | Max RPM |         | Lube Wt |      |
|-------|-------------------------------|--------|----------|--------|-------------|--------|----------------------------|--------|----------|--------|-------------------------------|---------|------|---------|---------|------|---------|---------|---------|------|
|       | Parallel Offset               |        | Angular  |        | Hub Gap ±0% |        | Parallel Offset            |        | Angular  |        | 1000T10                       |         |      | 1000T20 |         |      |         |         |         |      |
|       | Max Inch                      | Max mm | Max Inch | Max mm | Max Inch    | Max mm | Max Inch                   | Max mm | Max Inch | Max mm | Nm                            | (in-lb) | Size | Nm      | (in-lb) | Size | 1000T10 | 1000T20 | lb      | kg   |
| 1020T | 0.006                         | 0.15   | 0.003    | 0.08   | 0.125       | 3.2    | 0.012                      | 0.30   | 0.010    | 0.25   | 11                            | 100     | M6   | 8       | 70      | M6   | 4500    | 6000    | 0.06    | 0.03 |
| 1030T | 0.006                         | 0.15   | 0.003    | 0.08   | 0.125       | 3.2    | 0.012                      | 0.30   | 0.012    | 0.30   | 11                            | 100     | M6   | 8       | 70      | M6   | 4500    | 6000    | 0.09    | 0.03 |
| 1040T | 0.006                         | 0.15   | 0.003    | 0.08   | 0.125       | 3.2    | 0.012                      | 0.30   | 0.013    | 0.33   | 11                            | 100     | M6   | 8       | 70      | M6   | 4500    | 6000    | 0.12    | 0.05 |
| 1050T | 0.008                         | 0.20   | 0.004    | 0.10   | 0.125       | 3.2    | 0.016                      | 0.40   | 0.016    | 0.40   | 22                            | 200     | M8   | 8       | 70      | M6   | 4500    | 6000    | 0.15    | 0.05 |
| 1060T | 0.008                         | 0.20   | 0.005    | 0.12   | 0.125       | 3.2    | 0.016                      | 0.40   | 0.018    | 0.45   | 22                            | 200     | M8   | 8       | 70      | M6   | 4350    | 6000    | 0.19    | 0.09 |
| 1070T | 0.008                         | 0.20   | 0.005    | 0.12   | 0.125       | 3.2    | 0.016                      | 0.40   | 0.020    | 0.50   | 22                            | 200     | M8   | 18      | 160     | M8   | 4125    | 5500    | 0.25    | 0.11 |
| 1080T | 0.008                         | 0.20   | 0.006    | 0.15   | 0.125       | 3.2    | 0.016                      | 0.40   | 0.024    | 0.60   | 22                            | 200     | M8   | 18      | 160     | M8   | 3600    | 4750    | 0.38    | 0.17 |
| 1090T | 0.008                         | 0.20   | 0.007    | 0.18   | 0.125       | 3.2    | 0.016                      | 0.40   | 0.028    | 0.70   | 22                            | 200     | M8   | 18      | 160     | M8   | 3600    | 4000    | 0.56    | 0.25 |
| 1100T | 0.010                         | 0.25   | 0.008    | 0.20   | 0.188       | 4.8    | 0.020                      | 0.50   | 0.033    | 0.80   | 38                            | 340     | M10  | 18      | 160     | M10  | 2440    | 3250    | 0.94    | 0.43 |
| 1110T | 0.011                         | 0.25   | 0.009    | 0.23   | 0.188       | 4.8    | 0.020                      | 0.50   | 0.036    | 0.90   | 38                            | 340     | M10  | 38      | 340     | M10  | 2250    | 3000    | 1.10    | 0.51 |
| 1120T | 0.011                         | 0.28   | 0.010    | 0.25   | 0.125       | 6.4    | 0.022                      | 0.55   | 0.040    | 1.00   | 62                            | 550     | M12  | 38      | 340     | M10  | 2025    | 2700    | 1.60    | 0.73 |
| 1130T | 0.011                         | 0.28   | 0.012    | 0.30   | 0.125       | 6.4    | 0.022                      | 0.55   | 0.047    | 1.20   | 62                            | 550     | M12  | 62      | 550     | M12  | 1800    | 2400    | 2.00    | 0.91 |
| 1140T | 0.011                         | 0.28   | 0.013    | 0.33   | 0.125       | 6.4    | 0.022                      | 0.55   | 0.053    | 1.35   | 62                            | 550     | M12  | 62      | 550     | M12  | 1550    | 2200    | 2.50    | 1.13 |

**TABLE 2 – LUBRICANTS**

| MANUFACTURER   | PRODUCT                                  |
|--|--|
| American Lubricants Co.<br>(Dayton, OH)                          | Alubco Bison 1650                        |
| Brooks Technology<br>(Cleveland, OH)<br>(Fuchs Lubricants)       | Superplex EP #1<br>or Benalene 350 EP #2 |
| Chevron Lubricants   | Coupling Grease<br>or Duralith EP2       |
| Citgo Petroleum Corp.  | Premium Lithium EP2                      |
| Exxon / Mobil Corp.  | Mobilux EP111                            |
| Fiske Bros. Refining Co.   | Lubriplate 630AA                         |
| Anderol Inc.<br>(Houghton, Canada)                               | Anderol 786                              |
| Kendall Motor Oil  | L-424                                    |
| Lyondell Lubricants<br>(Houston, TX)                             | Litholene H EP 2                         |
| Maryn International/<br>Power Up Lubricants<br>(Calgary, Canada) | Thixogrease EP #2                        |
| Pennzoil / Quaker State  | Pennlith EP711<br>or Pennlith EP712      |
| Syn-Tech Ltd. (Addison, IL)                                      | NS-2913-G1                               |
| Texaco Inc.  | Mulifax EP2<br>or Texaco Coupling Grease |
| UNOCAL 76<br>(TOSCO Corporation)                                 | UNOBA EP2                                |



## 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)

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