

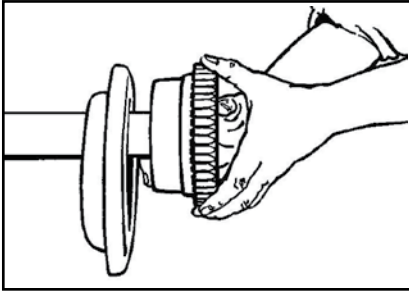
# G-Flex Coupling

## Service & Installation Instructions

P-5020-TBW  
Form 1445



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



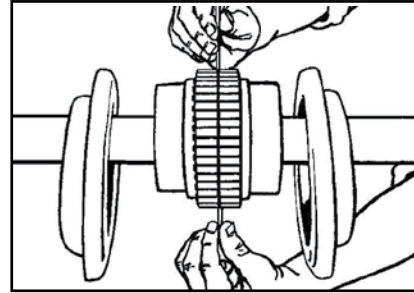
## 1. MOUNT SEALS AND HUBS

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.

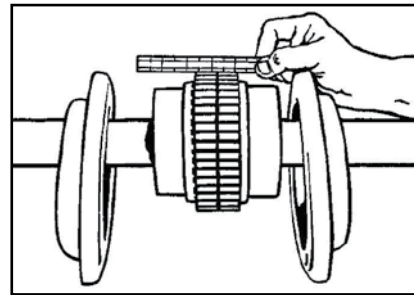
## 2. ALIGNMENT

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

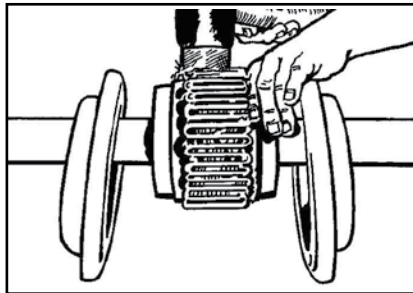
Set gap using a spacer bar equal in thickness to the hub gap specified in the table on page 4. With the spacer bar inserted to the same radial depth, measure clearance between bar and hub face at 90° intervals using feelers.



## 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.

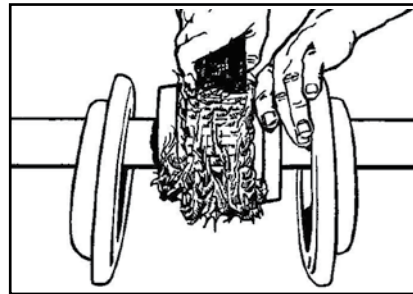
**5. TIGHTEN ALL EQUIPMENT BASED MOUNTING FASTENERS. REPEAT STEPS 3 & 4 AND IF NECESSARY RE-ALIGN**



**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 $\pm 0\%$		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	0.024	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	0.020	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. (Dayton, OH)	Alubco Bison 1650
Brooks Technology (Cleveland, OH) (Fuchs Lubricants)	Superplex EP #1 or Benalene 350 EP #2
Chevron Lubricants	Coupling Grease or Duralith EP2
Citgo Petroleum Corp.	Premium Lithium EP2
Exxon / Mobil Corp.	Mobilux EP111
Fiske Bros. Refining Co.	Lubriplate 630AA
Anderol Inc. (Houghton, Canada)	Anderol 786
Kendall Motor Oil	L-424
Lyondell Lubricants (Houston, TX)	Litholene H EP 2
Maryn International/ Power Up Lubricants (Calgary, Canada)	Thixogrease EP #2
Pennzoil / Quaker State	Pennlith EP711 or Pennlith EP712
Syn-Tech Ltd. (Addison, IL)	NS-2913-G1
Texaco Inc.	Mulifax EP2 or Texaco Coupling Grease
UNOCAL 76 (TOSCO Corporation)	UNOBA EP2



All Customer Service phone numbers shown in bold

Belted Drives and Sheaves	Couplings Cont.	Gearing	Linear Products
<p><b>TB Wood's</b> <i>Belted Drives</i> Chambersburg, PA - USA <b>1-888-829-6637</b> – Press #5 <i>For application assistance:</i> <i>1-888-829-6637 – Press #7</i></p>	<p><b>TB Wood's</b> <i>Elastomeric Couplings</i> Chambersburg, PA - USA <b>1-888-829-6637</b> – Press #5 <i>For application assistance:</i> <i>1-888-829-6637 – Press #7</i> <i>General Purpose Disc Couplings</i> San Marcos, TX - USA <b>1-888-449-9439</b></p>	<p><b>Bauer Gear Motor</b> <i>Gear Motors</i> Esslingen, Germany <b>+49 (711) 3518-0</b> Middlesex, NJ - USA <b>1-732-469-8770</b></p> <p><b>Boston Gear</b> <i>Enclosed and Open Gearing, Electrical and Mechanical P.T. Components</i> Charlotte, NC - USA <b>1-800-825-6544</b> <i>For application assistance:</i> <i>1-800-816-5608</i></p> <p><b>Nuttall Gear and Delroyd Worm Gear</b> <i>Worm Gear and Helical Speed Reducers</i> Niagara Falls, NY - USA <b>1-716-298-4100</b></p>	<p><b>Warner Linear</b> <i>Linear Actuators</i> New Hartford, CT - USA <b>1-800-825-6544</b> <i>For application assistance:</i> <i>1-800-825-9050</i> Saint Barthélemy d'Anjou, France <b>+33 (0)2 41 21 24 24</b></p>
<p><b>Couplings</b></p> <p><b>Ameridrives</b> <i>Mill Spindles, Ameriflex, Ameridisc</i> Erie, PA - USA <b>1-814-480-5000</b> <i>Gear Couplings</i> San Marcos, TX - USA <b>1-800-458-0887</b> <i>Universal Joints, Drive Shafts, Mill Gear Couplings</i> Erie, PA - USA <b>1-920-593-2444</b></p> <p><b>Bibby Turboflex</b> <i>Disc, Gear, Grid Couplings, Overload Clutches</i> Dewsbury, England <b>+44 (0) 1924 460801</b> Boksburg, South Africa <b>+27(0) 11 918 4270</b></p> <p><b>Guardian Couplings</b> <i>Engineered Flywheel Couplings, Engine Housings and Pump Mounts, Flexible Shaft Couplings</i> Michigan City, IN - USA <b>1-219-874-5248</b></p> <p><b>Huco</b> <i>Precision Couplings and Air Motors</i> Hertford, England <b>+44 (0) 1992 501900</b> Chambersburg, PA - USA <b>1-888-829-6637</b></p> <p><b>Lamiflex Couplings</b> <i>Flexible Couplings, Bearing Isolators, and Coupling Guards</i> Cotia, SP - Brasil <b>+55 (11) 4615-6300</b></p>	<p><b>Electromagnetic Clutches and Brakes</b></p> <p><b>Inertia Dynamics</b> <i>Spring Set Brakes; Power On and Wrap Spring Clutch/Brakes</i> New Hartford, CT - USA <b>1-800-800-6445</b></p> <p><b>Matrix</b> <i>Electromagnetic Clutches and Brakes, Pressure Operated Clutches and Brakes</i> Brechin, Scotland <b>+44 (0) 1356 602000</b> New Hartford, CT - USA <b>1-800-825-6544</b></p> <p><b>Warner Electric</b> <i>Electromagnetic Clutches and Brakes</i> New Hartford, CT - USA <b>1-800-825-6544</b> <i>For application assistance:</i> <i>1-800-825-9050</i> Saint Barthélemy d'Anjou, France <b>+33 (0)2 41 21 24 24</b> <i>Precision Electric Coils and Electromagnetic Clutches and Brakes</i> Columbia City, IN - USA <b>1-260-244-6183</b></p>	<p><b>Heavy Duty Clutches and Brakes</b></p> <p><b>Industrial Clutch</b> <i>Pneumatic and Oil Immersed Clutches and Brakes</i> Waukesha, WI - USA <b>1-262-547-3357</b></p> <p><b>Svendborg Brakes</b> <i>Industrial Brakes and Brake Systems</i> Vejstrup, Denmark <b>+45 63 255 255</b></p> <p><b>Twiflex</b> <i>Caliper Brakes and Thrusters</i> Wichita Falls, TX - USA <b>1-844-723-3483</b> Twickenham, England <b>+44 (0) 20 8894 1161</b></p> <p><b>Wichita Clutch</b> <i>Pneumatic Clutches and Brakes</i> Wichita Falls, TX - USA <b>1-800-964-3262</b> Bedford, England <b>+44 (0) 1234 350311</b></p>	<p><b>Overrunning Clutches</b></p> <p><b>Formsprag Clutch</b> <i>Overrunning Clutches and Holdbacks</i> Warren, MI - USA <b>1-800-348-0881</b> – Press #1 <i>For application assistance:</i> <i>1-800-348-0881 – Press #2</i></p> <p><b>Marland Clutch</b> <i>Roller Ramp and Sprag Type Overrunning Clutches and Backstops</i> Warren, MI - USA <b>1-800-216-3515</b></p> <p><b>Stieber Clutch</b> <i>Overrunning Clutches and Holdbacks</i> Heidelberg, Germany <b>+49 (0) 6221-30470</b></p>

For information concerning our sales offices in Asia Pacific check our website [www.altramotion.com.cn](http://www.altramotion.com.cn)



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

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