

FORMSPRAG CLUTCH™

Reverse-Locking Clutches Service & Installation Instructions

Regal Rexnord
Application Engineering: 1-800-927-3262
PTSAAppEng@regalrexnord.com
regalrexnord.com/FormspragClutch

FORM
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⚠ DANGER Indicates a hazard which, if not avoided, will result in serious injury or death.

⚠ WARNING Indicates a hazard which, if not avoided, could result in serious injury or death.

⚠ CAUTION Indicates a hazard which, if not avoided, could result in minor or moderate personal injury.

NOTICE Indicates information considered important, but not hazard-related (e.g. messages relating to property damage).

GENERAL SAFETY INSTRUCTIONS

⚠ WARNING

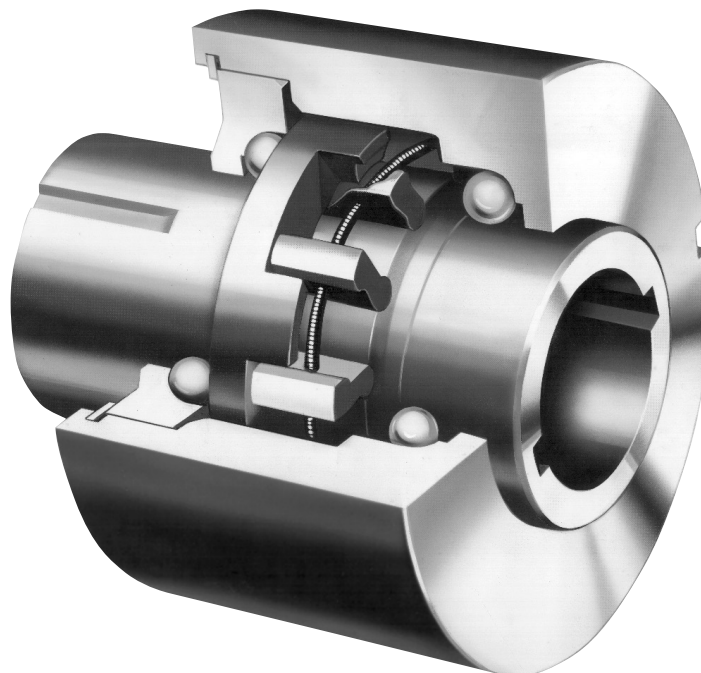
- Read and follow all instructions carefully.
- Disconnect and lock out power before installation and maintenance. Working on or near energized equipment can result in severe injury.
- Do not operate equipment without guards in place. Exposed equipment can result in severe injury or death.
- Read and understand the information in this section and in this manual completely before installing, operating or maintaining this equipment. Failure to follow this instruction could result in severe injury or death.

⚠ CAUTION

- Perform periodic inspections. Equipment may fail prematurely and could become unsafe if not properly inspected and maintained. Failure to follow this instruction could result in mild or moderate personal injury.

Models

RL-35A thru RL-160A



Introduction

The RL Clutch is a sprag type no-back which permits transmission of driving torque from input to output shaft in both directions of rotation, but which restrains any feed-back torque of the driven load from rotating the output shaft in either direction.

WARNING! Failure to follow these instructions may result in product damage, equipment damage, and serious or fatal injury to personnel.

Introduction

Formsprag RL Reverse Locking Clutches are factory lubricated with Lubriplate Low Temp low-temperature grease and are shipped ready to install. Remove the plastic plug from the outer race grease hole and place the RL clutch in the housing. Housing bore and clutch OD fits are tabulated below.

Note: Check to be sure the proper clutch member is aligned with the input before installing.

Install input and output shafts and keys and install ball bearings on each side of the RL clutch. See sketches on page 4. The bearings required to support the shafts to prevent radial and thrust loads from being applied to the RL clutch are also required to maintain alignment of the shafting. Use more than one bearing on each side if necessary to prevent deflection of the shafting due to external loading. (Bearings may not be needed with model RL-35 in light duty applications.) Check Catalog P-956 for overhauling loads and breakaway torques.

Note: Check to be sure the housing grease hole is in line with the grease hole in the RL clutch outer race.

RL clutches may be furnished for oil lubrication by special order. See instructions on Page 2, this page. for oil lubricated RL clutches.

Installing Oil Lubricated RL Clutches

Place the RL clutch in the housing. Follow instructions given above for installing the RL clutch, shafts and bearings. Install oil seals in the housing if necessary to prevent loss of oil from the RL clutch and from the housing. Provide a hole in the top of the housing in line with the hole in the RL clutch outer race. This hole may be used for supplying oil to the clutch. In addition, if oil seals are used, provide a hole in the housing at the one half full level. Use this for adding oil to the housing until the housing is one half and for periodic checking of the oil level. Also provide a drain at bottom of housing for draining and flushing.

Add oil before operating the RL clutch. (See Lubrication.)

Shaft Fits

A clearance fit .001 to .003 inches loose is recommended. Do not use press fits. (See Recommended Housing and Shaft Dimensions Table)

O.D. Housing Fits

RL clutch outside diameters are machined to fit in housings of standard ball bearing housing bores. Refer to ball bearing manufacturers recommendations. If housing bores are not prepared to ball bearing dimensions, a line fit to .002 inches loose is recommended. (See Recommended Housing and Shaft Dimensions Table)

Key Fits

A clearance fit from .001 to .002 inches loose is recommended for shaft and housing keys.

Alignment

Angular alignment of end to end shafts connected to the RL clutch must be within .001 inches per inch of shaft length. Parallel alignment must be within .001 of an inch per inch of nominal shaft diameter. These figures are maximum for either shaft to shaft or shaft to housing bore measurements.

Lubrication

Model RL-35A

Factory lubricated for life with special lubricant. No further Lubrication is required.

Models RL-47A thru RL-160A

These RL clutches are furnished grease packed. (Oil lubricated models are furnished by special order only.)

Grease Lubrication

Packed full at factory with Lubriplate Low Temp grease. Consult Formsprag Clutch if the operating temperature is less than 20°F. Also consult Formsprag Clutch for approval before using alternate greases.

Oil Lubrication

Temperature Range	Recommended Lubricant
+20°F to +150°F	Mobil DTE Heavy Medium
+20°F to -10°F	Mobil Gargoyle Arctic C Heavy
-10°F to -30°F	Mobil Arctic 155
-30°F or below	Consult Formsprag for silicone base lubricant developed specially for the RL clutch.

RL clutches should be 1/2 full of oil.

Important: Use Factory Recommended Lubricants only.

Models RL-47A thru RL-160A

Add grease every ninety (90) days. Under severe or dusty conditions or twenty-four hour daily operation, lubricate monthly. Insert grease fitting into grease hole in housing. Add grease until the old grease is purged from the RL clutch.

Oil Lubricated Models

Maintain oil level in RL clutch and housing one third to one half full. Check oil level weekly. Use factory recommended oils only. Add oil to RL clutch through hole provided at top of housing. Add oil to housing through hole provided at the one half full level.

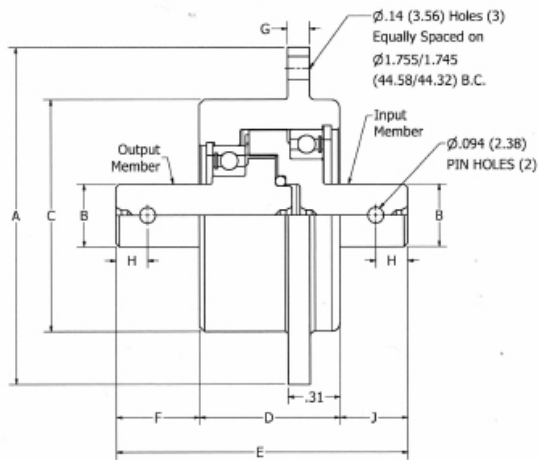
Note: Oil will flow from clutch to housing or from housing to clutch. However, since clearances are small, flow will be slow. Adding oil to both clutch and housing will speed oil adding process.

Important: Every ninety (90) days, drain oil from clutch and housing and flush with mineral spirits. Operate the clutch for 5 to 10 minutes to break up and dissolve the oily residue which may have formed. After flushing, add oil to clutch and housing as above.

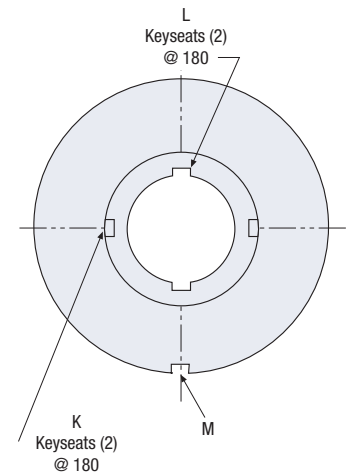
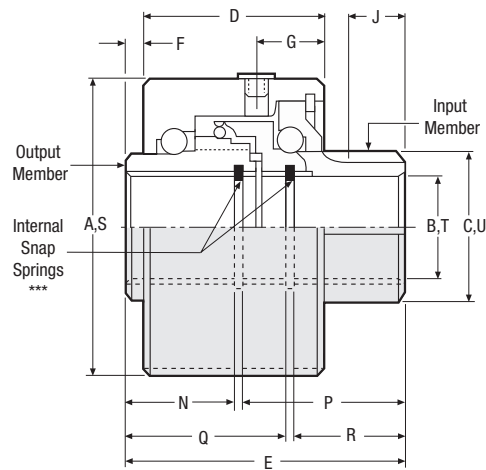
The RL clutch is available in several model sizes. The RL-35A is an economical, ball bearing, clutch specifically designed for hard operations, light duty machine tools, data processing equipment, instruments, etc. It is completely enclosed, self-contained, and permanently lubricated at the factory. The RL 35A is mounted through the external flange and pin holes in the included split shaft. Models RL-47A thru RL-160A are larger units applicable in an extensive torque capacity range. These models require lubrication.

Model RL-47A Through RL-160A

RL-35A



RL-47A through RL-160A



Dimensions inches (mm)

Size	A	B	C	D*	E*	F**	G*	H	J*
RL-35A	2.005/1.995 (50.93/50.67)	.3742/.3738 (9.505/9.495)	1.378/1.377 (35.00/34.96)	.843 (21.93)	1.75 (44.45)	.500 (12.70)	.06 (1.59)	.19 (4.76)	.40 (10.32)
RL-47A	1.8504/1.8499 (47.000/46.987)	.500/.501 (12.700/12.725)	.783/.782 (19.89/19.86)	1.563 (39.70)	2.125 (53.98)	.031 (.787)	.68 (17.48)		.43 (11.13)
RL-72A	2.8346/2.8341 (71.999/71.986)	1.000/1.001 (25.400/25.425)	1.376/1.375 (34.95/34.93)	1.719 (43.66)	2.625 (66.68)	.156 (3.96)	.85 (21.59)		.62 (15.88)
RL-90A	3.5433/3.5428 (89.999/89.987)	1.252/1.251 (31.800/31.775)	1.850/1.849 (46.990/46.964)	2.287 (58.089)	3.11 (78.994)	0.031 (0.787)	1.00 (25.40)		0.75 (19.05)
RL-115A	4.5276/4.5271 (115.001/114.988)	1.500/1.501 (38.100/38.125)	2.001/2.000 (50.83/50.80)	2.281 (57.94)	3.141 (79.78)	.031 (.787)	.87 (22.23)		.68 (17.48)
RL-130A	5.1181/5.1173 (129.999/129.979)	2.000/2.001 (50.800/50.825)	2.845/2.844 (72.26/72.24)	2.828 (71.83)	4.172 (105.97)	.031 (.787)	1.00 (25.40)		1.03 (26.19)
RL-160A	6.2992/6.2982 (159.999/159.974)	2.500/2.501 (63.500/63.525)	3.876/3.875 (98.45/98.43)	3.094 (78.59)	4.719 (119.86)	.031 (.787)	1.00 (25.40)		.93 (23.80)

* ± .010 (.254) except RL-35A

** ± .020 (.508) except RL-35A

*** Inside diameter of snap rings is larger than the bore size

Recommended Housing and Shaft Dimensions inches (mm)

Size	S Housing Bore	T Shaft Dia.	U Bore Dia.	Keyseat K	Keyseat L	Keyseat M	N	R	Q	P
RL-47A	1.8514/1.8520 (47.025/47.041)	.499/.498 (12.67/12.65)	.7833/.7838 (19.896/19.908)	3/32 x 3/64 (2.38 x 1.19)	3/32 x 3/64 (2.38 x 1.19)	1/8 x 1/16 (3.18 x 1.59)	.781 (19.84)	.813 (20.65)	1.156 (29.36)	1.188 (30.18)
RL-72A	2.8356/2.8362 (72.024/72.039)	.999/.998 (25.38/25.35)	1.3763/1.3768 (34.958/34.971)	5/32 x 5/64 (3.97 x 1.98)	5/32 x 5/64 (3.97 x 1.98)	1/8 x 1/16 (3.18 x 1.59)	1.000 (25.40)	1.000 (25.40)	1.469 (37.31)	1.469 (37.31)
RL-90A	3.5443/3.5451 (90.025/90.046)	1.250/1.249 (31.875/31.725)	1.8503/1.8510 (46.997/47.015)	3/16 x 3/32 (4.76/2.38)	3/16 x 3/32 (4.76/2.38)	3/16 x 3/32 (4.76/2.38)	1.250 (31.75)	1.250 (31.75)	1.770 (44.96)	1.770 (44.96)
RL-115A	4.5286/4.5294 (115.026/115.047)	1.499/1.498 (38.07/38.05)	2.0013/2.0020 (50.833/50.851)	1/4 x 1/8 (6.35 x 3.18)	1/4 x 1/8 (6.35 x 3.18)	1/4 x 1/8 (6.35 x 3.18)	1.188 (41.27)	1.188 (41.28)	1.781 (45.24)	1.781 (45.24)
RL-130A	5.1191/5.1201 (130.025/130.051)	1.999/1.998 (50.77/50.75)	2.8453/2.8463 (72.271/72.296)	5/16 x 5/32 (7.93 x 3.96)	5/16 x 5/32 (7.93 x 3.96)	1/4 x 1/8 (6.35 x 3.18)	1.635 (41.27)	1.635 (41.27)	2.375 (60.33)	2.375 (60.33)
RL-160A	6.3002/6.3012 (160.025/160.050)	2.499/2.498 (63.48/63.45)	3.8763/3.8775 (98.458/98.489)	1/2 x 1/4 (12.70 x 6.35)	1/2 x 1/4 (12.70 x 6.35)	1/4 x 1/8 (6.35 x 3.18)	1.875 (47.62)	1.875 (47.62)	2.688 (68.28)	2.688 (68.28)

Engineering Data

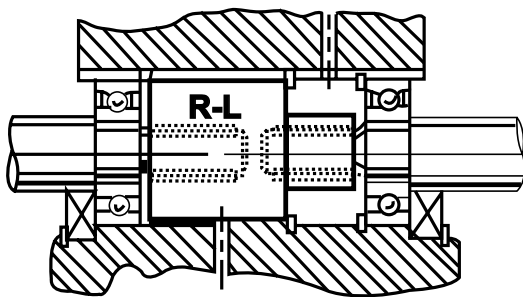
Model	Rated Capacity Lb. In. (Nm)	Drag After Break-in Lb. In. (Nm)(1)	Max. Operating Speed R.P.M. (2)	Weight Lb. (kg)
RL-35A/.375	96 (10.8)	1.0 (0.11)	1800	0.33 (0.14)
RL-47A/.500	300 (34)	1.0 (0.11)	1800	0.95 (0.4)
RL-72A/1.000	2,400 (271)	2.0 (0.22)	1800	2.5 (1.1)
RL-115A/1.500	8,500 (963)	5.0 (0.56)	1200	8.9 (4.0)
RL-130A/2.000	18,000 (2040)	10.0 (1.13)	1200	13.3 (6.0)
RL-160A/2.500	26,500 (3003)	20.0 (2.26)	900	22.9 (10.4)

(1) Break-in is equivalent to 24 hours of operation under ordinary circumstances.

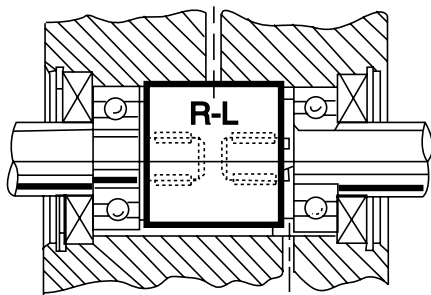
(2) Maximum driving speed permissible with grease pack if inertia torque as determined by selection procedure does not exceed rated torque.

Typical Installations

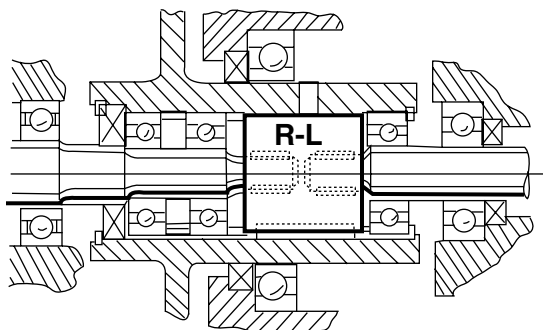
RL Reverse Locking Clutch



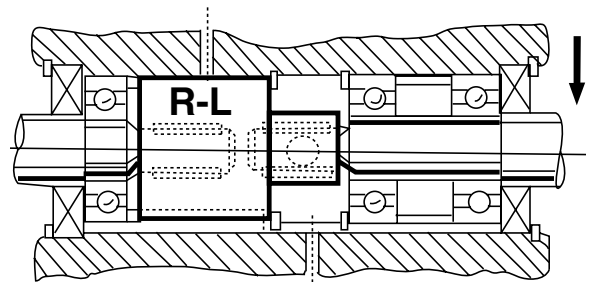
Fixed Housing – Grease Lubrication. (Grease purge hole required with shielded bearings.) If seals are used, install with lip outward. (All RL Models; RL-72, 115, 125 and 160 configuration shown.)



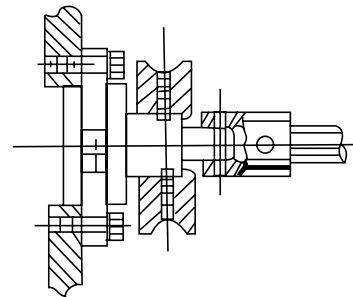
Fixed Housing – Oil Lubrication. Oil hole required at half full level and drain hole at bottom. Install seals with lips inward. (All RL Models; 47 configuration shown.)



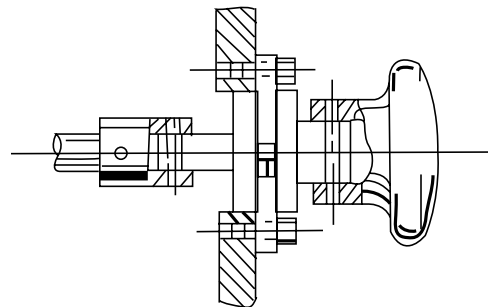
“Live Outer Race” Mounting Arrangement.
(All RL Models; 47 configuration shown.)



“Live Outer Race” Mounting Arrangement. (All RL Models; 47 configuration shown.)



Fixed Housing – “Overhung load” supported by two bearings. (All RL Models; RL-72, 115, 125 and 160 configurations shown.)



“Coaxial Arrangement” Flanged outer race fixed to stationary support, pulley fixed to control member with set screws and output shaft coupled to socket member with “Rollpins”. (RL-35)

Flanged outer race fixed to stationary support, hand knob fixed to control member with “Rollpin” and output shaft coupled to socket member with “Rollpins”. (RL-35)

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The proper selection and application of products and components, including assuring that the product is safe for its intended use, are the responsibility of the customer. To view our Application Considerations, please visit <https://www.regalrexnord.com/Application-Considerations>.

To view our Standard Terms and Conditions of Sale, please visit <https://www.regalrexnord.com/Terms-and-Conditions-of-Sale>.

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