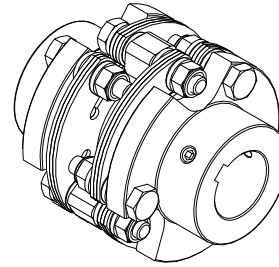


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Installation Instructions for Double Flex Six Bolt Composite Disc Couplings

1. Tools Required:
 - Torque wrench with sockets for coupling hex nuts and hub set screw or clamp collar screw (see table 1 and table 2).
 - Open end wrench for coupling hex bolts (see table 1).
 - Laser alignment tool or Dial indicator (recommended). If not available, a straight edge and feeler gauges.
 - Caliper
2. These instructions are for standard series couplings with normal running conditions. Special couplings may have different instructions or drawings.
3. Inspect hub bores, shafts and keyways making sure there are no burrs. Clean hub bores and shafts. Standard CD coupling clamped and set screw hubs are supplied with slight clearance fit (see catalog). Install hubs on shafts. Place one of the hubs flush with end of shaft. Tighten hub to shaft: If hub is set screw style (Fig 1), see Table 2 on page 3 for proper tightening torque. If installing clamped (Fig 2) or QD bushing hub (Fig 4) see assembly details on page 3.
4. Adjust hub separation to dimension “C” specified in the Table 1 and diagram 1. If possible, the shafts should not extend beyond the inside hub face. If the shaft extends past the hub face verify there is enough clearance to install the disc pack and also verify the shaft will not contact the disc pack during operation. Tighten second hub to the shaft.
5. Align the shafts within the limits for parallel and angular misalignment specified in Table 1. See diagrams 2 and 3 for recommended measurement and alignment methods. For best alignment results, use a laser alignment tool or dial indicator. Always rotate the hub on which the indicator is mounted.

Aligning the shafts as closely as possible at the time of initial installation will reduce noise and allow the coupling extra capacity for misalignments and loads which will occur during operation over the life of the connected equipment. Installing and operating the coupling at higher degrees of misalignment is possible (see catalog ratings), but will generally reduce the life of the composite disc pack.

Coupling and shaft alignment should be checked periodically due to foundation settling, equipment shifting, etc. Alignment should be re-checked after the first several hours of operation.

6. Install the intermediate member, disc packs, long and short bolts with nuts between the hubs; tightening the locknuts finger tight. Tighten the locknuts of one hub to ½ the stated torque value in table 1. Tighten the locknuts of other hub to ½ the stated torque value in table 1. Tighten the locknuts of the intermediate member to ½ the stated torque value in table 1. Repeat the process but tightening to the full torque value (see table 1). It is also recommended to apply torque on the locknut, not the bolt. Re-check and tighten all fasteners after several hours of operation to ensure proper tightening.

***NOTE: Rotating equipment is potentially dangerous and should be properly guarded. The user should follow all applicable safety codes and provide a suitable guard.**

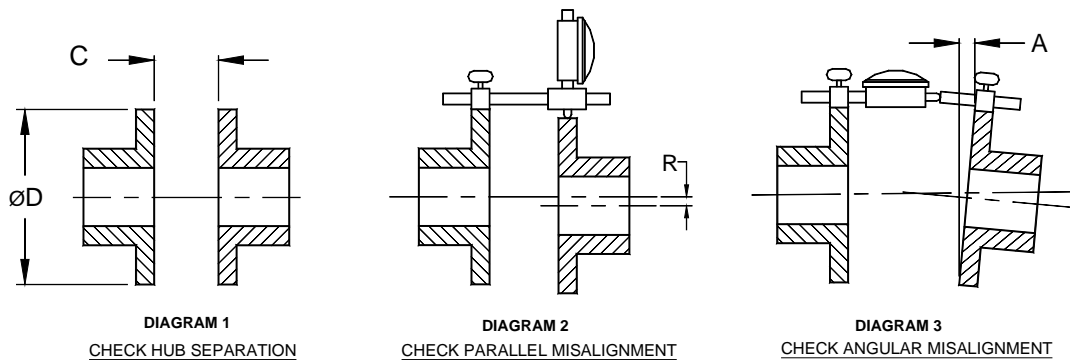


Table 1
Alignment and Assembly Specifications for Double Flex Series 6P

Model	Recommended maximum installed misalignments						Tightening Torque (Dry values)			Unit Outside Diameter Ø D	
	C See Diagram 1		R See Diagram 2		A See Diagram 3					Wrench Size	Inch
	Inch	mm	Inch	mm	Inch	mm					
6P18	0.803±0.020	20.4±0.50	0.008	0.20	0.016	0.41	2.5mm	18 in lb	214 Ncm	1.85	47.0
6P22	0.956±0.024	24.3±0.63	0.009	0.23	0.020	0.50	8mm	50 in lb	564 Ncm	2.25	57.2
6P26	1.034±0.029	26.3±0.74	0.010	0.25	0.023	0.58	8mm	50 in lb	564 Ncm	2.59	65.9
6P30	1.420±0.034	36.1±0.86	0.013	0.33	0.026	0.66	10mm	95 in lb	10.7 Nm	3.00	76.2
6P37	1.669±0.046	42.4±1.1	0.016	0.41	0.033	0.83	13mm	230 in lb	26 Nm	3.75	95.3
6P45	1.852±0.060	47.0±1.5	0.017	0.43	0.039	1.00	17mm	38 ft lb	51 Nm	4.50	114.3
6P52	2.105±0.074	53.5±1.8	0.021	0.53	0.046	1.20	17mm	38 ft lb	51 Nm	5.25	133.4
6P60	2.411±0.086	61.2±2.1	0.023	0.58	0.052	1.30	19mm	65 ft lb	88 Nm	6.00	152.4
6P67	2.704±0.100	68.7±2.5	0.025	0.64	0.059	1.50	19mm	65 ft lb	88 Nm	6.75	171.5
6P77	3.154±0.106	80.1±2.7	0.030	0.76	0.068	1.70	24mm	160 ft lb	217 Nm	7.75	196.9
6P90	3.581±0.120	90.9±3.0	0.034	0.86	0.079	2.00	30mm	310 ft lb	420 Nm	9.00	228.6
6P105	4.423±0.140	112.3±3.5	0.042	1.07	0.092	2.30	36mm	535 ft lb	725 Nm	10.50	266.7
6P120	4.822±0.166	122.5±4.2	0.046	1.17	0.105	2.70	36mm	535 ft lb	725 Nm	12	304.8

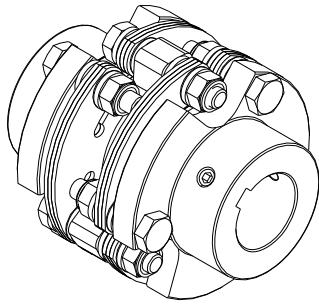


Fig. 1
Set Screw Style Hub

Table 2
Set Screw Torque Table

Screw Size	Wrench Size	Torque (in lb)	Torque (Nm)
#10-32unf	0.094	36	4.1
¼-20unc	0.125	87	9.8
3/8-16unc	0.188	290	33
½-13unc	0.250	620	70
¾-10unc	0.375	2400	271
1"-8unc	0.563	5000	564
Metric			
M5 x 0.8	2.5mm	35	4.0
M6 x 1.0	3mm	64	7.2
M8 x 1.25	4mm	150	17
M10 x 1.50	5mm	290	33
M12 x 1.75	6mm	480	54
M20 x 2.50	10mm	2100	237
M24 x 3.00	12mm	3860	440

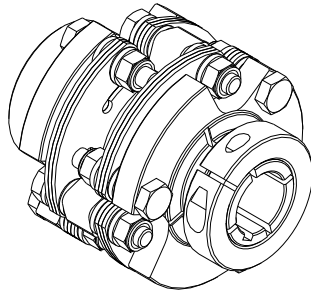


Fig. 2
Clamp Style Hub

See clamp collar labels for tightening

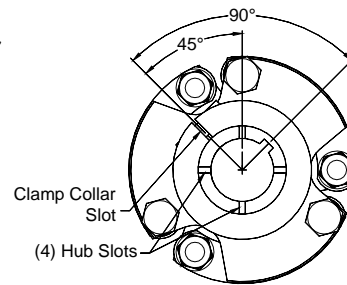


Fig. 3
Clamp Slot Location

Clamp Hub Assembly

Before tightening the clamp collar screw, orient the clamp collar 90 degrees from the keyway centerline (See Fig 3). If there is no keyway, orient the clamp collar 45 degrees from one of the hub slots (See Fig 3). Tighten clamp screw to tightening torque shown on clamp collar.

QD Bushing Hub Assembly

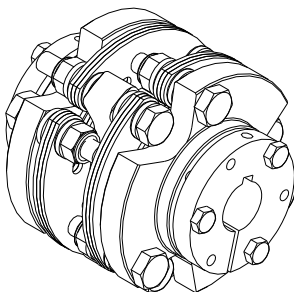


Fig. 4
QD Bushing Style Hub

When tightening the QD Bushing bolts the Hub will be pulled toward the bushing flange. The amount of movement is generally 0.06 to 0.10 inches (1.5 to 2.5mm) per hub. Install one hub/bushing assembly on the shaft and tighten the QD bushing to specifications. Place the second hub/bushing assembly on the shaft with a hub separation of 0.08 less than the "C" dimension shown in the Table 1 on page 2, See diagram 1. Torque the QD bushing bolts to the manufacturer's specification and verify hub separation and misalignment. Loosen bolt and adjust assembly as needed until hub separation and misalignment are within specifications. Consult QD bushing manufacturer's documentation for proper tightening torque and sequence.

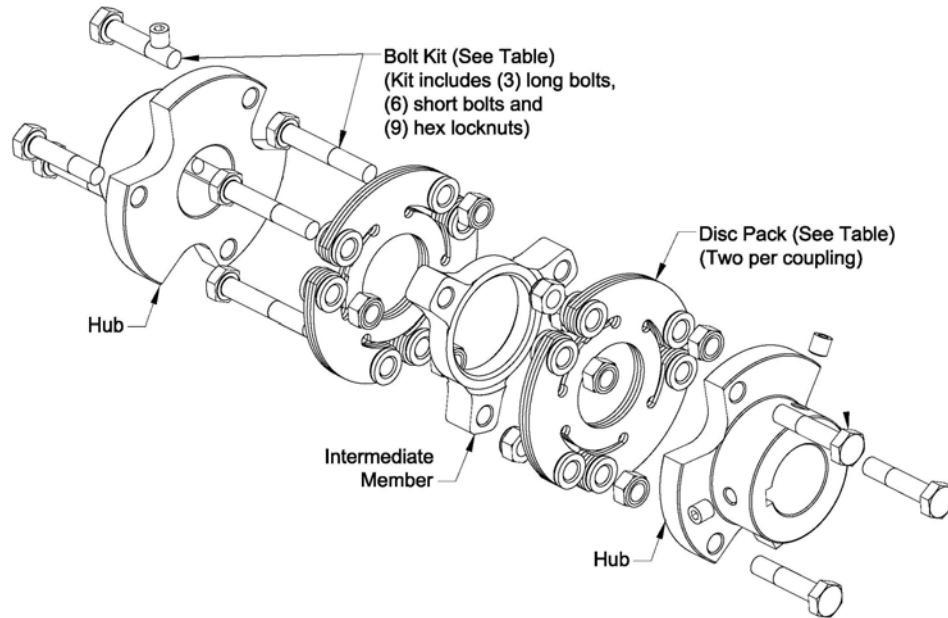


Fig. 5

Table 4
Replacement Parts

Model	Hub OD (inch)	Disc Pack		Bolt Kit	
		Qty	Part No	Qty	Part No
6P18	1.85	2	A018002	1	A010018
6P22	2.25	2	A022000	1	A010022
6P26	2.59	2	A026000	1	A010026
6P30	3.00	2	A030000	1	A010030
6P37	3.75	2	A037000	1	A010037
6P45	4.50	2	A045000	1	A010045
6P52	5.25	2	A052000	1	A010052
6P60	6.00	2	A060000	1	A010060
6P67	6.75	2	A067000	1	A010067
6P77	7.75	2	A077000	1	A010077
6P90	9.00	2	A090000	1	A010090
6P105	10.50	2	A105000	1	A010011
6P120	12.00	2	A120000	1	A010012