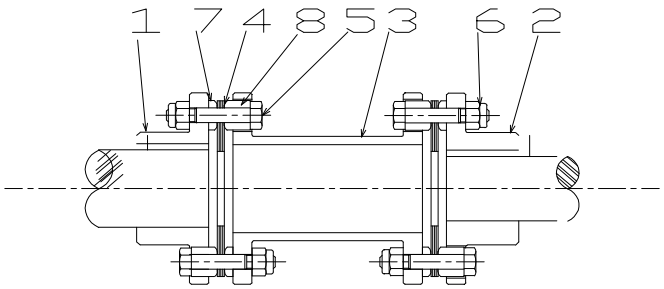
DPI-1100-K01E-R0

FORM-FLEX INSTALLATION
AND MAINTENANCE INSTRUCTION
(MATCH MARK)

(TYPE : AX,A4,AB,A5,E4,E5,G4,GB,G5)

DAIDO PRECISION INDUSTRIES LTD.



Parts

1. Hub 1
2. Hub 2
3. Spacer
4. Element
5. Bolt
6. Nut
7. Thin Washer
8. Thick Washer

In case of Type E and G,
No.8 is Over Load Washer

Fig.1

Proper care in installing and aligning will permit couplings to operate to full capacity, compensate for misalignment, and provide very good service life.

1. Inspect shafts and hubs bores and make sure they are free from burrs. Check for the proper fit of the keys to the shafts and hubs.

2. Fit the coupling hubs so that the shaft ends are flush with the face of the flange. If the hub is bored for an interference fit, the hubs should be heated in oil @ 200-250° F and then quickly positioned on the shaft.
   Do not spot heat as it may cause distortion.

3. Move the equipment to be connected into position. Set the gap between the hub faces to be required, distance between shaft ends, D dimension.

4. Assemble the blade packs to the spacer as shown in Figure 2.
   When match marks are specified, arrange the parts or correct position according to them.
   Tighten these nuts to the proper torque as indicated in Table 1.

Table 1
NUT TIGHTENING TORQUE

SIZE / TYPE	00	01	02	03	04	05	10	15	20	25	30	35	40
A	／	／	／	／	／	9	9	22	22	41	72	72	160
E	22	41	72	160	220	220	220	440	570	1100	1500	1700	1700
G	／	72	／	160	／								

SIZE / TYPE	45	50	55	60	65
A	160	220	570	／	／
E	1700	3000	3500	3700	4000
G					

UNIT : Nm

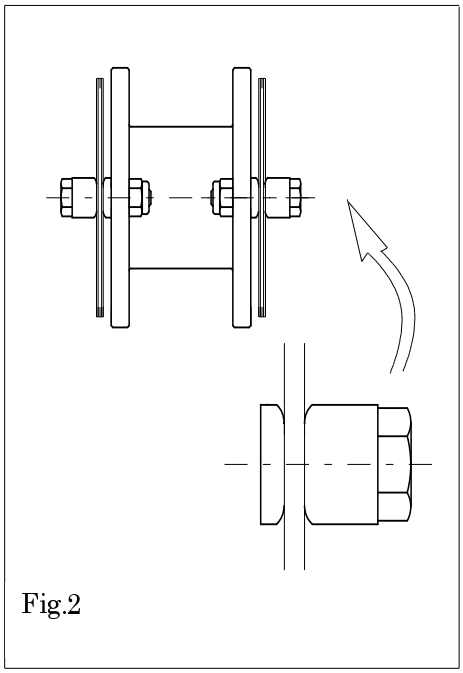


Fig.2

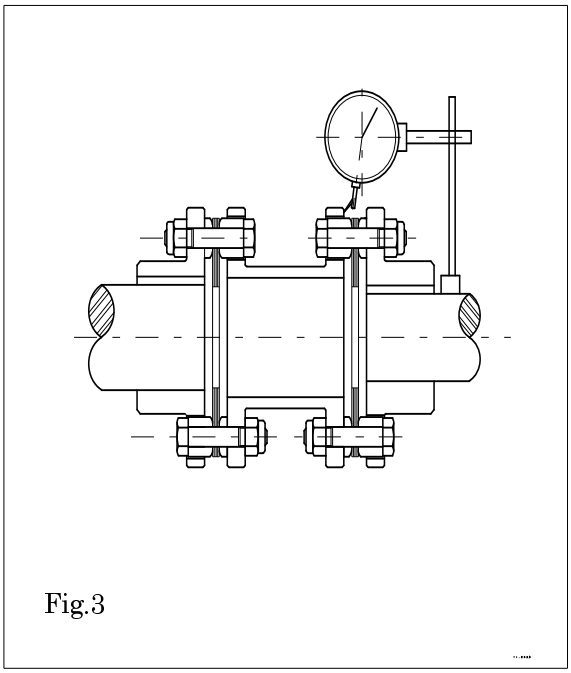


Fig.3

ALIGNMENT

1. Bring the equipment into an approximate good alignment, by attaching one end of the equipment. (Be sure the spacer assembly is fully supported at this time. If it is not, damage to the connected blade pack may result.)

2. With one end of the coupling attached, align the two pieces of equipment well enough to assemble the opposite end of the spacer to its hubs.

3. Attach a dial indicator to each hub. Indicate a point on the nearest spacer flange as shown. Any method may be used to attach the indicator to the hub. Be sure it is firmly attached. See Figure 3.

4. Rotate the coupling 360° to locate the minimum reading on the dial, then rotate the body or face of the indicator so that the zero reading lines up with the pointer.

5. Rotate the coupling 360° while watching the indicator for misalignment readings. The driver and driven equipment will be aligned when the maximum indicator readings are within the allowable limits as shown in Table 2. Adjust the equipment as necessary to comply with the limits.

6. Repeat this method for the other end of the coupling.
   Note : when the equipment is properly aligned, it is advisable to dowel the right gear box to its base. It has been found from experience that the right angle gear box tends to
   creep in a counter rotational direction. Recheck alignment after doweling.

Table 2

TYPE \ SIZE	00	01	02	03	04	05	10	15	20	25	30	35	40
A	／	／	／	／	／	0.12	0.15	0.16	0.18	0.22	0.25	0.29	0.34
E	0.21	0.24	0.28	0.32	0.37	0.48	0.48	0.53	0.60	0.65	0.71	0.77	0.81
G	／	0.37	／	0.43	／								

TYPE \ SIZE	45	50	55	60	65
A	0.37	0.43	0.48	／	／
E	0.88	0.96	1.02	1.09	1.13
G					

UNIT : mm (T.I.R)

1. With equipment aligned and coupling assembled make sure all bolts and washers are in the proper orientation. The curved face of the washer must face the blade pack as shown in Figure 2.

   IMPORTANT : To ensure unlimited life, re-check alignment after a short period (one to two hours) of actual running.

   At this time also re-torque bolts and nuts to values in table.