

Installation Guide: Clutches, Brakes, & Clutch/Brakes with Clamp Style Shaft Design

1. Apply a light coating of anti-seize lube to mounting shaft.
2. Place key stock into mounting shaft keyway.
3. Remove the clamp collar by loosening the clamp collar screws.
4. Align unit keyway with that of mounting shaft keyway and gently slide unit on the mounting shaft. **NOTE: Shaft engagement for end mounted units should be no less than the unit shaft bore depth minus 1/4".**
5. If the unit is supplied with a drive, ensure that the unit drive is in-line with associated drive to avoid axial chain/belt pull.
6. Reinstall the clamp collar onto the unit's shaft. Be sure to have the clamp collar located inside the groove provided.
7. Torque socket head cap screws to the recommended torque listed in the Torque Capacity Chart.

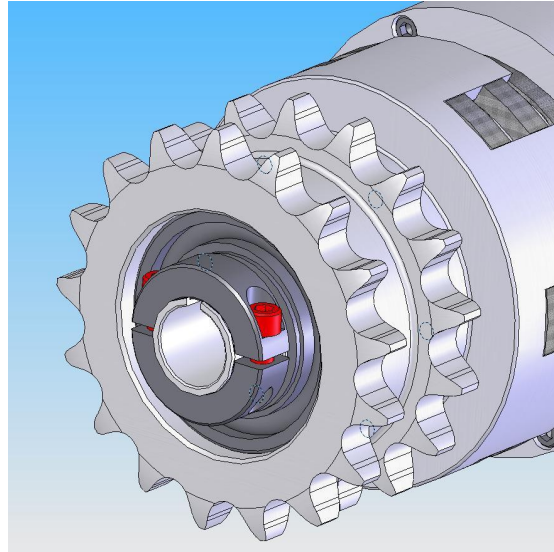


Figure 1: Clamp Style Shaft.

Torque Capacity Chart: Socket Head Cap Screws	
Screw Size (Inch)	Seating Torque (lb-in)
1/4-28	175
5/16-24	340

8. If the unit has a stationary piston housing:
 - a. Rotate the unit housing so the air inlet port is in the 6 o'clock position to reduce likelihood of air supply line moisture entering unit housing.
 - b. Attach torque arm (Shoulder Bolt) to stationary piston housing using the threaded anti-rotate holes. **Note: Torque arms should be a non-rigid restraint (a bracket, stopping peg, or strap).**
 - c. Attach air line fitting to air port hole of unit housing taking care not to cross-thread. Use a small amount of joint compound to help prevent possible leaks.
9. If the unit is supplied with a quick-disconnect rotary union:
 - a. Connect the plastic air supply line. **Note: If the air line is pulling against the fitting in any direction other than the direction of rotation, premature failure will occur.**

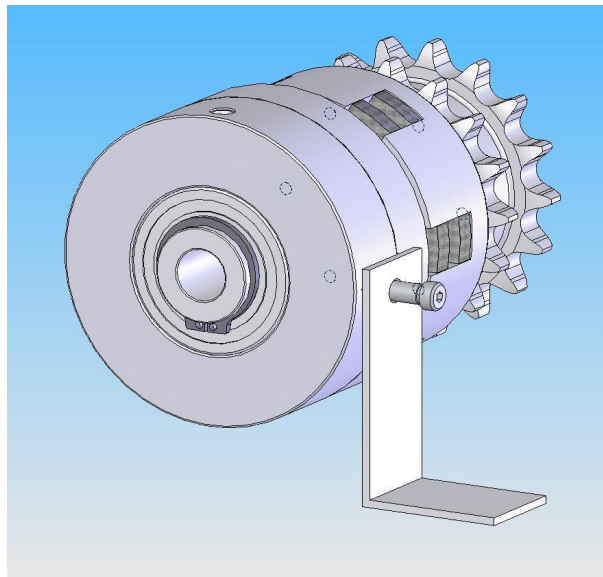


Figure 2: Anti-Rotate Bracket with Shoulder Bolt Used as a Torque Arm on a Stationary Piston Housing