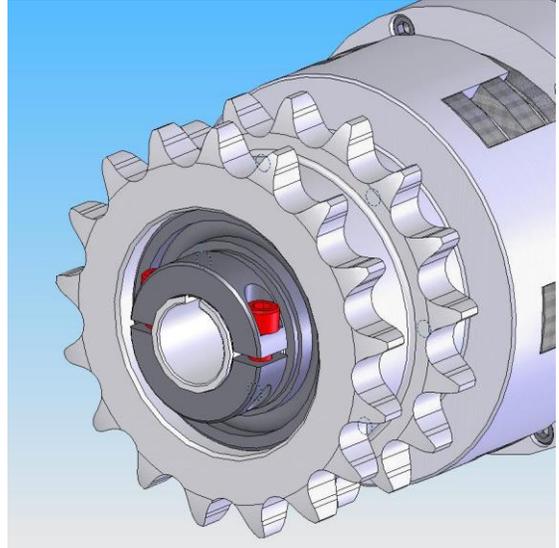


# Installation Guide: Clutches, Brakes, & Clutch/Brakes

## Set Screw & Clamp Style Shaft Design

1. Remove packet of anti-seize compound from the bore of the unit
2. Apply a light coating of anti-seize compound to the mounting shaft (mounting shaft not provided)
3. Place keystock into the keyseat located on the mounting shaft
4. Loosen the socket head cap screws on the clamp collar and remove the clamp collar from the unit
5. Align keyway in the bore of the unit with that of mounting shaft 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 ¼"**
6. If supplied with a drive, ensure that the unit drive is in-line with associated drive to avoid axial chain/belt pull
7. If set screw style unit, tighten set screws of unit after unit is in correct position. Refer to torque values listed in the chart below for set screw tightening torque.
8. If clamp collar unit, reinstall the clamp collar onto the unit's shaft. Be sure to have the clamp collar seated in the groove provided
9. Ensure that the keystock is seated inside the unit and is not located beneath the clamp collar
10. Torque socket head cap screws on clamp collar to the recommended torque (see chart below)



SET SCREWS	
Set Screw Size	Recommended Torque (in-lb)
#10-32	33.5
1/4-28	77.9
5/16-24	156
3/8-24	273
7/16-20	428

CLAMP COLLAR SOCKET HEAD CAP SCREWS	
Screw Size (Inch)	Recommended Torque (in-lb)
1/4-28	175
5/16-24	340

If the unit has a stationary piston housing:

- a. Although many positions may be allowable, it is recommended that the unit housing is rotated so that the air inlet port hole is in the 6 o'clock position. This will reduce the likelihood of air supply line moisture entering unit housing.
- b. Attach torque arm to stationary piston housing using the threaded anti-rotate holes (See Figure)  
**NOTE: Torque arms should be a non-rigid restraint (bracket, stopping peg, or strap)**
- c. Attach air line fitting to air port hole located on housing of the unit. Be sure not to cross-thread. Use a small amount of joint compound to help prevent possible leaks

If the unit is supplied with a quick-disconnect rotary union:

- a. Connect the plastic air supply line  
**WARNING: If the air line is pulling against the fitting in any direction other than the direction of rotation, premature failure will occur.**

