

# Form-Flex® Axially Split Spacer Coupling Type BA and DA All Sizes Installation Instructions

P-5001-TBW  
FORM 1170



**WARNING: Cancer and Reproductive Harm - [www.P65Warnings.ca.gov](http://www.P65Warnings.ca.gov)**

BILL OF MATERIALS			
ITEM	PART NAME	QTY REQ'D	
		BA	DA
1	HUB	2	2
2	C COUPLING BOLT	12	16
3	FLEX DISC	2	2
4	ELEMENT WASHER	24	32
5	C COUPLING NUT	12	16
6	SPLIT SPACER	1	1
7	MOUNTING	24	32
8	ADAPTER	2	2

**WARNING**  
ROTATING EQUIPMENT IS POTENTIALLY DANGEROUS AND MUST BE PROPERLY GUARDED. THE USER SHOULD COMPLY WITH APPLICABLE SAFETY CODES IN ACCORDANCE TO OSHA STANDARDS.



FIGURE 1

## INSTALLATION DATA TABLE

LINE	DESCRIPTION	BA33	BA39	BA43	DA31	DA35	DA37	DA42	DA45	DA50	DA55	DA60	DA70
1	(A) COUPLING O.D. inches	4.89	5.97	6.70	7.41	9.89	9.89	10.50	11.31	12.99	14.44	16.00	19.25
2	(D) SHAFT GAP inches	0.12	0.12	0.12	0.19	0.25	0.25	0.25	0.31	0.39	0.39	0.39	0.39
3	(G) FLEX DISC GAP inches	0.33	0.40	0.49	0.44	0.54	0.59	0.69	0.75	0.95	1.04	1.10	1.40
4	(T) FLEX DISC THICKNESS inches	0.15	0.20	0.24	0.25	0.29	0.31	0.31	0.37	0.45	0.54	0.59	0.79
5	COUPLING NUT UNF THREAD SIZE	1/4	5/16	7/16	7/16	1/2	9/16	5/8	5/8	3/4	7/8	1	1 1/8
6	TIGHTENING TORQUE lb·ft Torque values for lubricated threads	9	17	45	40	70	95	125	150	210	320	460	575
7	MOUNTING FASTENER UNF SIZE	1/4	1/4	5/16	5/16	3/8	7/16	7/16	1/2	5/8	5/8	3/4	7/8
8	TIGHTENING TORQUE lb·ft Torque values for lubricated threads	9	9	15	15	30	45	45	70	140	140	210	320
9	ALIGNMENT TIR inches	.010	.012	.014	.004	.004	.004	.005	.006	.006	.007	.009	.009

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

Shafts may become misaligned as a result of many natural and unavoidable causes. Heat, vibration, bearing wear, settling of foundations, etc., all tend to alter initial alignment. To ensure long life, recheck alignment after a short period of actual running.

In general, coupling life is increased when shafts are initially aligned carefully. If this is not done and a coupling is heavily stressed by torque or other forces, it will have little reserve left with which to accommodate misalignment stresses; and it might not provide the length of service intended. The closer the alignment TIR is to zero, the better the service life of the coupling.

## INSTALLATION

- 1) A complete coupling should consist of the components shown in the Bill of Materials in Figure 1. Examine the coupling to assure that no components are missing or damaged.
- 2) Inspect hubs and hubs to make sure they are free from burrs. Check for proper fit of the keys to the shafts and hubs. Check for proper fit of the keys to the hub and shaft keyways. Key edges should be chamfered to avoid interfering with rounded corners of the hub and shaft keyways. Keys should fit snugly side to side and about .010-.020" loose top and bottom.
- 3) Install coupling hubs with the flanged end away from the shaft end. Position each hub so that the small diameter end of the hub is flush to the end of the shaft.  
**Installing Interference Fitted Hubs**
  - a) Measure hub and shaft bores. The interference (hub bore - shaft diameter) should not exceed .0017" inch of shaft diameter.
  - b) Heat the hub uniformly. Use an oven, oil bath or similar process to provide uniform heating. Do not spot heat. Do not heat the hub above 300°F as distortion may occur. The temperature difference between the hub and shafts should be 100-150°F for each .0017" inch of interference.

# Tb Woods Manual 1226

**SB Merriam**



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