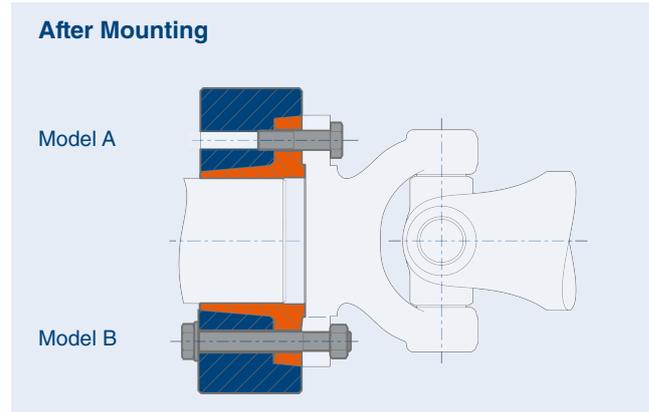
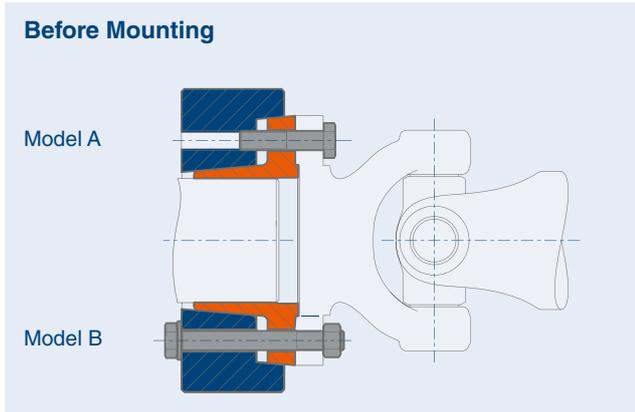


Mounting and Removal Instructions for STÜWE® Cardan Shaft Coupling GF



Mounting

The STÜWE® cardan shaft couplings GF are supplied ready to be mounted.

- Series 21** with tightening bolts
Series 22 und 23 with tightening bolts,
 without flange connecting bolts.

Therefore they should not be dismantled prior to employing the unit for the first time.

1. Degrease flange bore, shaft, and front of locking unit and cardan shaft.



Do not tighten the tightening bolts before the shaft is mounted.

2. Push flange onto the shaft.
3. Tighten the tightening bolts. It should consider the following:
 - With series 21 the locking unit and the cardan shaft will be connected in a single pass.
 - With series 22 and 23 all tightening screws have to be tightened in the first pass. In the second pass the cardan shaft has to be mounted with flange connecting bolts.

Approach:

- 3.1 Tighten four bolts evenly distributed over the circumference by reduced torque (approx. 50 to 70 % of maximum tightening torque).
- 3.2 Afterwards tighten all tightening bolts uniformly, one by one, over several revolutions with the maximum torque until the outer ring hits the inner ring and until the bolts can not be tightened with the max. torque anymore.
4. Check each tightening bolt twice for the required tightening torque.

Dismounting

This is similar to mounting.

1. With series 22 and 23 first remove all flange connecting bolts and the cardan shaft.
2. Loosen all tightening bolts uniformly and one by one, initially not more than a quarter turn per bolt.



Under no circumstances should the locking bolts be completely removed as this could be dangerous and result in injury.

3. Should the outer ring, when loosening the bolts, not slide automatically from the inner ring, this can be assisted by removing those locking bolts adjacent to the tapped holes provided for jacking purposes and screwing them into these tapped holes (only series 22 and 23).
4. Dismount shaft or pull off flange. Remove rust which may have formed on the shaft in front of the locking unit.

Cleaning and greasing

Dismounted cardan shaft connecting flanges do not have to be taken apart and re-lubricated before remounting. The conical surfaces have to be cleaned and regreased only if employed in dirty environment.

Use a solid containing lubricant with a high content of MoS₂ and a coefficient of friction of $\mu = 0,04$ to lubricate the conical surfaces. Usually a combination of bonded coating and paste is chosen.

Examples:

Lubricant	Source
Molykote D 321 R (bonded coating)	Dow Corning
Aema-Sol MO 84-K (bonded coating)	A.C. Matthes
Molykote G Rapid + (paste)	Dow Corning
Aema-Sol M 19 P (paste)	A.C. Matthes

The bolts have to be renewed if possible.

The bolts are lubricated with commercially available bolt lubricants ($\mu = 0,1$)