

MOTOR MOUNTING

The following procedure is required only when the motor is mounted at the job site.

1. Thoroughly clean the motor feet and mounting pads of grease, burrs, and other foreign matter to ensure firm seating of the motor.
2. Attach the motor to the base using the bolts and motor-raising blocks, if required. Bolt snugly through the base.
3. Weld the four kick bolts into place so that they are positioned to allow movement of the motor feet.
4. Now that the motor has been set, check to see that the shafts are properly spaced for the coupling being used. Refer to the coupling data tables for the applicable dimension (pages 5 and 6).

CHECKING MOTOR/COMPRESSOR ROTATION



Make sure coupling hubs are tightened to the shaft before rotating the motor to prevent them from flying

off and possibly causing serious injury or death.

COMPRESSOR ROTATION IS CLOCKWISE WHEN FACING THE END OF THE COMPRESSOR SHAFT. Under NO conditions should the motor rotation be checked with the coupling center installed as damage to the compressor may result. Bump the motor to check for correct compressor rotation. After verification, install gear or disk drive spacer, as applicable.



COMPRESSOR/MOTOR COUPLINGS INSTALLATION

RWB II units are arranged for direct motor drive and require a flexible drive coupling to connect the compressor to the motor. Before installing, perform the following:

1. Inspect the shaft of the motor and compressor to ensure that no nicks, grease, or foreign matter is present.
2. Inspect the bores in the coupling hubs to make sure that they are free of burrs, dirt, and grit.

3. Check that the keys fit the hubs and shafts properly.

CH COUPLING – The T.B. Woods Elastomeric CH Coupling is used in most applications up to 600 HP. It consists of two drive hubs and a loose, gear-type Hytel Drive Spacer. The split hub is clamped to the shaft by tightening the clamp screws. Torque is transmitted from the motor through the elastomeric gear which floats freely between the hubs. Install as follows:

1. Slide one hub onto each shaft as far as possible. It may be necessary to use a screwdriver as a wedge in the slot to open the bore before the hubs will slide on the shafts.

2. Hold the elastomeric gear between the hubs and slide both hubs onto the gear to fully engage the mating teeth. Center the gear and hub assembly so there is equal engagement on both shafts. Adjust the space between hubs as specified in the CH Coupling Data Table below.

3. Torque the clamping bolts in both hubs to the torque value given in the CH Data Table. **DO NOT USE ANY LUBRICANT ON THESE BOLTS.**

4. Proceed to Coupling Alignment.

DBZ-B COUPLING – The Thomas DBZ-B coupling is used on applications above 600 HP and with sleeve bearing motors that do not have axial end float constraint. The DBZ-B coupling consists of two drive hubs and a flexible metal disc drive spacer that is bolted to both hubs. A flexible steel disc pack serves as the drive element. This disc pack is bolted to the coupling hubs and prevents axial end float between the compressor and motor shafts which may occur with sleeve bearing motors. On sleeve bearing motors, the magnetic center must be determined and maintained by securing the coupling to the motor shaft with the shaft properly located.



Injury may occur if loose clothing, etc. becomes entangled on the spinning motor shaft.

If the motor is coupled to the compressor using a fixed-end-play coupling, such as a DBZ-B coupling, and the motor is not properly centered, additional thrust loads will be transmitted to the compressor bearings that could result in premature bearing failure. Install as follows:

1. Remove the eight locknuts and long bolts attaching the center member to the disc pack.
2. Slide the disc pack and coupling hub assemblies on their respective shafts.

DBZ-B COUPLING DATA TABLE

DBZ-B COUPLING SIZE	HUB FACE				MAXIMUM TOTAL INDICATOR READING		CLAMP BOLT		
	SPACING		±				TORQUE (LUBE)		SIZE
	in.	mm	in.	mm	in.	mm	ft-lb	Nm	
226	3 ¹¹ / ₁₆	96.8	1/64	.40	.003	.076	14	19.5	1/4 - 24 UNRF
263	4 ¹ / ₁₆	109.5	1/32	.79	.004	.102	22	30.6	1/4 - 24 UNRF
301	4 ¹ / ₁₆	123.8	1/32	.79	.004	.102	37	51.5	1/4 - 20 UNRF
351	5 ¹ / ₁₆	149.2	1/32	.79	.004	.102	55	76.5	1/4 - 20 UNRF
401	6 ¹ / ₁₆	169.9	1/32	.79	.004	.102	49	68.2	1/4 - 20 UNRF

CH COUPLING DATA TABLE

CH COUPLING SIZE	BETWEEN SHAFT SPACING				COUPLING HUB SHAFT ENGAGEMENT				FACE SPACING		MAX TOTAL INDICATOR READING		CLAMP BOLT TORQUE (DRY)		KEYWAY SETScrew TORQUE		
	MIN		MAX		MIN		MAX		MIN		MAX		TORQUE (DRY)		SIZE		
	in.	mm	in.	mm	in.	mm	in.	mm	in.	mm	in.	mm	ft-lb	Nm	ft-lb	Nm	
8	3 ¹¹ / ₁₆	96.8	4	101.6	1 ¹ / ₁₆	27.0	1 ¹¹ / ₁₆	46.0	1 ¹ / ₁₆	26.6	.004	.104	55	74.6	1/4 - 24 UNF	53	17.6
9	4 ¹ / ₁₆	109.5	5 ¹ / ₁₆	128.1	1 ¹ / ₁₆	26.5	2 ¹ / ₁₆	51.9	1 ¹ / ₁₆	26.5	.004	.104	55	74.6	1/4 - 24 UNF	53	17.6
10	4 ¹ / ₁₆	109.5	6 ¹ / ₁₆	151.9	1 ¹ / ₁₆	42.9	2 ¹ / ₁₆	55.1	1 ¹ / ₁₆	42.9	.004	.104	130	176.4	1/4 - 20 UNF	53	17.6
11	4 ¹ / ₁₆	123.8	5 ¹ / ₁₆	149.2	2	50.8	2 ¹ / ₁₆	73.0	1 ¹ / ₁₆	47.6	.004	.104	130	176.4	1/4 - 20 UNF	53	17.6

* Required for shaft seal removal.

Frick Rwb Ii Manual

Ying-Ying Zheng



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BRCON 2 Manual Kathryn Berg, 1991 *ROTCM 145-4-2* United States. Department of the Army, 1958 **BBL. 2 User's Manual** Nang-Ping Chen, 1985 **SLAM II**, 1990

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