#### MOTOR MOUNTING

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

 Thoroughly clean the motor feet and mounting pads of grease, burns, and other foreign matter to ensure firm seating of the motor.

Attach the motor to the base using the bolts and motorraising blocks, if required. Bolt snugly through the base.

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).

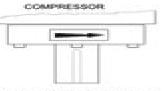
#### CHECKING MOTOR/COMPRESSOR ROTATION

**AWARNING** 

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 compres-



sor 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:

 Inspect the shaft of the motor and compressor to ensure that no nicks, grease, or foreign matter is present.

Inspect the bores in the coupling hubs to make sure that they are free of burns, dirt, and grit. 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 Hytrel 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:

 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.

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 belted to both hubs. A flexible steel disc pack serves as the drive element. This disc pack is belted 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.

## A CAUTION

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-endplay 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:

 Remove the eight locknuts and long bolts attaching the center member to the disc pack.

Slide the disc pack and coupling hub assemblies on their respective shafts.

#### DBZ-B COUPLING DATA TABLE

DBZ-B COUPLING SIZE		HUB FA	CE		MAXIMU	M TOTAL	CLAMP BOLT				
	SPACING		-4-		INDICATOR	READING	TORQUE	SIZE			
	im.	ED 600	lim.	con con	lim.	minn.	ft-fb	Nm	29140.00		
226	374	96.8	1/64	.40	.003	.076	1.4	19.5	Vin - 24 UNIFO		
263	47700	109.5	1/32	.79	.004	.102	22	30.6	*% - 24 UNRE		
301	47.6	123.8	1/32	.79	.004	.102	37	51.5	1/m - 20 UNR		
351	5/%	149.2	1/32	.79	.004	.102	55	76.5	% - 20 UNIRE		
401	67°77m	169.9	1/32	.79	.004	.102	49	68.2	1/a - 20 UNRI		

#### CH COUPLING DATA TABLE

OH COUP- LING SIZE	BETWEEN SHAFT SPACING				COUPLING HUB SHAFT ENGAGEMENT				FACE		MAXTOTAL INDICATOR		CLAMP-BOLT			KEYWWY SETSCREW	
	MINT N		AUX MAINS		MAX		SPACING		READING		TORQUE (DRY)		and the second	TORIQUE			
	in.	Amore I	lien.	PROPERTY.	in.	and the same of	lien.	enven.	lan.	- more	lim.	PROPERTY.	m-45-	19m	SIZE	85-85	Name
- 8	2007/14	96.6	4	101.6	1754	27.0	17770	46.0	1.7%	28.6	.004	.104	55	74.6	55 - 24 UNIF	10.5	17.6
- 9	477.00	109.5	5/7/mm	1238.1	177m	365.5	27%	63.0	3.77	265.5	-004	304	555	74.6	No. 24 LINE	123	17.6
10	4675714	109.5	675	167.9	10 TV/mm	42.9	2500	65.1	11.77 Per	42.9	.004	.1004	130	176.4	"/w - 210 IUMEF	53	17.46
11	45%	123.8	5770	149.2	2	50.8	27%	73.0	3.75 m	47.6	.004	.004	130	176.4	THE 20 LINE	13	17.6

Required for shaft seal removal.

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