

## FITTING

In mounting the couplings **Northon** please follow these instructions:

- 1) Clear accurately the shafts to be connected and the holes of the two half-couplings.
- 2) Heat the coupling halves to the temperature indicated below depending on the tolerances adopted.

Tolerance H7/m6	Tolerance H7/n6	Tolerance H7/r6	Tolerance H7/s6
+ 90°C	+ 110°C	+ 160°C	+ 200°C

- 3) Fitting the half-couplings at the end of each shaft.
- 4) When the half-couplings are cold, bring them together to get the value of “s” as indicated in the table. In order to check this value, use a feeler gauge and verify that the share is identical in 4 points placed at 90 ° to each other (Fig 1).
- 5) Check with a straight edge, on 2 points of the external diameter of the half-coupling, situated at 90° with each other, the parallel and angular misalignment of the shafts. The alignment can be considered correct when you will not notice the passage of light between the straight edge and the external diameter of the two half-couplings. (Fig 2).

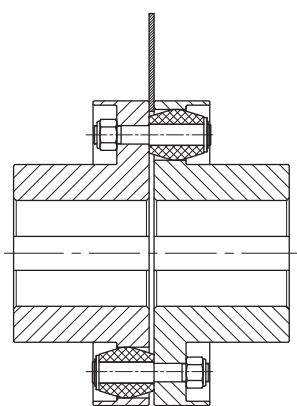


Fig. 1

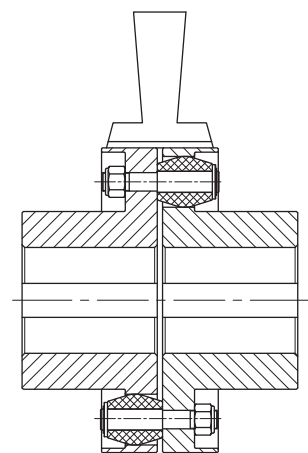
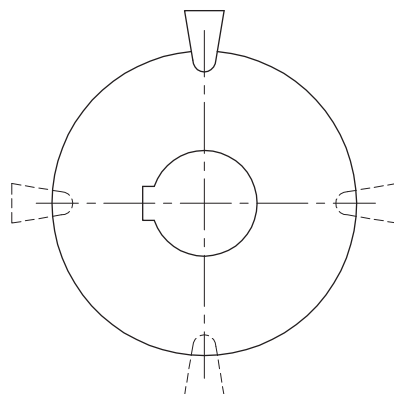


Fig. 2

It is unnecessary to say that a **better alignment** corresponds to a **longer life** of the coupling.