

Industrial Clutch inspection checklist

Torque, Inc stocks Industrial Clutch parts and units from 8" to 35" that are OEM replacements for Niagara presses, Stripet, Amada, and many other machines.

springs generally replaced on every rebuild. Check push stud assy; replace as needed.

check unit wear by measuring stroke and comparing to wear chart max values. Replace worn driveplates or Torque, Inc can reline with factory material.

check splines on hub and friction drive plates for wear or stepping

check drive studs for wear and stepping.
Observe torque specs. for stud nuts when reassembling!

O-rings and dust seals generally replaced during rebuild

check cylinder for any wear or burrs where o-rings ride. Clean and lightly grease with Magna-Lube G grease to help filter air.

Check drive ring for cracks from over-torquing stud nuts

ID tag with 6 digit spec number located here.

check iron wear surfaces for wear or cracks. Wear over 1/32" per surface should be replaced.

Inspect bearings in rotary union and replace poppet if old, cracked or worn.

Note: ensure poppet has proper metering holes for your size unit.

Clutch designed with total attention given to maximizing ventilation for cool running operation. Benefits include: longer lining life; stable friction coefficients; and lower maintenance costs.

All materials selected and field proven to provide the best available resistance to wear and thermal distress.

Precision machining of all components ensures positive interchangeability of all mating parts.



| SIZE | "LK" OR "LKB" STUD NUT TORQUE | "LKB" BRAKE PISTON BOLT TORQUE |
|------|-------------------------------|--------------------------------|
| 8" | 25-30 FT.LBS. | 25-30 FT.LBS. |
| 10" | 30-35 FT.LBS. | N/A |
| 11" | 35-40 FT.LBS. | 20-25 FT.LBS. |
| 13" | 45-50 FT.LBS. | 85-90 FT.LBS. |
| 17" | 70-80 FT.LBS. | 50-55 FT.LBS. |
| 18" | 70-80 FT.LBS. | N/A |
| 21" | 90-100 FT.LBS. | 200-220 FT.LBS. |
| 25" | 110-120 FT.LBS. | 200-220 FT.LBS. |
| 30" | 190-200 FT.LBS. | 275-300 FT.LBS. |
| 35" | 220-230 FT.LBS. | 150-160 FT.LBS. |
| 42" | 275-300 FT.LBS. | 850-875 FT.LBS. |
| 48" | 275-300 FT.LBS. | 850-875 FT.LBS. |