

Air Clutch Assembly Procedure

Before the Air Clutch assembly begins, safety block the slide and relieve the air pressure.
Turn off and lock out the electrical and pneumatic power. Follow all safety rules and procedures.

It is assumed that the Flywheel is properly mounted on the shaft with all of the internal clutch parts removed. Refer to drawing 00-02530-A below which shows a section view of the Air Clutch Flywheel Assembly. Refer to the following steps for the Air Clutch Assembly.

Procedure:

STEP 1: Lubricate the Piston (Detail 7) with dry graphite spray. Carefully install the Piston with the lip seals in the position as shown in the drawing. Do not damage the lip seals.

STEP 2: Temporarily install the 12 Socket Head Cap Screws (Detail 11).
(Note – The 12 Screws are installed in a reverse position so that the parts can be aligned and held in their proper position. After all of the parts have been assembled, each Screw must be removed, one at a time, and installed in the permanent position shown in the drawing and in Step 11.)

STEP 3: Install the Clutch Spring Plate (Detail 19). (Note – The Clutch Cover (Detail 14) is located by Spiral Pins (Detail 15). The Clutch Spring Plate must be positioned with the holes in line with the counterbored Spring holes in the Clutch Cover.)

STEP 4: Install the 6 Drivers (Detail 24). (Note – The Drivers are placed on the Screws and aligned with the 6 slots in the Clutch Spring Plate.)
(Note-Some Clutches do not include Drivers and slots in the Clutch Spring Plate. Holes are provided for 6 Screws instead of slots for Drivers.)

STEP 5: Install the Friction Plate (Detail 9).

STEP 6: Install the Clutch Plate (Detail 8). (Note – The 6 slots in the Clutch Plate are aligned with the 6 Drivers.)
(Note-Some Clutches do not include Drivers and slots in the Clutch Plates. Holes are provided for 6 Screws instead of slots for Drivers.)

STEP 7: Install the remaining Friction Plates and Clutch Plates in an alternating position as shown in the drawing.
(Note-The quantity of Friction Plates and Clutch Plates may be different than shown.)

STEP 8: Install the 6 Springs (Detail 10).

STEP 9: Install the Clutch Cover (Detail 14). (Note – The 6 counterbored holes must be in line with the 6 Springs as described in Step 4.)

STEP 10: Temporarily install standard Nuts. Tighten the standard Nuts so that the Clutch Cover is seated against the Flywheel.

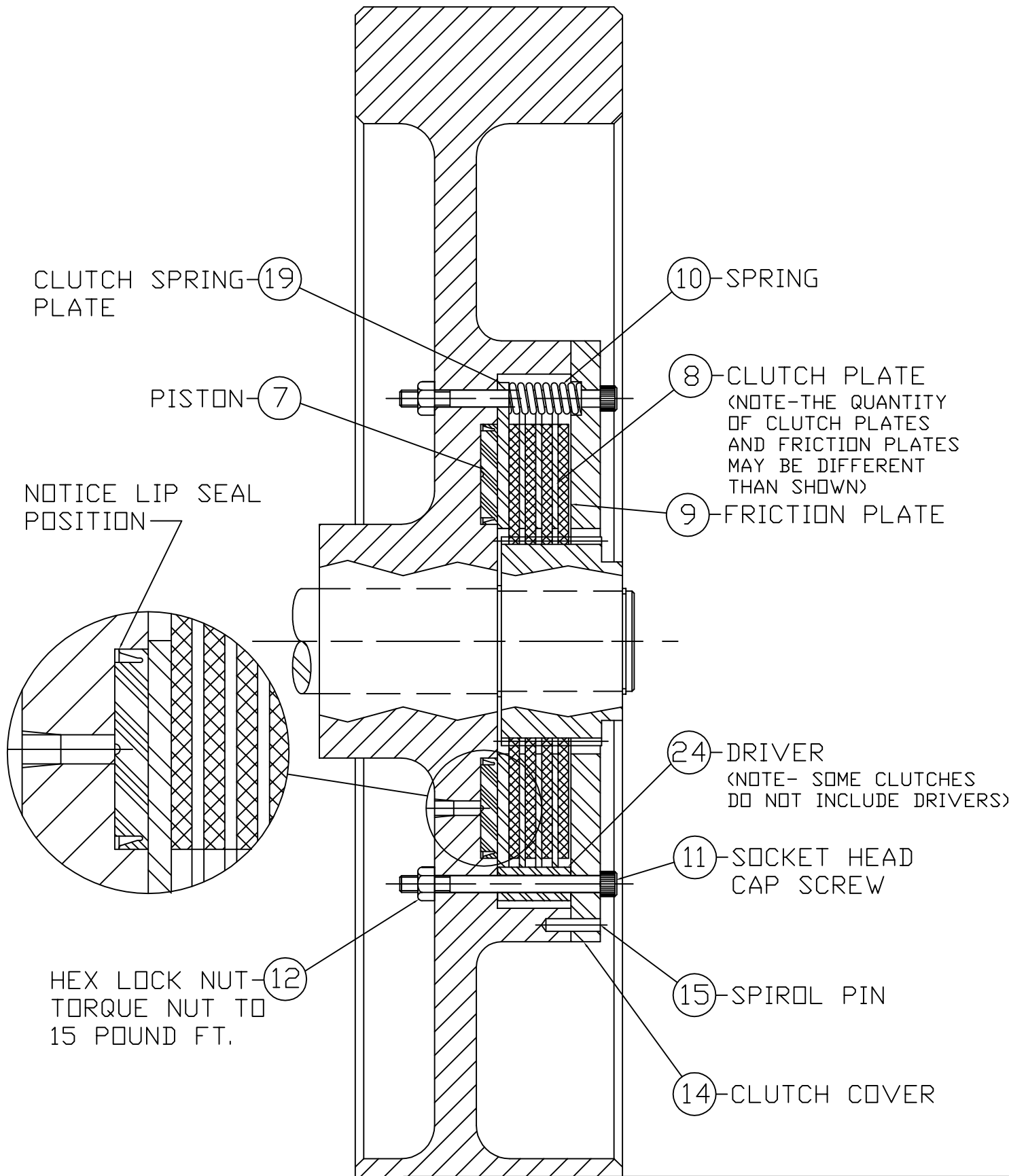
STEP 11: Remove each standard Nut and Screw, one at a time, and install the Screws in the permanent position as shown in the drawing.

STEP 12: Install the 12 permanent Hex Lock Nuts. Tighten each Lock Nut to 15 pound feet torque.

STEP 13: Manually rotate the Flywheel to check for free movement.

STEP 14: Connect the air lines to the air swivel.

STEP 15: Start-up and test. Remove the safety block from the slide. Turn on the electrical and pneumatic power. Set the Air Clutch and Counter Balance Cylinder at the proper air pressure. Operate the press in single stroke mode and observe the Air Clutch engagement and disengagement. Follow all safety rules and regulations.



SECTION VIEW OF AIR CLUTCH FLYWHEEL ASSEMBLY

REFER TO PRINTED AIR CLUTCH ASSEMBLY PROCEDURE

REF. DWG. 00-01450-00 & 00-02530-D

REVISION DESC. MODEL DESCRIPTION			
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ALL FINISHES 125 RMS UNLESS OTHERWISE SPECIFIED	FINISHED DIMENSION TOLERANCE DECIMAL +/- .005, FRACT. +/- .015, ANGLES +/- 0 DEG 30' UNLESS SPECIFIED. REMOVE BURRS BREAK SHARP CORNERS	DR: EB	4-21-11
OLD:	MATERIAL:	CKD:	
NEW:		APPR:	
The HEIM Group 6360 W. 73rd Street Chicago, Illinois 60638 708-496-7450 fax: 708-496-7428 porta fax 708-496-0708 http://www.theheimgroup.com		TITLE: AIR CLUTCH ASSEMBLY PROCEDURE	
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