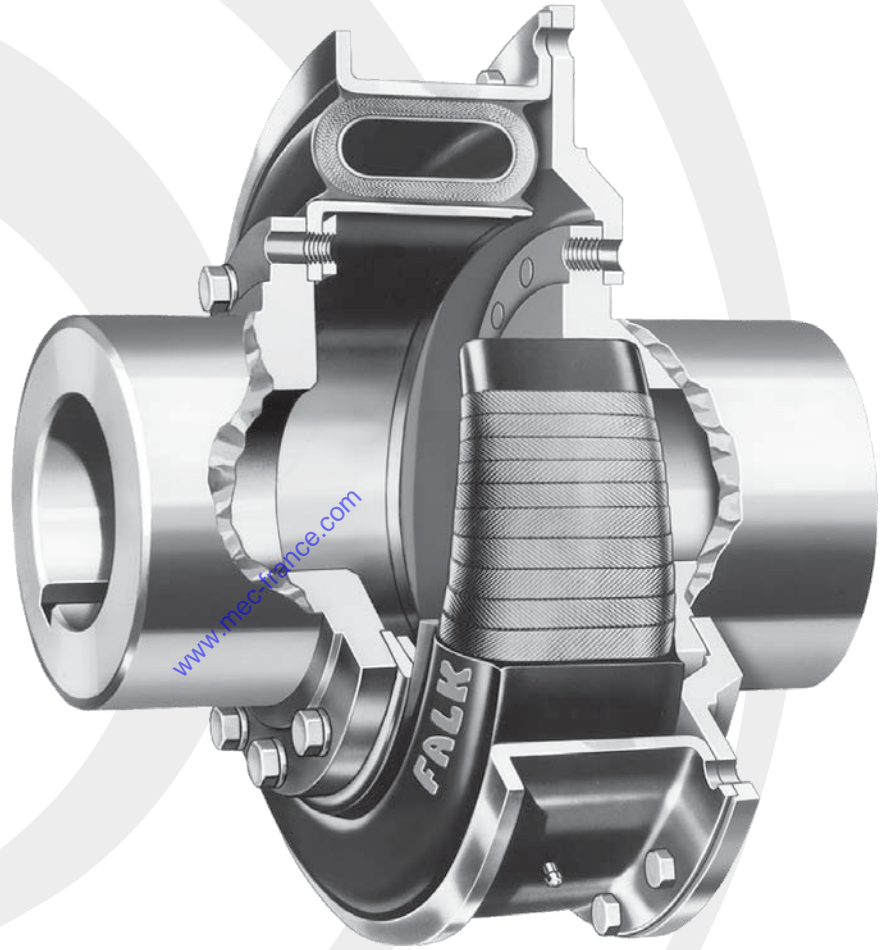
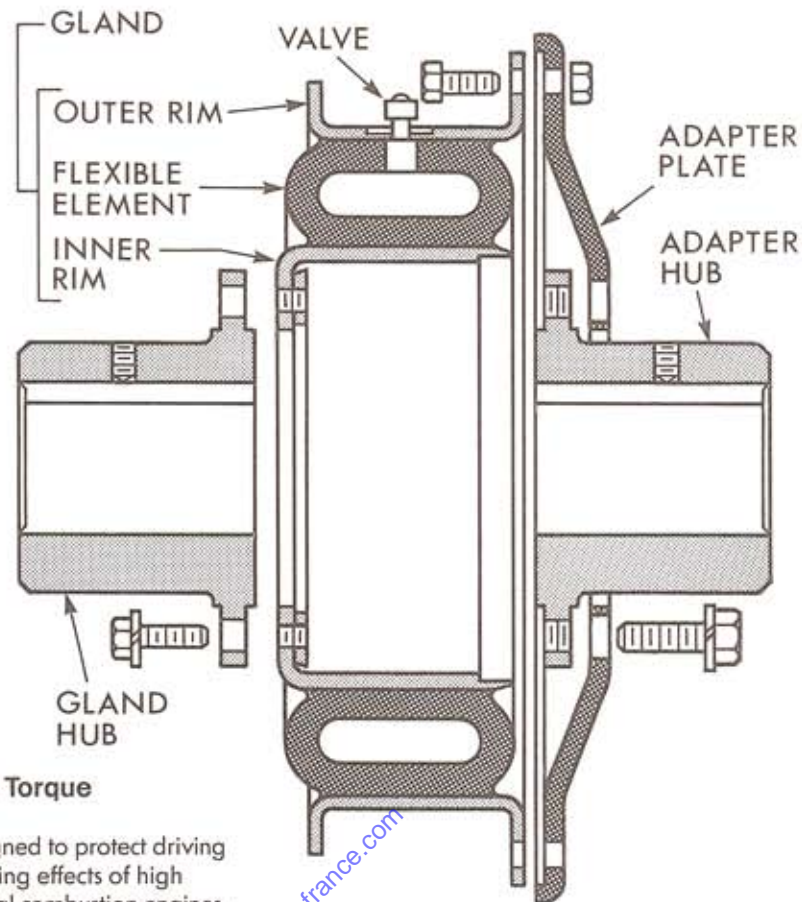


Couplings | Falk™ Airflex Gland Couplings
(English-Inch)



A-Airflex Couplings



Protects Equipment Against High Torque Fluctuations

The Falk Type A Airflex Coupling is designed to protect driving and driven machinery from the damaging effects of high torque fluctuations associated with internal combustion engines, reciprocating pumps and compressors, and other driven equipment of a similar fluctuating torque nature. The Airflex Coupling is especially suited to applications requiring flange or flywheel mounting and applications that require a low maintenance, non-lubricated coupling with high torque capacity.

Reliability

The reliability of the Falk Airflex Coupling design is proven by over 40 years of successful operations in the field. Today, Falk Airflex Couplings service both the marine and industrial fields . . . exceeding all expectations for dependability and positive, trouble free performance. Your machinery deserves the protection that the Falk Airflex Coupling provides.

Construction

The Falk Airflex Coupling gland consists of steel inner and outer rims bonded to a resilient corded natural rubber flexible element. The gland can be bolted directly to a flange on the connected equipment or to a shaft using the adapter hub and plate. Eleven combinations are available using standard components.

Airflex Gland The Airflex gland is a composition of rubber and polyester cord. The number of layers varies with coupling size; the larger the coupling, the greater the number of plies. The complete multi-ply sandwich is bonded to the inner and outer rims to form a unit which transmits torque and gives the best combination of strength and flexibility. This rubber-polyester bonded element is not affected by dust, dirt or ambient temperatures from -40°F (-40°C) to 150°F (66°C).

Hubs Both hubs are machined with precise registered fits. Hubs are made of steel for rugged service.

Gland Rims Both inner and outer rims are rugged steel, permanently bonded to the gland. The outer rim has an extended flange to allow bolting to a flywheel or adapter.

Adapter Plate The steel adapter plate is designed with an offset between the outer gland rim and coupling hub which allows removal of the gland, for the popular number 5 assembly, without disturbing the connected machines. It is fabricated with machined precise registered fits.

Fasteners Grade 5 or better fasteners are used throughout to provide maximum strength.

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6	Formula Selection Method
7	Minimum & Maximum Bores, Keys, WR^2
8 & 9	Hub & Flange Mountings and Dimensions
10	Flywheel Mounting and Dimensions
11	How to Order, Recommended Hub Bores

Benefits

Cushions Shock—Reduces Torque Fluctuations When coupling is properly selected, the resilience of the natural rubber, loaded in shear, cushions shock and reduces torque fluctuations.

Accommodates Misalignment Flexible rubber gland accommodates radial, angular and axial misalignment.

Dampens Vibration The natural hysteresis of the rubber in the gland helps dampen vibration.

Operates Quietly Airflex Couplings help prevent the transfer of noise from one machine to the next.

Installs Easily Pilot fits on all components ensure concentricity and easy alignment without special tools.

Never Needs Lubrication Due to the rubber gland design, no lubrication is ever required.

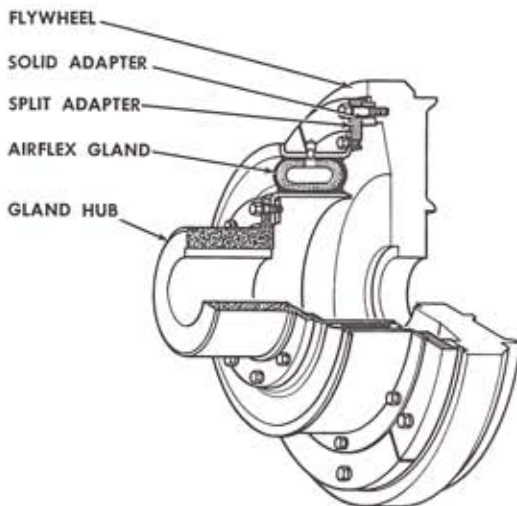
Versatile Design Eleven possible combinations ensure ready application to a wide variety of machine arrangements with no modification of the standard components. Also available, are flywheel mountings, floating shafts and tandem designs.

Other Falk Airflex Designs

Consult the Factory for complete details:

Airflex Flywheel Design This design simplifies mounting of an Airflex coupling to the flywheel of an industrial engine and permits coupling removal without disturbing driving or driven equipment.

The Airflex flywheel coupling consists of a solid and a split adapter ring fastened to the engine flywheel. The outer rim of the standard Airflex gland is fastened to the split adapter ring and the inner rim to the standard Airflex hub on the driven shaft.



Airflex Tandem Design If vibratory torque characteristics are too great, the Tandem or Double Airflex coupling can be furnished with twice the deflection and one-half the stiffness of a single Airflex.



Airflex Floating Shaft Design Floating shaft type coupling requirements are served by the combination of two standard Airflex glands and an intermediate floating shaft. This design takes advantage of the self-centering characteristics of the gland assembly. It allows for reasonable angular misalignment of the connecting shaft.



The Falk Corporation (the "Company") warrants that, for a period of one year from the date of shipment, the product to be manufactured and delivered hereunder will deliver successfully its rated output as indicated in this bulletin or on the nameplate, provided, it is properly installed and maintained, correctly lubricated and operated in the environment and within the limits of speed, torque or other load conditions for which it was sold. Such product is expressly not warranted against failure or unsatisfactory operation resulting from dynamic vibrations imposed upon it by the drive system in which it is installed unless the nature of such vibrations has been fully defined and expressly accepted in writing by the Company as a condition of operation. Unless otherwise provided herein, Company warrants title to the product manufactured and sold hereunder and that such product shall conform to Company's specifications. Subject to the preceding sentence and except as otherwise expressly stated herein, COMPANY MAKES NO REPRESENTATION OR WARRANTY OF ANY KIND, EXPRESS OR IMPLIED, AS TO MERCHANTABILITY, FITNESS FOR PARTICULAR PURPOSE OR ANY OTHER MATTER WITH RESPECT TO SAID PRODUCT. Company shall not be liable for and Purchaser assumes responsibility for, all personal injury and property damage resulting from the handling, possession or use of said product.

Install and operate Falk products in conformance with applicable local and national safety codes and per Falk installation manuals which are available upon request. Suitable guards for rotating members may be purchased from Falk as optional accessories. Consult your local Falk Representative for complete details.

WARNING: Lock out power source and remove all external loads from the system before attempting to service any component in the system. Locking out the power source and removing the load will reduce the possibility of an unexpected motion or reaction in the system.

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Bulletin 481-110 May 1992

Table 1 Airflex Coupling Service Factors for Motor and Turbine Drives
Service factors listed are typical values based on normal operation of the drive systems.

For repetitive high peak load applications, use the Formula Selection Method on Page 6, Step 2C.

Alphabetical listing of applications

	Service Factor
AERATOR	2.0
AGITATORS	
Vertical and Horizontal	
Screw, Propeller, Paddle	1.0
BARGE HAUL PULLER	1.5
BLOWERS	
Centrifugal	1.0
Lobe or Vane	1.25
CAR DUMPERS	2.5
CAR PULLERS	1.5
CLARIFIER OR CLASSIFIER	1.0
COMPRESSORS	
Centrifugal	1.0
Rotary, Lobe or Vane	1.25
Rotary, Screw	1.0
Reciprocating	
Direct Connected	Refer to Factory
Without Flywheels	Refer to Factory
*With Flywheel and Gear	
between Compressor and Prime Mover	
1 cylinder, single acting	3.0
1 cylinder, double acting	3.0
2 cylinders, single acting	3.0
2 cylinders, double acting	3.0
3 cylinders, single acting	3.0
3 cylinders, double acting	2.0
4 or more cyl., single act.	1.75
4 or more cyl., double act.	1.75
CONVEYORS	
Apron, Assembly, Belt, Chain, Flight, Screw	1.0
Bucket	1.25
Live Roll, Shaker and Reciprocating	3.0
CRANES AND HOIST	
Main Hoist	1.75▲
Skip Hoist	1.75▲
Slope	1.5
Bridge, Travel or Trolley	1.75
DYNAMOMETER	1.0
ELEVATORS	
Bucket, Centrifugal Discharge	1.25
Freight or Passenger	Not Approved
Gravity Discharge	1.25
ESCALATORS	Not Approved
EXCITER, GENERATOR	1.0
EXTRUDER, PLASTIC	1.5
FANS	
Centrifugal	1.0
Cooling Tower	2.0
Forced Draft—Across the Line start	1.5
Forced Draft Motor Driven thru fluid or electric slip clutch	1.0
Gas Recirculating	1.5
Induced Draft with damper control or blade cleaner	1.25
Induced Draft without controls	2.0
FEEDERS	
Apron, Belt, Disc, Screw	1.0
Reciprocating	2.5

- * For balanced opposed design, refer to Factory.
- ▲ If people are occasionally transported, refer to Factory for the selection of the proper size Steelflex or Gear coupling and availability of the dual path feature that will meet applicable safety codes. If the primary purpose of the application is material conveyance and occasionally people are transported, the Falk warranty may remain in effect provided the design load conditions are not exceeded and certification to the appropriate safety codes and load conditions has been obtained by the system designer or end user from the appropriate enforcement authorities.
- ★ For high peak load applications (such as Metal Rolling Mills) refer to the Formula Selection Method on Page 6, Step 2C.

Table 2 Engine Drive Service Factors

Service Factors for engine drives are those required for applications where good flywheel regulation prevents torque fluctuations greater than ±20%. For drives where torque fluctuations are greater or where the operation is near a serious critical or torsional vibration, a mass elastic study is necessary.

No. of Cylinders	4 or 5φ				6 or moreφ					
Table 1 Service Factor	1.0	1.25	1.5	1.75	2.0	1.0	1.25	1.5	1.75	2.0
Engine Service Factor	2.0	2.25	2.5	2.75	3.0	1.5	1.75	2.0	2.25	2.5

◆ To use Table 2, first determine application service factor from Table 1. Use that factor to determine ENGINE Service Factor from Table 2. When service factor from Table 1 is greater than 2.0 or where 1, 2 or 3 cylinder engines are involved, refer complete application details to the Factory for engineering review.

Alphabetical listing of industries

	Service Factor
AGGREGATE PROCESSING, CEMENT, MINING KILNS; TUBE, ROD AND BALL MILLS	
Direct or on L.S. shaft of Reducer, with final driver:	
Machined Spur Gears	2.0
Single Helical or Herringbone Gears	1.75
Conveyors, Feeders, Screens, Elevators	See General Listing
Crushers, Ore or Stone	2.5
Dryer, Rotary	1.75
Grizzly	2.0
Hammermill or Hog	1.75
Tumbling Mill or Barrel	1.75
BREWING AND DISTILLING	
Bottle and Can Filling Machines	1.0
Brew Kettle	1.0
Cookers, Continuous Duty	1.25
Lauter Tub	1.5
Mash Tub	1.25
Scale Hopper, Frequent Peaks	1.75
CLAY WORKING INDUSTRY	
Brick Press, Briquette Machine, Clay Working Machine, Pug Mill	1.75
DREDGES	
Cable Reel	1.75
Conveyors	1.25
Cutter Head, Jig Drive	2.0
Maneuvering Winch	1.5
Pumps (uniform load)	1.5
Screen Drive, Stacker	1.75
Utility Winch	1.5
FOOD INDUSTRY	
Beet Slicer	1.75
Bottling, Can Filling Machine	1.0
Cereal Cooker	1.25
Dough Mixer, Meat Grinder	1.75
LUMBER	
Band Resaw	1.5
Circular Resaw, Cut-off	1.75
Edger, Head Rig, Hog	2.0
Gang Saw (Reciprocating)	Refer to Factory
Log Haul	2.0
Planer	1.75
Rolls, Non-Reversing	1.25
Rolls, Reversing	2.0
Sawdust Conveyor	1.25
Slab Conveyor	1.75
Sorting Table	1.5
Trimmer	1.75
*METAL ROLLING MILLS	
Coilers (Up or Down) Cold Mills only	1.5
Coilers (Up or Down) Hot Mills only	2.0
Coke Plants	
Pusher Ram Drive	2.5
Door Opener	2.0
Pusher or Lorry Car Traction Drive	3.0
Cold Mills—	
Strip Mills	Refer to Factory
Temper Mills	Refer to Factory
Cooling Beds	1.5
Drawbench	2.0
Feed Rolls—Blooming Mills	3.0
Furnace Pushers	2.0
Hot and Cold Saws	2.0
Hot Mills—	
Strip or Sheet Mills	Refer to Factory
Reversing Blooming or Slabbing Mills	Refer to Factory
Edger Drives	
Ingot Cars	2.0
Manipulators	3.0
Merchant Mills	Refer to Factory
Mill Tables	
Roughing Breakdown Mills	3.0
Hot Bed or Transfer, non-reversing	1.5
Runout, reversing	3.0
Runout, non-reversing, non-plugging	2.0
Reel Drives	1.75
Rod Mills	Refer to Factory
Screwdown	2.0
Seamless Tube Mills	
Piercer	3.0
Thrust Block	2.0
Tube Conveyor Rolls	2.0
Reeler	2.0
Kick Out	2.0
Sideguards	3.0
Skelp Mills	Refer to Factory
Slitters, Steel Mill only	1.75
Soaking Pit Cover Drives—	
Lift	1.0
Travel	2.0
Straighteners	2.0
Unscramblers (Billet Bundle Busters)	2.0
Wire Drawing Machinery	1.75
OIL INDUSTRY	
Chiller	1.25
Oilwell Pumping (not over 150% peak torque)	2.0
Paraffin Filter Press	1.5
Rotary Kilm	2.0
PAPER MILLS	
Barker Auxiliary, Hydraulic	2.0
Barker, Mechanical	2.0
Barking Drum	
L.S. shaft of reducer with final drive—Helical or Herringbone Gear	2.0
Machined Spur Gear	2.5
Cast Tooth Spur Gear	3.0
Beater & Pulper	1.75
Bleachers, Coaters	1.0
Calendar & Super Calendar	1.75
Chipper	2.5
Converting Machine	1.25
Couch	1.75
Cutter, Felt Whipper	2.0
Cylinder, Dryer	1.75
Felt Stretcher	1.25
Fourdriner	1.75
Jordan	2.0
Log Haul	2.0
Line Shaft	1.5
Press	1.75
Pulp Grinder	1.75
Reel, Rewinder, Winder	1.5
Stock Chest, Washer, Thickener	1.5
Stock Pumps, Centrifugal	
Constant Speed	1.0
Frequent Speed Changes Under Load	1.25
Suction Roll	1.75
RUBBER INDUSTRY	
Calendar	2.0
Cracker, Plasticator	2.5
Extruder	1.75
Intensive or Banbury Mixer	2.5
Mixing Mill, Refiner or Sheeter	
One or two in line	2.5
Three or four in line	2.0
Five or more in line	1.75
Tire Building Machine	2.5
Tire & Tube Press Opener (Peak Torque)	1.0
Tube, Strainer, Pelletizer	1.75
Warming Mill	
One or two Mills in line	2.0
Three or more Mills in line	1.75
Washer	2.5
SEWAGE DISPOSAL EQUIPMENT	
Bar Screen, Chemical Feeders, Collectors, Dewatering Screen, Grit Collector	1.0
SUGAR INDUSTRY	
Cane Carrier & Leveler	1.75
Cane Knife & Crusher	2.0
Mill Stands, Turbine Driven with all helical or herringbone gears	1.5
Electric Drive or Steam Engine Drive with Helical, Herringbone, or Spur Gears with any Prime Mover	1.75
TEXTILE INDUSTRY	
Botcher	1.25
Calendar, Card Machine	1.5
Cloth Finishing Machine	1.5
Dry Can, Loom	1.5
Dyeing Machinery	1.25
Knitting Machine	Refer to Factory
Mangle, Napper, Sooper	1.25
Spinner, Tenter Frame, Winder	1.5

Quick Selection Method

- Determine Service Factor
 - For MOTOR, TURBINE or ENGINE driven applications, refer to Tables 1 and 2.
 - For BRAKE or HIGH PEAK LOAD applications, refer to the Formula Selection Method shown on Page 6.
- Determine Equivalent Horsepower

Refer to Table 3—Under the actual motor hp required and opposite the service factor determined in Step 1, read the equivalent hp.
- Determine Coupling Size and Mounting
 - Refer to Table 4—Trace horizontally from the required speed to a hp value equal to or larger than the hp determined in Step 2. Read the coupling size at top of column.
 - Refer to Pages 8 and 9—Select the mounting that best suits the application. For connecting shaft to engine with a standard SAE J620 flywheel, refer to Page 10. If the size of the Airflex coupling determined in Step 3A is smaller or equal to the coupling size shown on Page 10 for your particular flywheel, use the Airflex size shown on Page 10. If the size of the Airflex coupling determined in Step 3A is larger than that shown on Page 10, refer application to the Factory.
 - Check shaft diameters against coupling maximum bores shown in Table 6. If a larger bore is required, select a larger coupling.

- Check the required speed against the allowable speed shown in Table 5. Note that in Table 5, speeds are listed for standard and balanced couplings.
- Check application dimension requirements against selected coupling type dimensions shown on Pages 8 thru 10.

Example:

Select a coupling to connect a 450 hp, 8 cylinder engine, operating at 1000 rpm, to a centrifugal compressor. Engine shaft is 3.500" diameter and compressor shaft diameter is 3.000".

- Determine Service Factor—From Table 1, the service factor is 1.0 for a centrifugal compressor. Refer to Table 2 for Engine Drive Service Factors, and find that a service factor of 1.0 with an engine drive of 6 or more cylinders shows a new service factor of 1.5.
- Determine Equivalent HP—From Table 3, the equivalent hp is 675 (1.5 x 450 hp).
- Determine Coupling Size and Mounting—(A) From Table 4, coupling size is 28A. (B) From Pages 8 and 9, select (optional) mounting 5. (C) From Table 6, the maximum bore with square key is 5.500". (D) From Table 5, the allowable speed without balancing is 1500 rpm. (E) Dimensions for the 28A coupling shown on Pages 8 thru 10 satisfy the application requirements.

Table 3 Equivalent Horsepower = (Actual hp x Service Factor)

Service Factor ±	Actual hp																									
	¾	1	1½	2	3	5	7½	10	15	20	25	30	40	50	60	75	100	125	150	200	250	300	350	400	450	500
1.0	.75	1.0	1.5	2.0	3.0	5.0	7.5	10	15	20	25	30	40	50	60	75	100	125	150	200	250	300	350	400	450	500
1.25	.94	1.25	1.9	2.5	3.8	6.3	9.4	12.5	19	25	31	38	50	63	75	94	125	156	188	250	312	375	438	500	563	625
1.5	1.1	1.5	2.3	3.0	4.5	7.5	11.3	15	23	30	38	45	60	75	90	113	150	188	225	300	375	450	525	600	675	750
1.75	1.3	1.8	2.6	3.5	5.3	8.8	13.1	18	26	35	44	53	70	88	105	131	175	219	262	350	438	525	613	700	787	875
2.0	1.5	2.0	3.0	4.0	6.0	10.0	15.0	20	30	40	50	60	80	100	120	150	200	250	300	400	500	600	700	800	900	1000
2.5	1.9	2.5	3.8	5.0	7.5	12.5	18.8	25	38	50	63	75	100	125	150	187	250	312	375	500	625	750	875	1000	1125	1250
3.0	2.3	3.0	4.5	6.0	9.0	15.0	22.5	30	45	60	75	90	120	150	180	225	300	375	450	600	750	900	1050	1200	1350	1500
3.5	2.6	3.5	5.3	7.0	10.5	17.5	26.2	35	52	70	87	105	140	175	210	262	350	437	525	700	875	1050	1225	1400	1575	1750

‡For service factor not listed, Equivalent hp = Actual hp x Service Factor.

Table 4 Coupling Selection ★ . . . Based on Equivalent hp Ratings

Speed RPM*	Coupling Size												
	15A	16A	18A	21A	24A	28A	33A	39A	46A	53A	62A	72A	85A
1750	253	347	500	708	1055	2000	3055	5276					
1450	209	288	414	587	874	1656	2531	4371	7362				
1170	169	232	334	473	705	1337	2042	3527	5940	9282			
1000	144	198	286	405	603	1142	1745	3015	5077	7933	12060		
870	126	173	248	352	525	994	1518	2624	4417	6902	10500		
720	104	143	206	291	434	823	1257	2171	3656	5712	8682	13940	21705
650	93.9	129	186	263	392	743	1134	1960	3300	5157	7838	12580	15600
580	83.7	115	166	235	350	663	1012	1750	2945	4601	6994	11225	17490
520	75.1	103	149	210	314	594	908	1568	2640	4125	6271	10065	15675
420	60.6	83.3	120	170	253	480	733	1266	2132	3332	5065	8130	12660
350	50.5	69.4	100	142	211	400	611	1055	1777	2777	4221	6775	10550
280	40.4	55.5	80	113	169	320	489	844	1422	2221	3376	5420	8441
230	33.2	45.6	65.7	93.1	139	263	401	693	1168	1825	2774	4452	6934
190	27.4	37.7	54.3	76.9	115	217	332	573	965	1507	2291	3678	5728
155	22.4	30.7	44.3	62.7	93.5	177	271	467	787	1230	1869	3000	4673
125	18.0	24.8	35.7	50.6	75.4	143	218	377	635	992	1507	2420	3768
100	14.4	19.8	28.6	40.5	60.3	114	175	301	508	793	1206	1936	3015
84	12.1	16.7	24.0	34.0	50.6	96	147	253	426	666	1013	1626	2532
68	9.8	13.5	19.4	27.5	41.0	77.7	119	205	345	539	820	1316	2050
56	8.1	11.1	16.0	22.7	33.8	64.0	97.7	169	284	444	675	1084	1688
45	6.5	8.9	12.9	18.2	27.1	51.4	78.5	136	228	357	543	871	1357
37	5.3	7.3	10.6	15.0	22.3	42.3	64.6	112	188	294	446	716	1115
30	4.3	6.0	8.6	12.1	18.1	34.3	52.4	90.4	152	238	362	581	904
25	3.6	5.0	7.1	10.1	15.1	28.6	43.6	75.4	127	198	301	484	754
20	2.9	4.0	5.7	8.1	12.1	22.8	34.9	60.3	102	159	241	387	603
16.5	2.4	3.3	4.7	6.7	9.9	18.8	28.8	49.7	83.8	131	199	319	497
13.5	1.9	2.7	3.9	5.5	8.1	15.4	23.6	40.7	68.5	107	163	261	407
11.0	1.6	2.2	3.1	4.5	6.6	12.6	19.2	33.2	56.0	87.3	133	213	332
9.0	1.3	1.8	2.6	3.6	5.4	10.3	15.7	27.1	45.7	71.4	109	174	271
7.5	1.1	1.5	2.1	3.0	4.5	8.6	13.1	22.6	38.1	59.5	90	145	226

Selections shown in bold face type indicate that a balanced coupling is required.

* Refer to Falk Representative for selection of special purpose couplings.

* If required speed is not shown, use next lower listed or interpolate between those listed.

If required speed is over 1750 rpm, or under 7.5 rpm, refer to FORMULA method of selection on Page 6.

Those who have occasion to make numerous selections should contact the local Falk Representative for a Falk Coupling Selector.

Formula Selection Method

1. Determine Service Factor or System Peak HP

- A. For MOTOR, TURBINE or ENGINE driven applications, refer to Tables 1 and 2.
- B. For BRAKE and HIGH PEAK LOAD applications, refer to Step 2 below.

2. Calculate Required Rating

The coupling hp per 100 rpm rating or torque rating must equal or exceed the application requirements. Determine the required coupling rating using the formula in Step 2A and the applicable formula from Steps 2B and 2C. Use the highest calculated rating to determine the coupling size in Step 3.

A. NORMAL SERVICE:

$$\text{HP per 100 RPM} = \frac{\text{Transmitted HP} \times 100 \times \text{SF}}{\text{RPM}}$$

Transmitted hp equals the measured hp or if not available, the motor or turbine rated hp with the exceptions noted below.

- B. BRAKE APPLICATIONS: Use the brake hp in the above formula if it exceeds the prime mover hp rating.
- C. REPETITIVE HIGH PEAK LOAD APPLICATIONS: Use one of the following applicable formulas for applications using motors with torque characteristics that are higher than normal, applications with intermittent operation, shock loading, inertia effects due to starting and stopping and/or system induced repetitive high peak torques. The "System Peak Torque" is the maximum that can exist in the system.
- a. For NON REVERSING SERVICE:
Req'd Coupling Torque Rating = System Peak Torque
- b. For REVERSING SERVICE:
Req'd Coupling Torque Rating = 2.0 x System Peak Torque

3. Determine Coupling Size and Mounting

- A. Refer to Table 5—Trace down the HP per 100 RPM column or the Torque Rating column to a figure equal to or in excess of the highest calculated value in Step 2. Read coupling size at left.
- B. Refer to Pages 8 and 9—Select the mounting that best suits the application. For connecting shaft to engine with a standard SAE J620 flywheel, refer to Page 10. If the size of the Airflex coupling determined in Step 3A is smaller or equal to the coupling size shown on Page 10 for your particular flywheel, use the Airflex size shown on Page 10. If the size of the Airflex coupling determined in Step 3A is larger than that shown on Page 10, refer application to the Factory.
- C. Check shaft diameters against coupling maximum bores shown in Table 6. If a larger bore is required, select a larger coupling.
- D. Check the required speed against the allowable speed shown in Table 5. Note that in Table 5, speeds are listed for standard and balanced couplings.
- E. Check application dimension requirements against selected coupling type dimensions shown on Pages 8 thru 10.

EXAMPLE: Normal Load Method

Select a coupling to connect a 700 hp, 12 cylinder engine, operating at 1100 rpm, to a dynamometer. The dynamometer shaft diameter is 4.000". Coupling flange will be bolted to engine flywheel per Mounting 3 shown on Pages 8 and 9.

1. Determine Service Factor—From Table 1, the service factor is 1.0 for a dynamometer. Refer to Table 2 for Engine Drive Service Factors, and find that a service factor of 1.0 with an engine drive of 6 or more cylinders shows a new service factor of 1.5.

2. Calculate Required Rating—Use the Normal Service Formula from Step 2A.

$$\text{HP per 100 RPM} = \frac{\text{Transmitted HP} \times 100 \times \text{SF}}{\text{RPM}}$$

$$\text{HP per 100 RPM} = \frac{700 \times 100 \times 1.5}{1100} = 95.45$$

3. Select Coupling Size—(A) From Table 5, the coupling size is 28A with a rating of 114 hp per 100 rpm. (B) From Table 6, the maximum bore with square key is 5.500". (C) From Table 5, the allowable speed without balancing is 1500 rpm. (D) Dimensions for the 28A coupling shown on Pages 8 thru 10 satisfy the application requirements.

EXAMPLE: Peak Load Method

Select a coupling for reversing service to connect a gear reducer low speed shaft to a runout mill table roll. The electric motor rating is 50 hp at the base speed and the system peak torque at the coupling is estimated to be 150,000 lb-in. Coupling speed is 77 rpm at the motor base speed. The reducer shaft diameter is 4.000" with a 1.000" x .500" keyway. The runout table roll shaft diameter is 5.250" with a 1.250" x .625" keyway.

1. Determine Service Factor—From Table 1, the service factor is 3.0.
2. Calculate Required Rating
- a. NORMAL SERVICE FORMULA (Step 2A)
- $$\text{HP per 100 RPM} = \frac{\text{Transmitted HP} \times 100 \times \text{SF}}{\text{RPM}}$$
- $$\text{HP per 100 RPM} = \frac{50 \times 100 \times 3.0}{77} = 195$$
- b. REVERSING SERVICE FORMULA (Step 2Cb)
- Req'd Coupling Torque Rating = 2.0 x System Peak Torque
or 2.0 x 150,000 lb-in.
or 300,000 lb-in.
3. Determine Coupling Size—(A) From Table 5, the coupling size is 39A using the Normal Service Formula and 46A using the Reversing Service Formula. Select the larger size (46A) coupling. (B) From Table 6, the maximum bore with square key is 8.500". (C) From Table 5, the allowable speed without balancing is 900 rpm. (D) Dimensions for the 46A coupling shown on Pages 8 thru 10 satisfy the application requirements.

Table 5 Coupling Ratings, Allowable Speeds and Torsional Stiffness

Coupling Size	HP per 100 RPM	Torque Rating (lb-in.)	Allowable Speeds -RPM		Torsional Stiffness* (lb-in./Rad) x 10 ⁶		
			Standard	With Balancing	Single Gland	Tandem Gland	Triple Gland
15A	14.4	9,100	1800	3600	.170	.085	.057
16A	19.8	12,500	1800	3000	.220	.110	.073
18A	28.6	18,000	1800	3000	.290	.145	.097
21A	40.5	25,500	1800	2400	.410	.205	.137
24A	60.3	38,000	1800	2400	.60	.30	.20
28A	114	72,000	1500	2200	1.30	.65	.43
33A	175	110,000	1200	2000	2.10	1.05	.70
39A	301	190,000	1000	1750	3.0	1.5	1.0
46A	508	320,000	900	1500	6.0	3.0	2.0
53A	793	500,000	750	1250	11.0	5.5	3.7
62A	1,205	760,000	650	1000	21.0	10.5	7.0
72A	1,935	1,220,000	500	850	37.0	18.5	12.3
85A	3,015	1,900,000	450	750	70.0	35.0	23.3

* Constant value at zero PSI (gauge) gland pressure. Tolerance is ± 35%.

Dimensions Inches

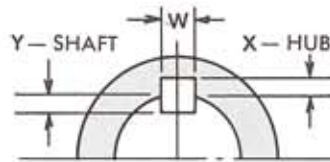


Table 6 Airflex Coupling Bore Ranges with Square and Rectangular Keys†

Coupling Size	Min Bore †	For One Square Key				For One Rectangular Key					
		Max Bore	Y = X		Max Bore	Y = X		Max Bore	Y = W/2Δ		
			W	X		W	X		W	X	
15A	1.000	2.500	.625	.312	2.687	.625	.218	2.875	.750	.125	
16A	1.250	2.625	.625	.312	2.750	.625	.218	2.875	.750	.125	
18A	1.500	3.000	.750	.375	3.250	.750	.250	3.375	.875	.187	
21A	1.875	3.500	.875	.437	3.750	.875	.312	3.875	1.000	.250	
24A	1.875	4.500	1.000	.500	4.625	1.250	.437	5.000	1.250	.250	
28A	2.125	5.500	1.250	.625	5.875	1.500	.500	6.125	1.500	.250	
33A	2.875	6.250	1.500	.750	6.500	1.500	.500	6.625	1.750	.625	
39A	2.625	7.500	1.750	.875	7.750	2.000	.750				
46A	3.750	8.500	2.000	1.000	9.000	2.000	.750				
53A	4.500	9.250	2.500	1.250	9.500	2.500	.875				
62A	5.000	10.750	2.500	1.250	11.000	2.500	.875				
72A	6.000	11.750	3.000	1.500	12.000	3.000	1.000				
85A	7.000	13.000	3.000	1.500	13.250	3.500	1.250				

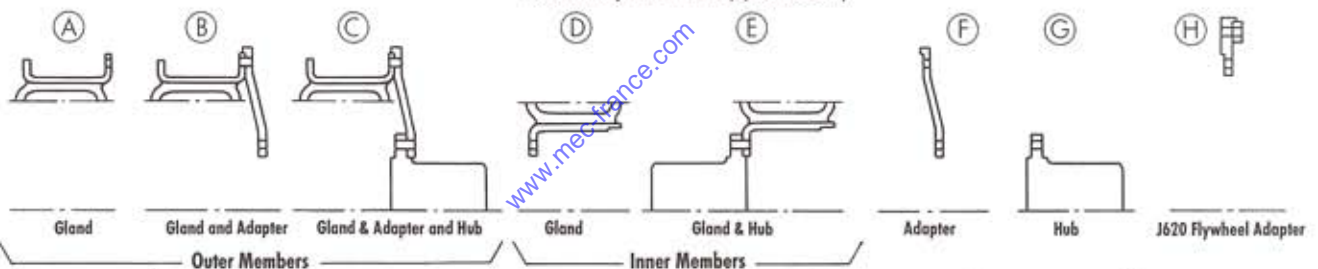
□ Shaded areas indicate maximum bores using standard recommended keys shown in Table 7.
 † Unless otherwise specified, Sizes 15A thru 18A will be furnished for CLEARANCE FIT with a set screw OVER the keyway, and Sizes 21A and larger will be furnished for INTERFERENCE FIT without a set screw.
 † Minimum bore is the smallest bore to which a RSB (rough stock bore) hub can be bored. Rough stock bore hubs have a small through hole that will permit remachining of the hubs to the minimum bores specified. RSB hubs are not drilled and tapped for set screws.
 Δ Shaft keyway depth Y equals one-half of square key W. CHECK KEY STRESSES.

Table 7 Recommended Keys for Bores with One Key

Shaft Diameters		Key
Over	Thru	
875	1.250	.250x .250
1.250	1.375	.312x .312
1.375	1.750	.375x .375
1.750	2.250	.500x .500
2.250	2.750	.625x .625
2.750	3.250	.750x .750
3.250	3.750	.875x .875
3.750	4.500	1.000x1.000
4.500	5.500	1.250x1.250
5.500	6.500	1.500x1.500
6.500	7.500	1.750x1.500
7.500	9.000	2.000x1.500
9.000	11.000	2.500x1.750
11.000	13.000	3.000x2.000
13.000	15.000	3.500x2.500
15.000	18.000	4.000x3.000
18.000	22.000	5.000x3.500
22.000	26.000	6.000x4.000

It is general practice in industry to supply coupling hubs without fillet radii in the keyway corners to permit the use of standard commercial keys without chamfered edges. Falk will cut fillet keyways per the established standards shown in Engineering 427-109. Keyway tolerances: Refer to Engineering 427-108.

Table 8 Coupling Component WR²—lb-in² (For coupling WR² add portions of coupling assembly that fit application)



Coupling Size	Outer Members			Inner Members			F	G*	H
	MTG. 1,3,4 A	MTG. 2,12,13 B	MTG. 5,6,9,10,11 C*	MTG. 1,2,10,11 D	MTG. 3,4,5,6,9,12,13 E*				
15A	202	427	449	49	71	225	22	...	
16A	273	555	586	88	119	282	31	552 (11.5")	
18A	499	911	966	122	177	412	55	...	
21A	720	1,498	1,618	216	336	778	120	2,180 (14")	
24A	1,035	1,952	2,195	386	629	917	243	3,125 (16")	
28A	1,904	2,850	3,615	889	1,654	946	765	4,545 (18")	
33A	3,690	10,063	11,571	1,647	3,155	6,373	1,508	10,330 (21")	
39A	7,248	15,195	18,512	3,779	7,096	7,947	3,317	15,715 (24")	
46A	17,112	30,560	36,684	7,062	13,186	13,448	6,124	...	
53A	45,300	79,225	92,975	15,417	29,167	33,925	13,750	...	
62A	93,425	189,325	215,145	31,325	57,145	95,900	25,820	...	
72A	175,235	355,835	406,235	76,740	127,140	180,600	50,400	...	
85A	328,450	613,450	715,950	141,900	244,400	285,000	102,500	...	

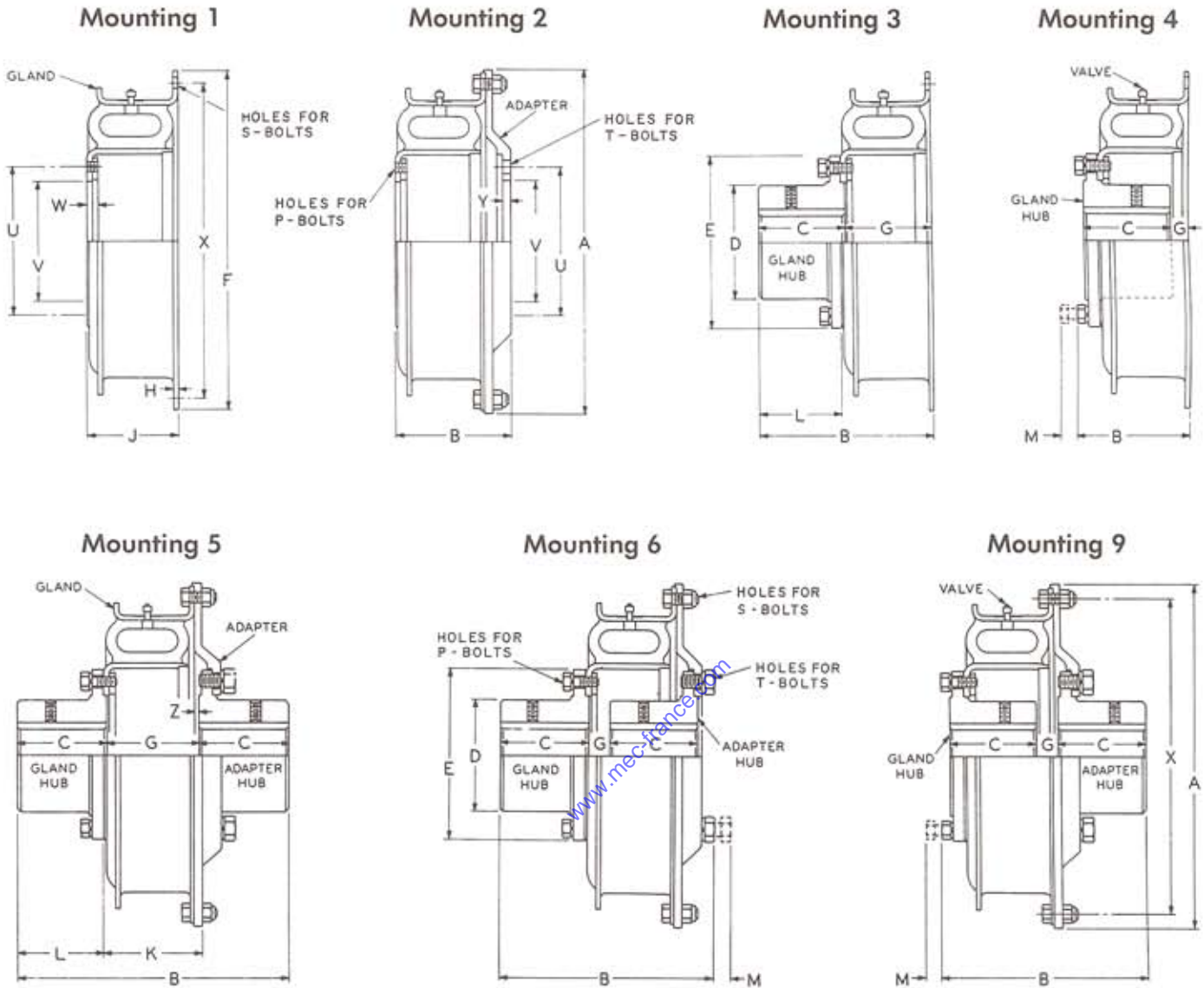
* Hub WR² values are with no bore.

Table 9 Shaft Diameters and Ratings for NEMA 60 Hertz Motors

Frame Size	T Frames																TS Frames												
	143	145	182	184	213	215	254	256	284	286	324	326	364	365	404	405	444	445	284	286	324	326	364	365	404	405	444	445	
Shaft Dia—Inches	.88	.88	1.13	1.13	1.38	1.38	1.63	1.63	1.88	1.88	2.13	2.13	2.38	2.38	2.88	2.88	3.38	3.38	1.63	1.63	1.88	1.88	1.88	1.88	2.13	2.13	2.38	2.38	
3600 RPM	Drip Proof	1½	2-3	5	7½	10	15	20	25	30	40	50	60	75	100	125	150	200	250	30	40	50	60	75	100	125	150	200	250
	Enclosed	1½	2	3	5	7½	10	15	20	25	30	40	50	60	75	...	100	125	150	25	30	40	50	60	75	...	100	125	150
1800 RPM	Drip Proof	1	1½-2	3	5	7½	10	15	20	25	30	40	50	60	75	100	125	150	200	25	30	40	50	60	75	100	125	150	200
	Enclosed	1	1½-2	3	5	7½	10	15	20	25	30	40	50	60	75	...	100	125	150	25	30	40	50	60	75	...	100	125	150
1200 RPM	Drip Proof & Enclosed	¾	1	1½	2	3	5	7½	10	15	20	25	30	40	50	60	75	100	125	15	20	25	30	40	50	60	75	100	125
900 RPM	Drip Proof & Enclosed	½	¾	1	1½	2	3	5	7½	10	15	20	25	30	40	50	60	75	100	10	15	20	25	30	40	50	60	75	100

Mountings and Dimensions

For Flywheel Mounting and Dimensions, Refer to Page 10



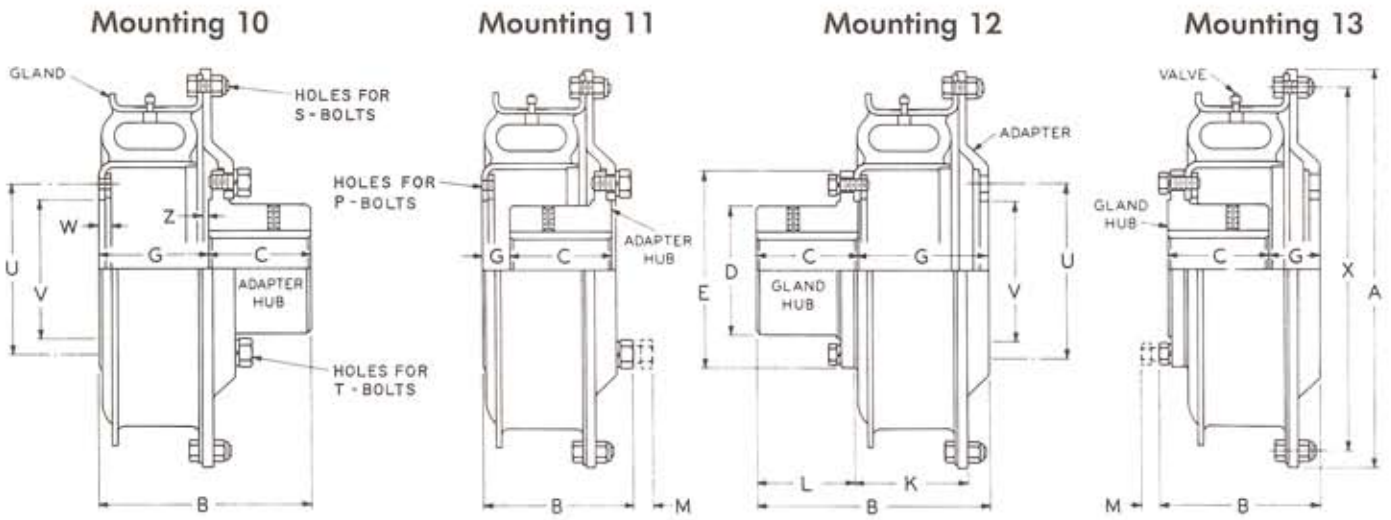
Refer to Pages 6 & 7 for Ratings, Speeds and Bores

DIMENSIONS—INCHES

(Cont'd. on next page)

SIZE ★	A	B										C	D	E	FA	G					
		Mtg. 2	Mtg. 3	Mtg. 4	Mtg. 5	Mtg. 6	Mtg. 9	Mtg. 10	Mtg. 11	Mtg. 12	Mtg. 13					Mtg. 3	Mtg. 4	Mtg. 5	Mtg. 6	Mtg. 9	Mtg. 10
15A	11.62	4.34	6.56	4.19	9.97	7.94	7.56	6.84	4.78	7.47	5.05	3.25	3.50	5.56	11.375	3.31	.69	3.47	.84	.84	3.59
16A	12.62	4.59	7.06	4.44	10.72	8.44	8.06	7.34	5.03	7.97	5.30	3.50	3.75	6.00	12.375	3.56	.69	3.72	.84	.84	3.84
18A	14.25	4.84	7.56	4.69	11.47	8.94	8.56	7.84	5.28	8.47	5.55	3.75	4.38	6.62	13.937	3.81	.69	3.97	.84	.84	4.09
21A	15.69	5.22	7.94	5.00	12.09	9.69	9.19	8.22	5.77	9.09	6.16	4.00	5.12	7.88	15.375	3.94	.69	4.09	.84	.84	4.22
24A	17.38	5.72	8.94	5.50	13.59	10.69	10.19	9.22	6.27	10.09	6.66	4.50	6.25	9.25	17.062	4.44	.69	4.59	.84	.84	4.72
28A	19.62	6.22	10.00	6.06	15.41	12.00	11.50	10.28	6.88	11.34	7.39	5.25	7.88	11.25	19.312	4.75	.38	4.91	.53	.53	5.03
33A	22.94	6.91	11.38	6.69	17.53	13.44	12.88	11.66	7.56	12.78	8.08	6.00	9.00	13.25	22.625	5.38	.25	5.53	.41	.41	5.66
39A	26.50	8.16	13.88	7.94	20.53	15.81	15.06	13.66	8.92	15.03	9.56	7.00	10.50	15.50	26.187	6.38	.38	6.53	.53	.53	6.66
46A	30.50	8.91	14.88	8.69	22.78	17.31	16.56	15.16	9.67	16.53	10.31	7.75	12.00	18.50	30.187	7.12	.38	7.28	.53	.53	7.41
53A	34.88	10.75	17.31	10.38	26.56	20.56	19.62	17.75	11.72	19.56	12.61	9.00	13.75	21.00	34.500	8.31	.69	8.56	.94	.94	8.75
62A	40.75	12.06	19.56	11.62	29.81	22.88	21.88	20.00	13.03	21.88	13.92	10.00	15.50	24.75	40.375	9.56	.94	9.81	1.19	1.19	10.00
72A	46.75	13.69	21.75	13.38	33.06	25.62	24.69	22.31	14.88	24.44	16.03	11.00	17.50	28.50	46.250	10.75	1.50	11.06	1.81	1.81	11.31
85A	54.25	14.69	23.75	14.38	36.06	27.62	26.69	24.31	15.88	26.44	17.03	12.00	19.00	35.38	53.750	11.75	1.50	12.06	1.81	1.81	12.31

★ Dimensions are for reference and subject to change without notice unless certified. All glands are designed to operate at zero psi (gauge) pressure; valves in the glands are required only for manufacturing purposes. Hub Sizes 15 thru 18A will be furnished for a CLEARANCE FIT with a set screw over keyway and Hub Sizes 21 thru 85A will be furnished for an INTERFERENCE FIT without set screw.



FASTENERS & APPROXIMATE WEIGHTS

SIZE	Fasteners±						Approximate Weight—lbs						
	P Inner Rim to Gland Hub		S Outer Rim to Adapter		T Adapter to Adapter Hub		Hub (No Bore)	Adaptor Plate	Gland	Gland and Adaptor Plate	Gland and One Hub	Gland, Two Hubs and One Adaptor	Gland, One Hub and One Adaptor
	No.	Size	No.	Size	No.	Size			Mounting 1	Mounting 2	Mountings 3, 4	Mountings 5, 6, 9	Mountings 10, 11, 12, 13
15A	8	.375-24x1.00	6	.375-24x1.00	8	.500-20x1.00	11	13	13	26	24	48	37
16A	10	.375-24x1.00	8	.375-24x1.00	10	.500-20x1.00	13	17	19	36	32	62	49
18A	12	.375-24x1.00	10	.500-20x1.25	12	.500-20x1.00	18	15	22	37	40	73	55
21A	12	.500-20x1.25	12	.500-20x1.25	12	.625-18x1.25	30	20	25	45	55	105	75
24A	12	.500-20x1.25	10	.500-20x1.25	12	.625-18x1.25	45	25	35	60	80	150	105
28A	12	.625-18x1.50	14	.500-20x1.25	12	.750-16x1.50	80	35	50	85	130	245	165
33A	14	.625-18x1.50	14	.625-18x1.50	14	.750-16x1.50	120	45	75	120	195	360	240
39A	12	.750-16x1.75	18	.625-18x1.75	12	.875-14x1.75	195	75	115	190	310	580	385
46A	16	.750-16x1.75	20	.625-18x1.75	16	.875-14x1.75	285	95	155	250	440	820	535
53A	12	1.000-14x2.50	20	.625-18x2.25	12	1.125-12x2.25	440	165	350	515	790	1395	955
62A	16	1.000-14x2.50	24	.750-16x2.25	16	1.125-12x2.25	630	240	475	715	1105	1975	1345
72A	16	1.250-12x3.00	28	.750-16x2.50	16	1.375-12x2.50	910	370	710	1080	1620	2900	1990
85A	16	1.250-12x3.00	32	.750-16x2.75	16	1.375-12x2.50	1270	445	980	1425	2250	3965	2695

±All fasteners are Grade 5 or better.

(Cont'd. from preceding page)

DIMENSIONS—INCHES

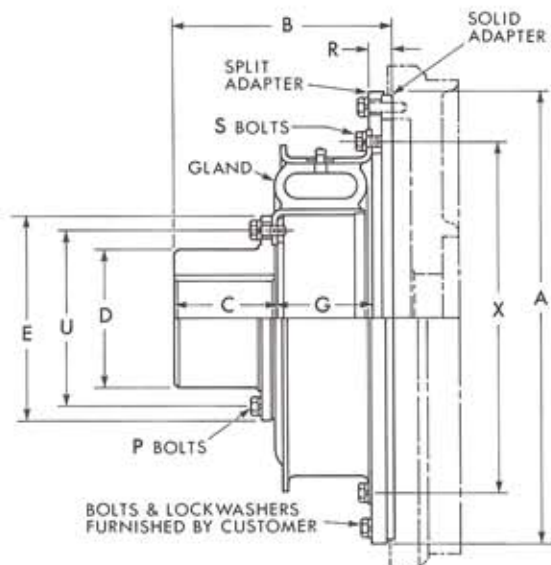
G			H	J	K	L	M					U	V*	W	X	Y	Z	SIZE ★
Mtg. 11	Mtg. 12	Mtg. 13					Mtg. 4	Mtg. 6	Mtg. 9	Mtg. 11	Mtg. 13							
.97	4.22	1.59	.17	3.44	3.69	3.12	.56	.69	.56	.69	.56	4.69	3.688	.41	10.56	25	.16	15A
.97	4.47	1.59	.19	3.69	3.94	3.38	.56	.69	.56	.69	.56	5.12	4.063	.44	11.56	25	.16	16A
.97	4.72	1.59	.19	3.94	4.19	3.62	.56	.69	.56	.69	.56	5.75	4.688	.44	12.88	25	.16	18A
.97	5.09	1.84	.19	4.06	4.38	3.88	.69	.75	.69	.75	.69	6.75	5.500	.53	14.31	38	.16	21A
.97	5.59	1.84	.19	4.56	4.88	4.38	.69	.75	.69	.75	.69	8.00	6.625	.53	16.00	38	.16	24A
.66	6.09	1.72	.19	4.88	5.25	5.12	.81	.94	.81	.94	.81	9.88	8.250	.62	18.25	44	.16	28A
.53	6.78	1.66	.25	5.50	5.88	5.88	.81	.94	.81	.94	.81	11.75	9.625	.62	21.31	50	.16	33A
.66	8.03	2.03	.25	6.50	7.00	6.88	.88	.94	.88	.94	.88	13.75	11.500	.75	24.94	62	.16	39A
.68	8.78	2.03	.31	7.25	7.75	7.62	.88	.94	.88	.94	.88	16.62	14.375	.75	28.88	62	.16	46A
1.12	10.56	2.94	.62	8.50	9.25	8.81	1.31	1.19	1.31	1.19	1.31	19.00	16.625	1.12	32.75	81	.25	53A
1.38	11.88	3.25	.62	9.75	10.50	9.81	1.31	1.19	1.31	1.19	1.31	22.50	19.875	1.12	38.25	88	.25	62A
2.06	13.44	4.19	.62	11.00	11.88	10.75	1.50	1.31	1.50	1.31	1.50	25.75	22.500	1.38	44.00	88	.31	72A
2.06	14.44	4.19	.88	12.00	12.88	11.75	1.50	1.31	1.50	1.31	1.50	32.50	30.000	1.38	51.38	88	.31	85A

▲ Dimension F tolerances for 15 thru 46A are +.000, -.002 and for 53 thru 85A are +.000, -.003.

● Dimension V tolerances for 15 thru 46A are +.002, -.000 and for 53 thru 85A are +.003, -.000.

Dimensions for Mounting to SAE J620 Flywheels

(Consult Factory for other flywheel mountings)



Refer to Pages 6 & 7 for Ratings, Speeds and Bores

DIMENSIONS—INCHES

SAE Flywheel		Airflex Coupling Size *	Weight No Bore (lbs)	DIMENSIONS—INCHES										Fasteners - Gr 5			
Nominal Clutch Dia.	Bolt Circle (Inches)			A	B	C	D	E	G	R	U	X	S		P		
				No	Size	No	Size										
11.5"	13.125	16A	46	14.18	7.94	3.50	3.75	6.00	3.56	1.00	5.12	11.56	8	.375-16x .75	10	.375-24x 1.00	
14"	17.250	21A	85	18.70	8.94	4.00	5.12	7.88	3.90	1.12	6.75	14.31	12	.500-13x .88	12	.500-20x 1.25	
16"	19.250	24A	115	20.70	9.94	4.50	6.25	9.25	4.44	1.12	8.00	16.00	10	.500-13x .88	12	.500-20x 1.25	
18"	21.375	28A	170	22.82	11.00	5.25	7.88	11.25	4.75	1.12	9.88	18.25	14	.500-13x .88	12	.625-18x 1.50	
21"	25.250	33A	265	26.82	12.52	6.00	9.00	13.25	5.38	1.26	11.75	21.31	14	.625-11x 1.25	14	.625-18x 1.50	
24"	27.250	33A	290	29.20	12.52	6.00	9.00	13.25	5.38	1.26	11.75	21.31	14	.625-11x 1.25	14	.625-18x 1.50	

* Dimensions are for reference and subject to change without notice unless certified. All glands are designed to operate at zero psi (gauge) pressure; valves in the glands are required only for manufacturing purposes. Hub Sizes 16A will be furnished for a CLEARANCE FIT with a set screw over the keyway and Hub Sizes 21 thru 33A will be furnished for an INTERFERENCE FIT without set screw.

How to order Falk Airflex Couplings

The following information is necessary to quote or ship to your exact requirements. Prompt service is assured if this information is given on your inquiry or order:

1. Size of Coupling

If not known or if in doubt, supply the following data:

- A. Speed of driver.
- B. Normal and Maximum horsepower of driver.
- C. Kind of driver (electric motor, combustion engine & number of cylinders, etc.).
- D. Hours of service per day.
- E. Type of driven machine (If reciprocating, include number of cylinders). See tables on Page 4.

2. Bore Coupling for

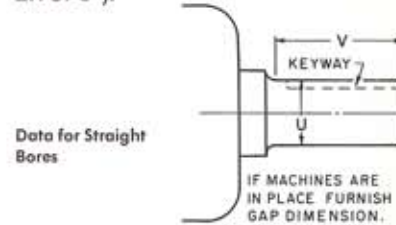
- A. **CLEARANCE FIT**—Sizes 15A thru 18A are furnished for a CLEARANCE FIT with a set screw OVER the keyway, unless otherwise specified.
- B. **INTERFERENCE FIT**—Sizes 21A and larger are furnished for an INTERFERENCE FIT without a set screw, unless otherwise specified.

3. Desired mounting

Refer to Pages 8 thru 10.

4. Dimensions

The dimensions requested here are necessary for correct selection of coupling size and for prompt handling of the order—please refer to the following diagram and furnish the dimensions indicated. Also, check table of Recommended Specifications for Bore Dimensions below. Diameter should be given in decimals, (For Example, 2.9375").



FURNISH DIMENSIONS IN INCHES

FOR STRAIGHT SHAFTS

Driving Shaft	Driven Shaft
Diameter U _____	Diameter U _____
Length V _____	Length V _____
Keyway _____	Keyway _____

Refer to Page 7 for recommended keys. When customer desires to rebore couplings, the reboring instruction sheet is furnished with rough bored couplings.

Table 10 Recommended Bores for Falk Steel Coupling Hubs—Inches

Shaft Dia	Clearance Fit		Interference Fit		Shaft Dia	Clearance Fit		Interference Fit		Shaft Dia	Interference Fit		Shaft Dia	Interference Fit	
	Hub Bore	Clearance	Hub Bore	Interference		Hub Bore	Clearance	Hub Bore	Interference		Hub Bore	Interference		Hub Bore	Interference
+ .0000	+ .0020	.0000	+ .0008	.0000	+ .0000	+ .0020	.0000	+ .0010	.0005	+ .0000	+ .0015	.0010	7.000	6.9950	.0025
- .0005	- .0000	.0025	- .0000	.0013	- .0005	- .0000	.0025	- .0000	.0020	- .0010	- .0000	.0035	7.250	7.2450	.0050
.5000	.5000		.4987		2.2500	2.2500		2.2480		4.0625	4.0590		7.500	7.4950	
.5625	.5625		.5612		2.3125	2.3125		2.3105		4.1250	4.1215		7.750	7.7450	
.6250	.6250		.6237		2.3750	2.3750		2.3730		4.1875	4.1840		8.000	7.9945	.0030
.6875	.6875		.6862		2.4375	2.4375		2.4355		4.2500	4.2465		8.250	8.2445	.0055
.7500	.7500		.7487		2.5000	2.5000		2.4980		4.3125	4.3090		8.500	8.4945	
.8125	.8125		.8112		2.5625	2.5625		2.5605		4.3750	4.3715		8.750	8.7445	
.8750	.8750		.8737		2.6250	2.6250		2.6230		4.4375	4.4340		9.000	8.9940	.0035
.9375	.9375		.9362		2.6875	2.6875		2.6855		4.5000	4.4965		9.250	9.2440	.0060
1.0000	1.0000		.9987		2.7500	2.7500		2.7480		4.5625	4.5590		9.500	9.4940	
1.0625	1.0625		1.0612		2.8125	2.8125		2.8105		4.6250	4.6215		9.750	9.7440	
1.1250	1.1250		1.1237		2.8750	2.8750		2.8730		4.6875	4.6840		+ .000	+ .0020	.0035
1.1875	1.1875		1.1862		2.9375	2.9375		2.9355		4.7500	4.7465		- .001	- .0000	.0065
1.2500	1.2500		1.2487		+ .0000	+ .0020	.0000	+ .0010	.0005	4.8125	4.8090		10.000	9.9935	
1.3125	1.3125		1.3112		- .0010	- .0000	.0030	- .0000	.0025	4.8750	4.8715		10.250	10.2435	
1.3750	1.3750		1.3737		3.0000	3.0000		2.9980*		4.9375	4.9340		10.500	10.4935	
1.4375	1.4375		1.4362		3.0625	3.0625		3.0600		5.0000	4.9965		10.750	10.7435	
1.5000	1.5000		1.4987		3.1250	3.1250		3.1225		5.0625	5.0585	.0015	11.000	10.9930	.0040
+ .0000	+ .0020	.0000	+ .0008	.0002	3.1875	3.1875		3.1850		5.1250	5.1210	.0040	11.250	11.2430	.0070
- .0005	- .0000	.0025	- .0000	.0015	3.2500	3.2500		3.2475		5.1875	5.1835		11.500	11.4930	
1.5625	1.5625		1.5610		3.3125	3.3125		3.3100		5.2500	5.2460		11.750	11.7430	
1.6250	1.6250		1.6235		3.3750	3.3750		3.3725		5.3125	5.3085		12.000	11.9925	.0045
1.6875	1.6875		1.6860		3.4375	3.4375		3.4350		5.3750	5.3710		12.500	12.4925	.0075
1.7500	1.7500		1.7485		3.5000	3.5000		3.4975		5.4375	5.4335		13.000	12.9920	.0050
1.8125	1.8125		1.8110		3.5625	3.5625		3.5600		5.5000	5.4960		13.500	13.4920	.0080
1.8750	1.8750		1.8735		3.6250	3.6250		3.6225		5.5625	5.5585		14.000	13.9915	.0055
1.9375	1.9375		1.9360		3.6875	3.6875		3.6850		5.6250	5.6210		14.500	14.4915	.0085
2.0000	2.0000		1.9985		3.7500	3.7500		3.7475		5.6875	5.6835		+ .000	+ .0025	.0055
+ .0000	+ .0020	.0000	+ .0008	.0002	3.8125	3.8125		3.8100		5.7500	5.7460		- .001	- .0000	.0090
- .0005	- .0000	.0025	- .0000	.0015	3.8750	3.8750		3.8725		5.8125	5.8085		15.000	14.9910	
2.0625	2.0625		2.0610		3.9375	3.9375		3.9350		5.8750	5.8710		15.500	15.4910	
2.1250	2.1250		2.1235		4.0000	4.0000		3.9975		5.9375	5.9335		16.000	15.9905	.0060
2.1875	2.1875		2.1860							6.0000	5.9955	.0020	16.500	16.4905	.0095
										6.2500	6.2455	.0045			
										6.5000	6.4955				
										6.7500	6.7455				

* For 2.9980 bore, interference fit is .0000 to .0020.

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