

 KTR Kupplungstechnik GmbH D-48407 Rheine	CLAMPEX® KTR 700		KTR-N 40824 E
	mounting instructions		sheet: 1
			edition: 2

The **CLAMPEX®** clamping set is a frictionally engaged, detachable shaft - shaft connection for cylindrical shafts without feather key.

General Hints

Please read through these mounting instructions carefully before assembling the clamping set. Please pay special attention to the safety instructions!

The mounting instructions are part of your product. Please keep them carefully and close to the clamping set.

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Safety and Advice Hints



DANGER!

Danger of injury to persons.



CAUTION!

Damages on the machine possible.



ATTENTION!

Pointing to important items.

General Hints to Danger



DANGER!

With assembly and disassembly of the clamping set it has to be made sure that the entire drive train is protected against unintentional engagement. You can be seriously hurt by rotating parts. Please make absolutely sure to read through and observe the following safety instructions.

- All operations on and with the clamping set have to be performed taking into account "safety first".
- Please make sure to disengage the power pack before you perform your work at the clamping set.
- Protect the power pack against unintentional engagement, e. g. by providing hints at the place of engagement or removing the fuse for current supply.
- Do not touch the operation area of the machine as long as it is in operation.
- Please protect the rotating drive parts against unintentional touch. Please provide for the necessary protection devices and caps.

Proper Use

You may only assemble and disassemble the clamping set if you

- have carefully read through the mounting instructions and understood them
- and if you are authorized and have proper skills

The clamping set may only be used in accordance with the technical data (see **CLAMPEX®** catalogue). Unauthorized modifications on the clamping set are not admissible. We do not take any warranty for resulting damages. To further develop the product we reserve the right for technical modifications. The **CLAMPEX®** clamping set described in here corresponds to the technical status at the time of printing of these mounting instructions.

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The clamping set is generally delivered in assembled condition.

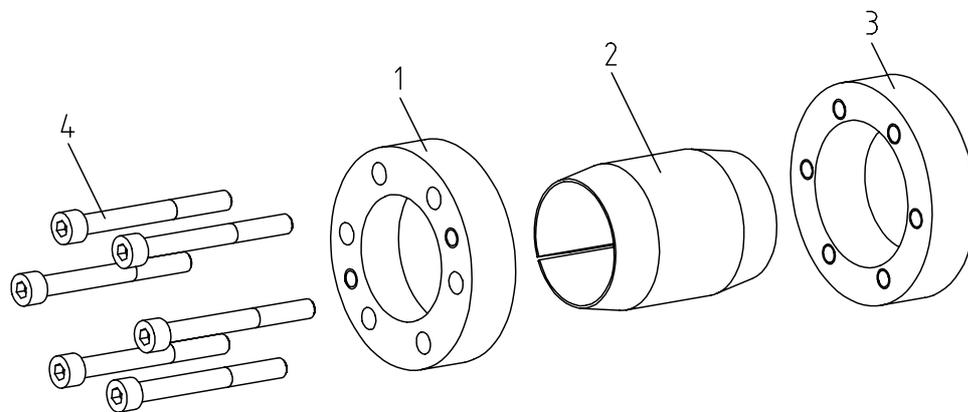
Tolerances, surfaces

A good rotating process is sufficient:
Rz ≤ 16µm

Highest permissible tolerance:
d = h8 for the shafts

Components of CLAMPEX® KTR 700

component	quantity	designation
1	1	front external ring (with through holes)
2	1	internal ring (slotted)
3	1	back external ring (with tappings)
4	see drawing M 367701	cap screw DIN 912



picture 1: CLAMPEX® KTR 700



ATTENTION!

Dirty or used clamping sets must be disassembled, cleaned and afterwards oiled with thin-bodied oil (e. g. Castrol 4 in 1 or Klüber Quitsch Ex) before the assembly.

Assembly

- Check the shaft position regarding the permitted tolerance (h8).
- The contact surfaces of the shafts to be connected must be cleaned and degreased. Afterwards oil them with thin-bodied oil (e. g. Castrol 4 in 1 or Klüber Quitsch Ex).



CAUTION!

Do not use oils and greases with molybdenum disulphide or high pressure additions as well as slide grease pastes.

- Detach the clamping screws (do not detach completely) and put the clamping set KTR 700 stiff shaft coupling onto the shaft ends to be connected.

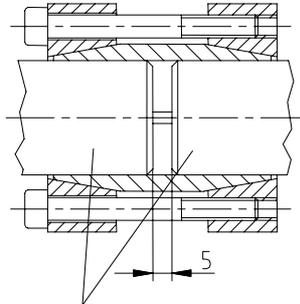
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Assembly

Continuation:

- Slightly tighten the clamping screws by hand and align the clamping set and the shafts (see picture 2).



Shaft ends must be flush with each other.

picture 2: alignment of clamping set

- Tighten the clamping screws evenly and crosswise. Increase the tightening torque step by step. This procedure must be repeated until the tightening torque indicated in table 1 is reached with all clamping screws.

Table 1:

type of clamping set	KTR 700				
screw size M	M6	M8	M10 – Ø70, 75	M10 – Ø80, 85, 90	M12
tightening torque T _A [Nm]	17	41	83	71	143

Disassembly



DANGER!

Loosened or falling drive parts can cause injuries to persons or damages to the machines.

Safe the drive parts before the disassembly.

- Detach all clamping screws evenly and successively. Do not unscrew the clamping screws completely from the thread.
- The clamping sets are not self-locking. If the front and the back external taper ring don't loose, the loosening process must be started by a slight pressure onto the front and the back external taper ring on the circumference.
- Pull the shaft ends out of the clamping set KTR 700.



CAUTION!

In case of non-observance of these hints or in case of non-considerance of the operating conditions regarding the selection of the clamping set, the function of the clamping set can be influenced.

Disposal of waste:

Defective clamping sets must be cleaned and scrapped.

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