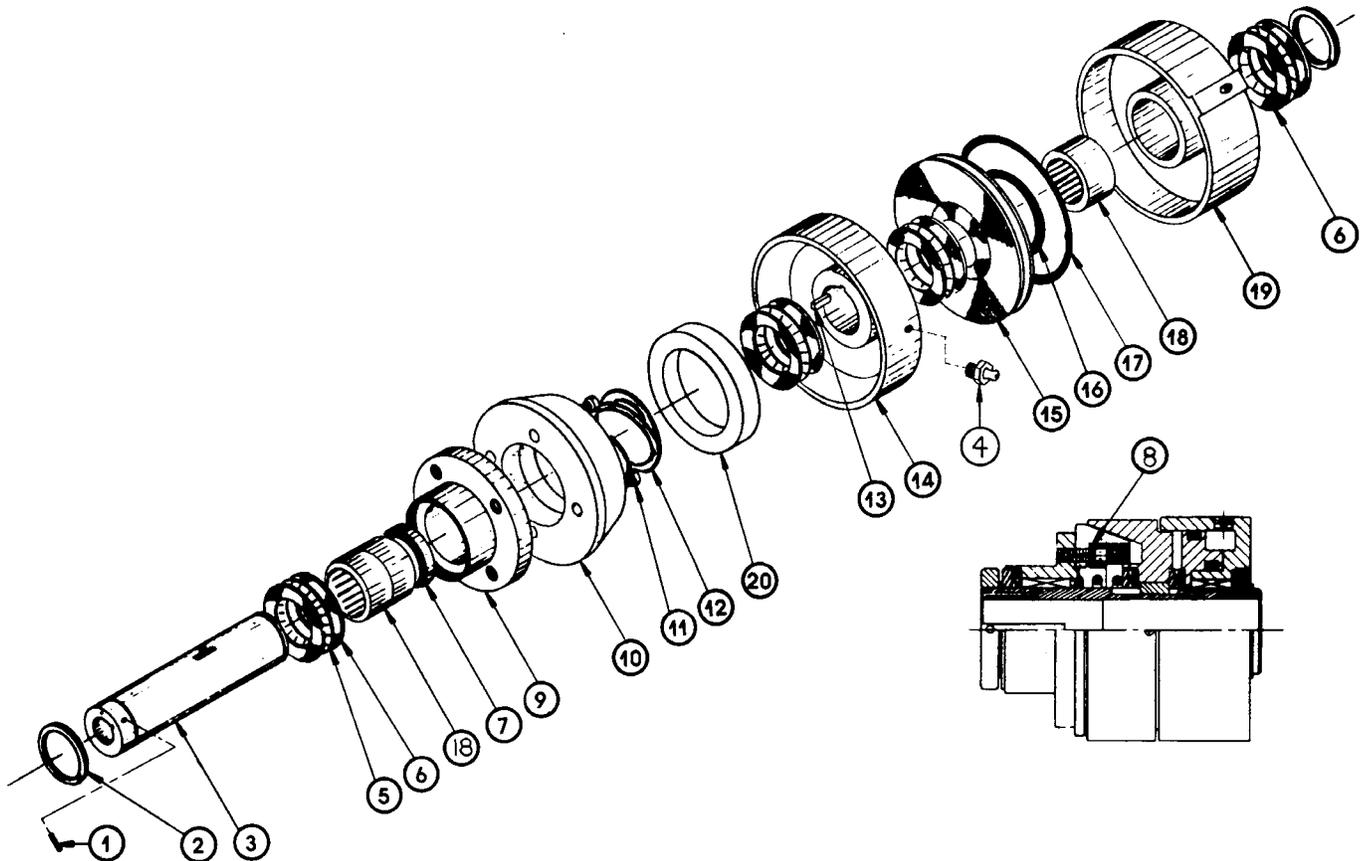


1310B Disc/Cone Clutch

 Models: 1310-0922
 1310-0924
 1310-0932


Parts Listing

ITEM	PART NO.	DESCRIPTION	Quantity		
			1310-0922	1310-0924	1310-0932
1	1310-1014	Set Screw	2	2	2
2	1310-1011	Retaining Ring	2	2	2
3	1310-2032	Clutch Shaft, 1-3/8" Bore	1		
	1310-2034	Clutch Shaft, 1-1/2" Bore		1	
	1310-2042	Clutch Shaft, 2" Bore			1
4	1208-1034	Grease Fitting	1	1	1
5	1304-1162	Thrust Bearing	4	4	4
6	1310-2020	Thrust Race	12	12	12
7	1310-1008	Oil Seal	1	1	1
8	1310-2007	Adapter Ring	1	1	1
9	1310-2001	Adapter	1	1	1

ITEM	PART NO.	DESCRIPTION	Quantity		
			1310-0922	1310-0924	1310-0932
10	1310-1003	Cone	1	1	1
11	1004-1066	Soc. Hd. Cap Screw	4	4	4
12	1310-1007	Compression Spring	1	1	1
13	1310-1010	Key	1	1	1
14	1310-2002	Cup	1	1	1
15	1310-2006	Piston	1	1	1
16	1310-1012	O-Ring, Buna-N-436	1	1	1
17	1310-1013	O-Ring, Buna-N-344	1	1	1
18	1310-1017	Needle Bearing	3	3	3
19	1310-2004	Clutch Cylinder	1	1	1
20	1310-2003	Felt Seal	1	1	1

INSTALLATION

The Tolomatic Disc/Cone Clutch is as simple to install as a sprocket or sheave. Simply slip the clutch over the shaft to the desired position, align with keyway and insert key. After final alignment with mating sprocket or sheave, tighten set screws (#1) to lock clutch in place.

Connect air or hydraulic source (maximum of 100 psi) to cylinder. Make sure no side or end thrust is transmitted to clutch. Flexible hose (**NOT PLASTIC TUBING**) may be used. A restraining member may be necessary to prevent cylinder rotation.

MAINTENANCE

Lubrication, based on maximum rated speeds, will be required after every 24 hours of operation. Use a lubricant such as Mobilith® SHC 460 or equivalent and a grease gun. Three ports are provided for this purpose. Two ports are located in the wall of the shaft at each end of the clutch, the other is located on the Cup (#14).

After long periods of operation, it may be necessary to disassemble the clutch for cleaning and inspection.

⚠ CAUTION: CLUTCHES ARE UNDER SPRING TENSION. USE CARE WHEN DISASSEMBLING.

To disassemble, remove the retaining ring from the cylinder end of the clutch shaft and slide all parts off this end. Assemble all parts onto the shaft from the opposite end. This procedure is necessary to keep from damaging the edges of the bearing seal lips. See exploded view on the other side for correct assembly sequence. The two outer thrust races that contact the retaining rings are heavier than the other races. Be certain they are replaced in the same position.

Wipe off all of the old lubricant before applying fresh grease. Use Mobilith® SHC 460 or equivalent. If it is necessary to remove the piston from the cylinder, re-lubricate the O-rings with a mineral-based O-ring grease.

Remove any grease that may have contacted the cone and clean out any foreign material in the cup. Be careful not to re-contaminate any internal parts.

If these simple procedures are followed, your Tolomatic Disc/Cone Clutch will give years of trouble-free service.

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