

# Warner Electric AT Series Clutches–Pulleys

## Installation Instructions

P-1412  
 819-0362

### Introduction

This sheet provides step by step installation instructions for manufacturer furnished pulleys for AT series clutch pulleys.

**▲ WARNING** Failure to follow these instructions may result in product damage, equipment damage, and serious or fatal injury to personnel.

### Key and Snap Ring Mounting

1. Insert the factory furnished key into its keyway in the clutch hub. Position the sheave or pulley so it will fit onto the hub aligning the keyway with the key. Be sure to keep the tapped pulley removal holes accessible.

**Note:** For high cycle rate applications or applications with potential pulley misalignment, apply Loctite® to the I.D. of the pulley to eliminate the possibility of keyway wear.

2. Gently tap the sheave or pulley until it seats against the hub shoulder.

**Note:** Do not force the pulley or sheave onto the hub if it will not go. Check alignment to assure it is going on evenly. Check for burrs or ridges on the shaft and remove any which may be present with a file.

3. Install the furnished retaining ring with retaining ring pliers. Ensure that the retaining ring is fully seated around its periphery.



**▲ CAUTION** When installing this or other retaining rings, be sure to hold the ring with one hand so it will not spring away should the pliers lose their grip on the ring. Always wear safety glasses when installing or removing retaining rings.

### Through Bolt Mounting

**Note:** This method is suitable for pulleys and sheaves with adequate radial wall thickness to accommodate through holes.

1. Drill holes through the pulley or sheave to match the tapped holes on the hub shoulder of the clutch.
2. Align the through holes in the sheave or pulley with the tapped holes on the hub shoulder and gently tap until it seats against the shoulder.

**Note:** Installing the keyway and snap ring are not necessary if the sheave or pulley is held in place by the through bolt method.

3. Secure the pulley with capscrews, using lock-washers or Loctite to assure thread retention.

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