



**HT Series Clutches**  
Installation and Lubrication Instructions

Emerson Power Transmission  
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**F O R M**  
**4046-005**  
**Revised**  
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	<p><b>▲WARNING</b></p> <p>High voltage and rotating parts may cause serious or fatal injury. Turn off power to install or service. Operate with guards in place. Read and follow all instructions.</p>	
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**A. Preinstallation**

1. The HT Series Clutches are designed primarily as indexing clutches but can be used as general duty or backstop clutches.
2. The HT Clutch is used with a snap ring type ball bearing (preferably sealed), which is mounted in the counterbored end of the clutch. The snap ring ball bearing is not furnished with the clutch.

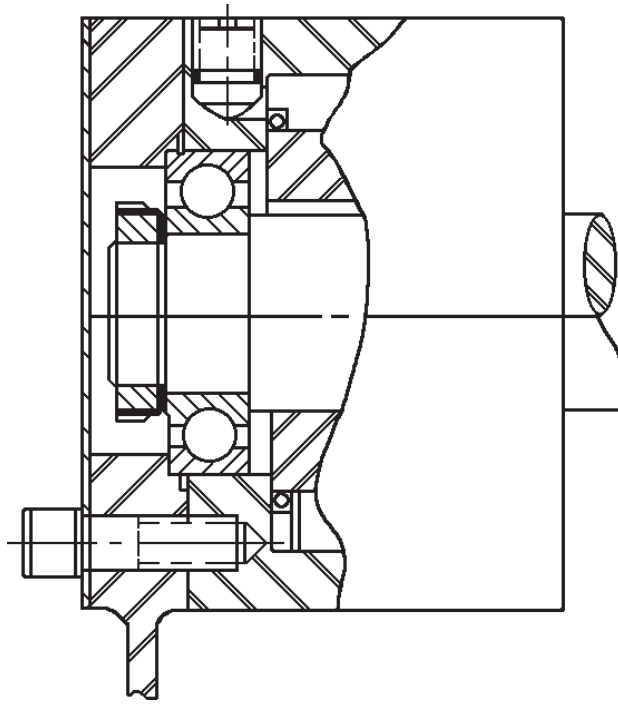
<u>Clutch #</u>	<u>Bore Range</u>	<u>Brg. #</u>	<u>Brg. ID</u>
HT-10	.4250 to .6250	200	.3937
HT-20	.4875 to 1.3125	304 205	.7874 .9843
HT-30	.6125 to 2.00	306 207	1.1811 1.3780

**B. Installation**

To install the HT Clutch: (see illustration)

1. Push the clutch onto the shaft and insert a hardened key (apply pressure on the face of the inner race). The counter bore of the clutch is outboard.
2. If a snap ring type ball bearing is used, place the bearing in the clutch and onto the shaft. Refer to the ball bearing manufacturer's recommendations for pressure on the bearing. Insert the bearing in until the retaining ring used with the bearing is against the clutch outer race.
3. Install bearing retainer and nut on the shaft. Tighten the bearing in place snugly.
4. Mount the indexing arm, overrunning sprocket, or backstop sprocket on the clutch using the mount holes which are in the clutch.
5. Fill the clutch with multi-purpose automatic transmission fluid until it runs out between the end cap and hub.





### C. Lubrication:

1. The HT Clutches are prelubricated with multi-purpose automatic transmission fluid when they are assembled to prevent corrosion and rusting during shipment and storage. They are drained before shipment and most must be lubricated prior to use.
2. After initial lubrication, the clutch must be lubricated as follows:

Note: The following are general lubrication recommendations based on our experience and are intended as suggested or starting points only. For best results, specific applications should be monitored regularly and lubrication intervals and amounts adjusted accordingly.

#### a. Indexing Clutches:

1. Add multi-purpose automatic transmission fluid every 2 weeks until it runs out between the end cap and hub.
2. Drain the clutch and refill every four months.

#### b. General Duty and Overrunning Clutches:

1. Add multi-purpose automatic transmission fluid once every month until it runs out between the end cap and hub.
2. Drain and refill the clutch once every four months.
3. Do not use any lubricants which contain EP additives or those containing slippery additives such as molybdenum disulfide and graphite.

### D. General Information

1. Do not use the clutch above its torque or speed ratings.
2. Do not attempt to take this clutch apart.
3. Application Engineering: 1-800-626-2093.



**Disconnect all power before adjusting units.**