



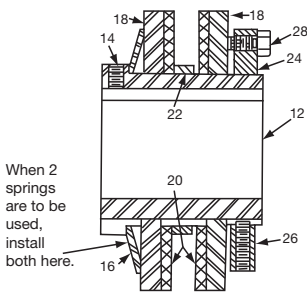
## Instruction Manual for Torque-Tamer™ with Easy-Set Adjustment Sizes 25 through to 70

These instructions must be read thoroughly before installation or operation. This instruction manual was accurate at the time of printing. Please see [dodgeindustrial.com](http://dodgeindustrial.com) for updated instruction manuals.

**WARNING:** To ensure the drive is not unexpectedly started, turn off and lock-out or tag power source before proceeding. Failure to observe these precautions could result in bodily injury.

**WARNING:** All products over 25 kg (55 lbs) are noted on the shipping package. Proper lifting practices are required for these products.

**CAUTION:** Friction discs must be kept clean and free of oil or moisture at all times to obtain proper functioning of the TORQUE TAMER. Do not use washers under heads of tension screws.



**Figure 1 - Torque Tamer Parts**

No.	Name of Part
12	Hub Assembly
14	Hub Setscrew
16	Spring
18	Pressure Plates
20	Friction Discs
22	Bushing
24	Adjusting Nut Assembly
26	Adjusting Nut Setscrew
28	Tension Screws

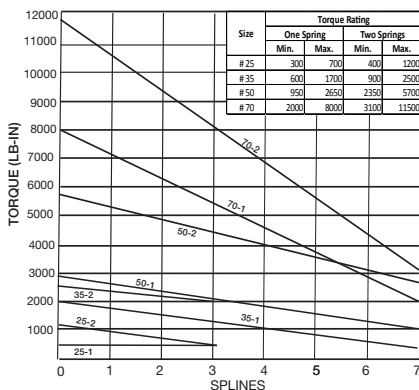
**WARNING:** Because of the possible danger to person(s) or property from accidents which may result from the improper use of products, it is important that correct procedures be followed. Products must be used in accordance with the engineering information specified in the catalog. Proper installation, maintenance and operation procedures must be observed. The instructions in the instruction manuals must be followed. Inspections should be made as necessary to assure safe operation under prevailing conditions. Proper guards and other suitable safety devices or procedures as may be desirable or as may be specified in safety codes should be provided, and are neither provided by Dodge nor are the responsibility of Dodge. This unit and its associated equipment must be installed, adjusted and maintained by qualified personnel who are familiar with the construction and operation of all equipment in the system and the potential hazards involved. When risk to persons or property may be involved, a holding device must be an integral part of the driven equipment beyond the speed reducer output shaft.

## INSTALLATION

1. Back off tension screws (28) at least three turns.
2. Loosen setscrew (26) nine full turns. (Size 25 six full turns). Remove nut (24).
3. Remove one pressure plate (18) and one friction disc (20). Place bushing (22) on hub (12).
4. Slide center member (sprocket, sheave, etc.) on bushing (22). NOTE: Bore finish must not exceed 125 micro-inch and both sides of center member, where contacted by discs (20), must be ground parallel (65 to 125 micro-inch) and must be clean and free of oil or moisture.
5. Replace friction disc (20) and pressure plate (18) with ground side of plate against friction disc.
6. Replace nut (24) and tighten finger tight.
7. Tighten setscrew (26) in nearest spline notch.
8. Tighten tension screws (28) alternately and evenly until heads bottom on nut (24). This provides maximum torque setting. For less torque proceed with the following directions.

## TO ADJUST TORQUE

1. Back off tension screws (28) at least three turns.
2. Loosen adjusting nut setscrew (26) at least nine turns.
3. Reset adjusting nut (24) (Turn clockwise for more torque or counter clockwise for less. Do not tighten adjusting nut beyond finger tight.)
4. Tighten adjusting nut setscrew (26) in nearest spline notch. (Do not tighten set screw on threads of hub.)
5. Tighten tension screws (28) alternately and evenly until heads bottom. Do not use washers under heads of these screws.
6. Check alignment of drive. If necessary, loosen hub setscrew (14) and shift hub (12) on shaft.



**NOTE:** Graph indicates approximate rated torque vs. number of splines adjusting nut is backed off from finger tight. Numbers on calibration lines indicate TORQUE TAMER model and quantity of compression springs. Example: 35-2 is a model 35 TORQUE TAMER with 2 springs.

**Figure 2 - Torque Tamer Clutch Calibration**

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