Typical Mobile Clutch
Hydraulic Pump Applications

[Images of mobile clutches in different applications]
The following installation instructions and service data is for direct shaft driven and belt driven electromagnetic clutches. Proper assembly, installation and maintenance will assure optimal application performance and extended life. Please read the appropriate section prior to assembly and operation.

A. DIRECT DRIVEN CLUTCH/BRACKET INSTALLATION

1. If the power driving source, such as vehicle engine, electric motor, etc. has not been equipped with a mounting platform, extended bumper or suitable frame work to support the pump/clutch assembly, this must be fabricated first. Most any method is acceptable as long as the platform will adequately support the total weight of the pump/clutch/bracket assembly. The mounting platform must also allow for close tolerance adjustment and alignment of the clutch center line to the power source shaft center line. This alignment must be within 3°. Check clutch and bracket dimension prior to fabrication of platform.

2. Mount the clutch to the appropriate foot mount bracket with the bolts provided and torque to specified limits.

3. Loosely position the clutch/bracket assembly on the previously fabricated mounting platform. (NOTE: Remember that close alignment is very important — if necessary, use suitable shims between the bracket and mounting platform. An alignment of zero degrees (0°) vertically and horizontally between clutch and power source shaft center line is optimum. Do not exceed 3°.

4. Drill required holes in platform to correspond to the foot mount bracket on the clutch.

5. Loosely install mount bracket bolts, nuts, lock washers, Re-check alignment (per item 3), and secure all bolts. Torque to specified limits.

6. Remove all alignment tools and/or other devices used.

7. Mount pump to foot bracket on opposite side from clutch. (NOTE: lubrication and cleanliness of the pump shaft and clutch bore is important. Thoroughly clean these areas if any contamination. Apply a thin coating of molybdenum disulfide grease on the shaft and in the bore. This will avoid installation interference, resist corrosion, and reduce friction wear). Use mounting bolts long enough to engage at least three-fourths of the threads in the mounting bracket. Do not use bolts that will touch housing after tightening. Always use lock washers. Clutches with keyways are provided with two dorman plugs. When a short shaft hydraulic pump is used, the smaller plug should be tapped into the clutch bore until it bottoms on the pump shaft. If a long shaft hydraulic pump is used, the smaller plug should be tapped into the clutch bore until bottoms out on the pump shaft. If a long shaft hydraulic pump is used, the larger plug should be installed in the same way.

8. Measure and select and appropriate sized universal drive line. (NOTE: consult with drive line manufacturer's specifications and select a drive line that is adequately sized to accommodate the pump and overall application requirements). See additional notes on each clutch model page in clutch catalog.

9. Install drive line between clutch and power source. Install bolts, nuts and lock washers. Torque to specified limits (NOTE: inspect the drive line for proper phasing. This means that flange yoke ears on each end of the shaft must be directly in line. If not, remove and disassemble the shaft at the splined connection and align the flange yoke ears).

10. If a speed control device is to be used, install per manufacturer’s instructions.

11. This portion of the assembly is now complete. Proceed to section “C”, final installation.

B. BELT DRIVEN CLUTCH/BRACKET INSTALLATION

1. Assemble the clutch, pump and bracket using bolts that will not bottom on the clutch housing. (NOTE: Lubrication and cleanliness of the pump shaft and clutch bore is important. Thoroughly clean these areas if any contamination. Apply a thin coating of molybdenum disulfide grease on the shaft and in the bore. This will avoid installation interference, resist corrosion, and reduce friction wear). Clutches with keyways are provided with two dorman plugs. When a short shaft hydraulic pump is used, the smaller plug should be tapped into the clutch bore until is bottoms out on the pump shaft. If a long shaft hydraulic pump is used, then the larger plug should be installed in the same way.

2. Mounting the pump/clutch/bracket assembly may be accomplished by various methods. You may find that on some vehicle engines there are existing available brackets and/or engine location points whereby a simple fabricated bracket will allow mounting the pump/clutch/bracket assembly with ease. Othets may require a more elaborate method to mount the assembly. An alternative to fabricating your own engine mounting bracket is to use a commercially available, air-conditioning mount and drive kit. These kits may be purchased from most auto and truck air-conditioning warehouse supply centers in your area.

3. With a suitable mount/drive bracket in place and all necessary minor adjustments completed, you are now ready to install the pump/clutch/bracket assembly. Make sure that the pulleys are lined up and the shafts are parallel. This can be done by placing a straightedge against the outside edge of the drive pulley and moving the pulley/pump/bracket until the straightedge touches both sides of both pulleys. Use extreme caution and avoid any possible interference with other accessory members and drive belts. Stay clear of the radiator, fan and hood area. Misalignment causes many problems, some of which are:

- SATURATION: misaligned belts are subject to turnover or roll off.
- NOISE: Misaligned belts can create a noisy drive.
- WEAR: Misalignment will accelerate wear on the side of the belt that comes in contact with the pulley first.
- LIFE: a significant degree of misalignment rapidly decreases belt life.

4. Position the assembly so that the belts can be put on without force. Although V-belts are elastic, they are not rubber bands. Forcing a belt over the groove can result in broken tensile cords in the belt and limited belt life. Using a belt tensiometer, tighten belts to 100-110 lbs., per strand.

5. Place the straight edge against the outside edge of the driver pulley and moving the pulley/pump/bracket until the straightedge touches both sides of both pulleys. Use extreme caution and avoid any possible interference with other accessory members and drive belts. Stay clear of the radiator, fan and hood area. Misalignment causes many problems, some of which are:

- SATURATION: misaligned belts are subject to turnover or roll off.
- NOISE: Misaligned belts can create a noisy drive.
- WEAR: Misalignment will accelerate wear on the side of the belt that comes in contact with the pulley first.
- LIFE: a significant degree of misalignment rapidly decreases belt life.

C. FINAL INSTALLATION INSTRUCTIONS FOR:

A- DIRECT DRIVEN CLUTCHES

B- BELT DRIVEN CLUTCHES

1. Completely inspect the entire assembly and installation. Check and secure all areas for loose or removed components during the installation.

2. Proper connection of the clutch coil to the D.C. Electrical System is very important. Locate a circuit controlled by the vehicle ignition switch, is possible. This will prevent the clutch from being engaged when the vehicle is not in use.

   The coil in the field assembly is continuous run wire. One end of the wire is connected to positive (+). The other end to negative (-) (ground). If the coil has only one led wire protruding from the housing, it will be connected to positive...
H-Series Hydraulic Pump Clutch Installation Instructions (continued)

(+), as the other end is internally grounded to the case. If two lead wires are protruding, connect one to positive (+) and one to negative (-) (ground). Proper clutch operation and clutch life relies on adequate supply of rated D.C. voltage to the field coil.

LOW VOLTAGE = CLUTCH FAILURE
The wiring circuit may vary, depending on whether or not a speed control device is used in the system. This schematic illustrates a simple method of connecting to the D.C. circuitry.

3. IMPORTANT: When the system installation is complete, mechanically and electrically, and the pump/clutch can be operated, a functional check is necessary. With the power source running at 1,000 to 1,200 RPM, cycle the clutch on/off at a rate of 5 sec. on- 5 sec. off for a total of 25 cycles. The armature plate should “Snap” firmly against the rotor. If not, re-check for rated voltage at the lead wire and check for proper grounding.

4. The clutch automatically compensates for wear requiring no adjustment throughout the life of the clutch. DO NOT lubricate the unit. If the clutch should fail to operate, check the electric circuit to be sure that the proper voltage is being supplied to the clutch. DO NOT attempt to make any mechanical adjustments on the clutch.

5. CAUTION: At the moment of engagement, the clutch must pickup all related inertia load of the clutch components and other components being put into rotary motion. This action is correlated to dynamic torque. The larger the clutch and related components the higher the inertia load. Higher R.P.M. engagement of the clutch creates excessive shock load and may cause breakage of the leaf springs and/or clutch slippage and ultimate clutch failure. On direct drive clutches the input drive shaft may also break causing excessive to surrounding area. Please refer to these recommendations regarding maximum clutch engagement R.P.M.

Clutch Model

<table>
<thead>
<tr>
<th>Clutch Model</th>
<th>Max. Engagement R.P.M.</th>
</tr>
</thead>
<tbody>
<tr>
<td>H24</td>
<td>2,500</td>
</tr>
<tr>
<td>H27</td>
<td>1,800</td>
</tr>
<tr>
<td>H28</td>
<td>1,500</td>
</tr>
<tr>
<td>H36</td>
<td>1,200</td>
</tr>
<tr>
<td>H49</td>
<td>1,200</td>
</tr>
<tr>
<td>H55</td>
<td>1,200</td>
</tr>
</tbody>
</table>

CONCLUSION:
Satisfactory performance and life expectancy of your clutch drive system depends on:

- MATCHED COMPONENTS: Pump/Clutch/Brackets and Drive Line equally sized to handle the job
- ALIGNMENT: Direct Drive Lines within 3º (0º is optimum). Belt Drives within 1/8" (Pulley to Pulley).
- NO LEAKS: Hydraulic Fluid, oil and contamination in and around clutch friction surfaces and bearings equals “Short Life”.
- ELECTRICAL: Full rated D.C. voltage must be applied to coil. A loss of 1 volt, on a 12 volt system, equals 9% less torque.
- SCHEDULED MAINTAINENCE: Inspect the entire drive system periodically for proper operation.
- HIGH RPM ENGAGEMENT: refer to item 5 (above). Use caution signs-train the operator.

PERFORMANCE ASSURANCE
The performance of an electro-magnetic clutch depends upon the proper application of the product, adequate run-in, installation and maintenance procedures, and reasonable care in operation of the unit.

All torque values listed in our literature are nominal and are subject to the variations normally associated with friction devices. Adequate and reasonable service factors must be applied when selecting units. Although application engineers are available for consultation, final selection and performance assurance on the buyer's application is the responsibility of the purchaser. The buyer should take into consideration all variables shown in the applicable specification sheet. Careful selection, adequate testing, and proper operation and maintenance of all products should aid in obtaining the best possible performance.
TORQUE
In determining torque requirements for a given machine application, the following relationship of Torque R.P.M. and horsepower is useful.

Mechanical
\[ T = \frac{5252 \times \text{H.P.}}{\text{R.P.M.}} \]

Where \( T \) = Torque (Pound Feet)
\( \text{HP} \) = Horsepower
\( \text{R.P.M.} \) = Speed of Clutch, Revolutions per minute

Fluid Power
\[ T = \text{CIR} \times \text{PSI} \]

\( \text{CIR} \) = Cubic inch per revolution (Hydraulic Pump)
\( \text{PSI} \) = Pounds per square inch

STATIC TORQUE
All references to torque capacity are in terms of static torque, the “break-away” torque required to slip a locked-up clutch or brake.

DYNAMIC TORQUE
Dynamic torque is that applied during the period when the surfaces are sliding into engagement. As a percentage of static torque, dynamic torque varies with surface slip speed and is represented on the accompanying graph.

TORQUE – HORSEPOWER – RPM RELATIONS
What size clutch do you need for your application?
• Determine R.P.M. of operation at the clutch.
• Determine Horsepower that clutch will drive.
• Determine clutch torque required by using the following formula or read directly from chart below.

To find Torque: use formula: \[ T = \left( \frac{\text{H.P.} \times 5252}{\text{R.P.M.}} \right) \]

SERVICE FACTOR
When actual clutch torque is determined for your application, a service factor (or K-factor) must be added to this value. The K-factor is necessary in order to avoid clutch slippage caused by system pressure spikes and/or high RPM engagement shock load to the clutch. Multiply actual torque value required by the K-factor listed below for your particular application.

• For light machines such as drilling, where load is applied after clutch is engaged...................................................... \( K = 1 \frac{1}{2} \) to 2 \( \frac{1}{2} \)
• For electric motors where (during overloads) clutch stalls the motor, use pullout torque factor from motor catalog, or approximately ...................................................... \( K = 2 \) to 3
• For engines where clutch should be strong enough to stall engine................................................................. \( K = 2 \) to 4
• For refrigerant and air compressors.............................................. \( K = 2 \) to 4
• For hydraulic pumps where pressure may be on the system at instant of engagement ...................................................... \( K = 2 \frac{1}{2} \) to 5
• Conveyors and augers, where static load on system must be started by the slipping torque of the clutch.......................... \( K = 3 \) to 5
• The resulting torque requirement, \( K \times T = \) Required Torque of clutch.

Example: Known: 25 H.P. hydraulic pump load at 1800 R.P.M. an occasional pressure spike may occur and the pump will be in the max pressure or by-pass condition \( K = 3 \) is selected. From the chart at left, 25 H.P. at 1800 R.P.M. calls for 73 lb. ft. of Torque. \( T = 73 \). Then \( K \times T = 219 \). We would therefore recommend our MT Clutch Model H-28, “high torque” rated at 200 lb. ft.

*Other useful formulas:
To find Horsepower: use formula
\[ \text{H.P.} = \left( \frac{T \times \text{R.P.M.}}{5252} \right) \]

To find R.P.M. use formula
\[ \text{R.P.M.} = \left( \frac{\text{H.P.} \times 5252}{T} \right) \]

Note: See additional Horsepower data on next page.
Horsepower to a Drive Pump

The standard formula for calculating hydraulic (fluid power) horsepower is: \( HP = \frac{PSI \times GPM}{1714} \). Most positive displacement hydraulic pumps have an efficiency range of 80% to 90%. Figures, in the body of the table below, show the horsepower needed to drive a hydraulic pump having an efficiency of 85%. Therefore, this table is accurate to within 5% of nearly any hydraulic pump. The table below was calculated using this formula:

\[ HP = \frac{PSI \times GPM}{1456.9} \text{ (1714 x 85% efficiency = 1456.9).} \]

For pumps, with other than 85% efficiency, this formula can be used by substituting actual efficiency in place of .85.

Using this table:

The range of 500 to 5000 PSI covers most hydraulic systems, but power requirements can be determined for conditions outside the table, or for intermediate values, by combining values in the table. For example, power at 4000 PSI will be exactly twice the figures shown for 2000 PSI. At 77 GPM, power will be the sum of the figures shown in the 75 and 2 GPM lines, etc.

For systems of less than 500 PSI, horsepower calculations tend to become inaccurate because mechanical friction losses reduce pump efficiency.

Rules-of-Thumb:

Approximate power requirements can be figured with simple mental arithmetic with this rule-of-thumb.

**1 HP is required for each 1 GPM @ 1500 PSI**

For example, a 5 GPM pump operating at 1500 PSI would need 5 HP, or at 3000 would need 10 HP. A 10 GPM pump at 1500 PSI would need 6-2/3 HP, or the same pump operating at 1500 PSI would need 10 HP, etc. Another rule-of-thumb states that about 5% of the pump maximum rated horsepower is required to idle that pump when it is “unloaded” and the oil is circulating at zero PSI. This amount of power is consumed in flow losses plus mechanical friction losses in bearings and pumping elements.

The above data is the calculation typically used for an “average” hydraulic pump and system. For a system that may have unusual pressure spikes, non-matched components, or other idiosyncrasies, an additional horsepower requirement must be considered. When horsepower requirement has been calculated, refer to the nomograph on previous page for horsepower – torque – R.P.M. correlation. Clutches are rated by LBS. FT. of torque.

**NOTE:** A service factor must be added to the actual torque requirement. See service factor data.
H24V90 CLUTCH
Hydraulic Pump Drive
12 or 24 Volt D.C. – V-Belt Driven – 1/2” Wide Belts

12 Volt Amp Draw 4.0  |  Max RPM 5000  |  Weight 14 lbs.

<table>
<thead>
<tr>
<th>24 Volt Clutch Part No.</th>
<th>12 Volt Clutch Part No.</th>
<th>For Pump Shaft Size</th>
<th>For Pump Mount Style</th>
</tr>
</thead>
<tbody>
<tr>
<td>N/A</td>
<td>MT-13229</td>
<td>“A” SPLINE 9T 16/32 DP</td>
<td>“A” 2 Bolt</td>
</tr>
<tr>
<td>MT-13817</td>
<td>MT-13233</td>
<td>3/4” - WITH 3/16” KEY WAY</td>
<td>“A” 2 Bolt</td>
</tr>
</tbody>
</table>

STATIC RATED TORQUE – 90 LBS. FT.
H28V200 CLUTCH
Hydraulic Pump Drive
12 or 24 Volt D.C. – V-Belt Driven – 5/8" Wide Belts

12 Volt Amp Draw 6.0 | Max RPM 3600 | Weight 30 lbs.

Use pump shaft data for more sizes & types

Dorman Expansion Plug
Install as required to seal bore or retain key

STATIC RATED TORQUE – 200 LBS. FT.

<table>
<thead>
<tr>
<th>24 Volt Clutch Part No.</th>
<th>12 Volt Clutch Part No.</th>
<th>For Pump Shaft Size</th>
<th>For Pump Mount Style</th>
</tr>
</thead>
<tbody>
<tr>
<td>MT-13730</td>
<td>MT-13244</td>
<td>1&quot; - WITH 1/4&quot; KEYWAY</td>
<td>&quot;B&quot; 2 OR 4 BOLT</td>
</tr>
<tr>
<td>MT-13654</td>
<td>MT-13245</td>
<td>&quot;B&quot; SPLINE 13T 16/32 DP</td>
<td>&quot;B&quot; 2 OR 4 BOLT</td>
</tr>
<tr>
<td>MT-14046</td>
<td>MT-13246</td>
<td>7/8&quot; - WITH 1/4&quot; KEYWAY</td>
<td>&quot;B&quot; 2 OR 4 BOLT</td>
</tr>
</tbody>
</table>
H28D200 CLUTCH
Hydraulic Pump Drive
12 or 24 Volt D.C. – Shaft Driven

12 Volt Amp Draw 6.0  |  Max RPM 3600  | Weight 30 lbs.

NOTE
• Drive flange bolt pattern and pilot diameter on clutch are dimensioned to correlate with "Spicer" type 1280-1310 series drive shaft flange connections.
• Proper drive shaft selection is important. Consult with drive shaft manufacturers specifications for each specific application requirements.
• Drive shaft alignment must be within 3°.
• Please review performance assurance on bottom of page 3B.

Dorman Expansion Plug
Install as required to seal bore or retain key

Use pump shaft data for more sizes & types

STATIC RATED TORQUE – 200 LBS. FT.

<table>
<thead>
<tr>
<th>24 Volt Clutch Part No.</th>
<th>12 Volt Clutch Part No.</th>
<th>For Pump Shaft Size</th>
<th>For Pump Mount Style</th>
</tr>
</thead>
<tbody>
<tr>
<td>MT-13814</td>
<td>MT-13394</td>
<td>“B” SPLINE 13T 16/32 DP</td>
<td>“B” 2 OR 4 BOLT</td>
</tr>
<tr>
<td>MT-14171</td>
<td>MT-13396</td>
<td>1” - WITH 1/4” KEYWAY</td>
<td>“B” 2 OR 4 BOLT</td>
</tr>
</tbody>
</table>
H28V200 CLUTCH
Hydraulic Pump Drive – (Gresen TC)
12 or 24 Volt D.C. – V-Belt Driven – 5/8” Wide Belts

12 Volt Amp Draw 6.0 | Max RPM 3600 | Weight 28 lbs.

FOR GRESEN
PUMP ONLY

STATIC RATED TORQUE – 200 LBS. FT.

<table>
<thead>
<tr>
<th>24 Volt Clutch Part No.</th>
<th>12 Volt Clutch Part No.</th>
<th>For Pump Shaft Size</th>
<th>For Pump Mount Style</th>
</tr>
</thead>
<tbody>
<tr>
<td>MT-13500</td>
<td>MT-13403</td>
<td>1” STRAIGHT KEYED X 1/4” KWY</td>
<td>“A” 6 BOLT</td>
</tr>
</tbody>
</table>
H36D400 CLUTCH
Hydraulic Pump Drive
12 or 24 Volt D.C. – Shaft Driven

12 Volt Amp Draw 7.6  |  Max RPM 3600  |  Weight 44 lbs.

NOTE:
See next page for drive and mounting flange dimensions.

STATIC RATED TORQUE
400 LBS. FT.

INERTIA
Rotor Assy.  .79 LB. FT.²
Armature Assy. .48 LB. FT.²

<table>
<thead>
<tr>
<th>24 Volt Clutch Part No.</th>
<th>12 Volt Clutch Part No.</th>
<th>For Pump Shaft Size</th>
<th>For Pump Mount Style</th>
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</thead>
<tbody>
<tr>
<td>MT-13856</td>
<td>MT-13378</td>
<td>&quot;C&quot; SPLINED 1-1/4&quot; 14T 12/24 DP</td>
<td>&quot;C&quot; 2-4</td>
</tr>
<tr>
<td>MT-13798</td>
<td>MT-13538</td>
<td>&quot;C&quot; - 1-1/4&quot; WITH 5/16&quot; KEYWAY</td>
<td>&quot;B&quot; 2 -4</td>
</tr>
<tr>
<td>MT-13859</td>
<td>MT-13589</td>
<td>&quot;B&quot; SPLINED 7/8&quot; 13T 16/32 DP</td>
<td>--------</td>
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</tbody>
</table>
H36D400 CLUTCH
MOUNTING DIMENSIONS

NOTE:
• Drive flange bolt pattern and pilot diameter on clutch are dimensional to correlate with “Spicer” type 1350-1410 series drive shaft flange connections.
• Proper drive shaft selection is important. Consult with drive shaft manufacturers specifications for each specific application requirements.
• Drive shaft alignment must be within 3°.
H49D1000 CLUTCH
Hydraulic Pump Drive
12 or 24 Volt D.C. – Shaft Driven

12 Volt Amp Draw 7.6 | Max RPM 3000 | Weight 76 lbs.

NOTE:
See next page for drive and mounting flange dimensions.

STATIC RATED TORQUE
1,000 LBS. FT.

INERTIA
Rotor Assy.  2.76 Lb. FT.²
Armature Assy.  1.88 Lb. FT.²

<table>
<thead>
<tr>
<th>24 Volt Clutch Part No.</th>
<th>12 Volt Clutch Part No.</th>
<th>For Pump Shaft Size</th>
<th>For Pump Mount Style</th>
</tr>
</thead>
<tbody>
<tr>
<td>MT-13902</td>
<td>MT-13635</td>
<td>&quot;C&quot; SPLINED 1-1/4&quot; 14T 12/24 DP</td>
<td>&quot;C&quot; 2-4</td>
</tr>
<tr>
<td>MT-14144</td>
<td>MT-13557</td>
<td>&quot;C&quot; - 1-1/4&quot; WITH 5/16&quot; KEYWAY</td>
<td>&quot;B&quot; 2-4</td>
</tr>
</tbody>
</table>
H49D1000 CLUTCH
MOUNTING DIMENSIONS

NOTE:
• Drive flange bolt pattern and pilot diameter on clutch are dimensional to correlate with "Spicer" type 1410 series drive shaft flange connections.
• Proper drive shaft selection is important. Consult with drive shaft manufacturers specifications for each specific application requirements.
• Drive shaft alignment must be within 3°.
HEAVY DUTY  
(AG – Off Road – Truck)  
TAPER BORE

These heavy duty clutches have been utilized for many years on air compressors, spray rigs, and refrigerant compressors. Whether for those long haul diesel trucks or rugged off-road equipment, this clutch can do the job.

The heavy duty doubles row bearing has been tested to 4,000 hours and is specially designed for a hot, dusty environment.

Stationary field coil assembly is to be mounted concentric to the shaft within .015 T.I.R. Use shoulder bolts provided. Coil face to pulley cavity face – 3/32”.

<table>
<thead>
<tr>
<th>Part No.</th>
<th>A</th>
<th>B</th>
<th>C</th>
<th>D</th>
<th>E</th>
<th>F</th>
<th>G</th>
<th>NO. OF GROOVES</th>
</tr>
</thead>
<tbody>
<tr>
<td>MT-14193</td>
<td>6.700</td>
<td>.500</td>
<td>36º</td>
<td>.500</td>
<td>.392</td>
<td>.620</td>
<td>1.650</td>
<td>2</td>
</tr>
<tr>
<td>MT-14194</td>
<td>5.800</td>
<td>.140</td>
<td>40º</td>
<td>.140</td>
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<tr>
<td>MT-14195</td>
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<td>.140</td>
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