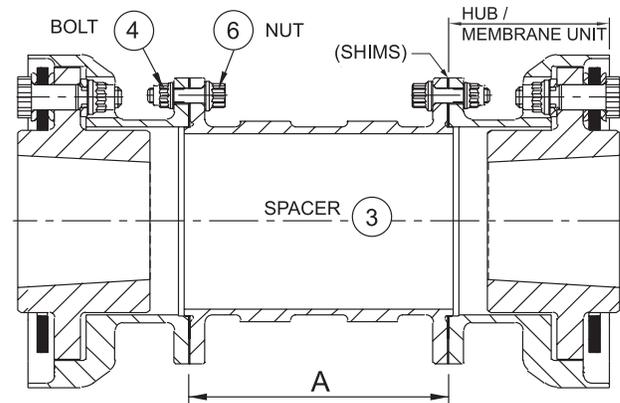


General Specification

John Crane's Metastream torsionally rigid H-CE flexible coupling is a high-performance, dynamically balanced, low-moment coupling typically for use on high-speed mechanical drives (turbines, pumps, compressors). Additionally, due to interlocking flanges, it is designed to cater for large overload torques and maintain the drive until the machinery can be safely brought to rest in the event of failure of the flexing elements.

A general arrangement (GA) drawing is always supplied for high-performance couplings. These instructions are to be read in conjunction with the GA and any specific information on the drawing takes precedence over the general information included herein.

NOTE: Throughout these instructions, the generic high-performance coupling code H-CE indicates HSCE and HLCE.

FIGURE 1

Extent of Supply

The coupling will generally be supplied in the following configuration:

- Factory-assembled coupling complete with hub-mounted membrane assemblies and spacer piece. The whole coupling will have been dynamically balanced for high-speed applications.
- The hub/membrane units are delivered fitted with gagging bolts, painted red and blue, to give protection during transportation and to aid installation of the coupling. **These must be removed before running the coupling.**
- If requested, the coupling can be supplied with a number of packing shims to allow the coupling length to be adjusted on site to suit the specific application. Refer to the specific GA drawing for details of the use of these shims.

Selection Verification

Although a coupling may be correctly specified at the time of order placement, the duty conditions can sometimes change prior to the coupling being put into service. Information is available from John Crane to advise on the selection and limitations of their power transmission products, but the user is ultimately responsible for verifying the suitability of the selection for the actual service conditions.

The coupling and its manner of use must conform to any legal or licensing requirements and, where appropriate, meet local health and safety requirements.

IMPORTANT If the conditions of operation are changed without approval from John Crane, then we would decline responsibility for any consequent damage and the user would assume all risks.

Handling and Storage

- Couplings and components should be stored in a dry building away from direct heat.
- For maximum protection, the coupling and components should be stored in the original packaging. If any packaging has been removed or damaged in transit, it should be restored to a secure safely packaged condition.
- The coupling should be stored horizontally and should not be stood on end for long periods. Avoid shock during handling and protect against corrosion.
- Always examine parts thoroughly when taking them from storage for signs of damage or deterioration.
- During transport, handling and storage, the gagging bolts (painted red and blue for identification) should be in position.
- Following installation of the coupling, all transit gags and bolts should be tagged with the plant/coupling ID and stored ready for subsequent reuse on coupling removal, as should ancillary items, such as spare shims.
- Documentation supplied with the coupling should be retained for future reference.

Installation of Coupling

- Refer to the assembly drawing for all dimensions.
- Inspect the coupling to ensure that it is undamaged and note any match marks that must be aligned when the coupling is installed.
- Set the distance between the shaft ends (DBSE), taking into account any axial movements and thermal expansion which may occur in operation. The final operating distance must be as close as possible to that shown on the arrangement drawing. The shafts should then be aligned.
- Separate the individual hub/membrane units from the spacer. DO NOT dismantle the hub/membrane units, as this will invalidate the dynamic balance.
- If assembled, remove the spacer stripper bolts and nuts and separate the spacer from the hub/membrane assemblies.

IMPORTANT Do not dismantle the membrane assemblies!



Prior to installing the coupling, ensure that the machinery is made safe. Hubs must be adequately supported during installation to avoid accidental damage should they slip.

IMPORTANT Refer to the coupling assembly drawing for all dimensions.

Parallel bore with keyed drive

1. Ensure the hub bore and mating shaft are clean and free from burrs.
2. The hub is usually installed with the hub face flush to the shaft end.
3. Measure the shaft diameter and hub bore to confirm the correct fit.
4. John Crane recommends a light interference fit for most applications, and it may be necessary to apply heat to assist fitting of such hubs. An oven or induction type heater will usually be adequate. DO NOT spot heat or exceed 175°C as this may cause distortion. A thermal heat stick can be used to estimate the temperature before quickly sliding the hub onto the shaft. A suitable stop will ensure the correct axial position is located.

Taper bore with keyed drive

1. Thoroughly clean all contact surfaces and smear the tapered surfaces with oil.
2. Fit the hub onto the shaft without the key(s). Lightly hammer the hub with a soft-faced mallet to ensure metal-to-metal contact takes place. Taper surface contact should be checked for compliance with applicable standards.
3. Measure the distance from the end of the shaft to the face of the hub using a depth micrometer (record this measurement).
4. Securely mount a dial gauge onto the inboard hub flange and set to zero.
5. Remove the hub and fit the key(s) which should be a tight sliding fit in the keyway with a small clearance at the top of the key.
6. Refit the hub and draw up the shaft to the correct axial position indicated by the dial gauge. *(If an interference fit is required the hub may have to be heated [this is rare however]).*
7. When the hub has cooled, remeasure the distance from the end of the shaft to the face of the hub to confirm the correct axial position.
8. Fit the shaft-end retaining nut, if applicable, to ensure the hub is locked in position axially. Ensure the nut is seated against the hub-recess face.

NOTE: *The hub face may not be flush with the shaft end when taper bores are used.*

Taper hubs mounted by oil injection

1. Ensure that fillets and corner radii of mating surfaces, oil distribution and drainage grooves are well-rounded and free from burrs and contamination. Taper surface contact should be checked for compliance with applicable standards.
2. Thoroughly clean all contact surfaces and smear the tapered surfaces with oil.
3. Remove O-rings if fitted.
4. Fit the hub onto the shaft. Lightly hammer the hub with a soft-faced mallet to ensure metal-to-metal contact takes place.
5. Measure the distance from the end of the shaft to the face of the hub using a depth micrometer (record this measurement).
NOTE: *Where O-rings are used, this measurement should be taken with the O-rings removed.*
6. Position a dial gauge against the hub flange face to measure axial movement and set to zero.
NOTE: *Dial gauge should be zeroed with O-rings removed.*
7. If O-rings are used, remove hub and refit the O-rings before continuing.
8. Fit the oil injection equipment, axial stop and mounting tools. Consult the arrangement drawing and the oil injection system supplier's instructions.

Installation of Coupling (continued)

Fit and secure the axial ram or hydraulic nut BEFORE injecting oil between the components.

9. Inject oil between the component interface until the required mounting pressure is reached or it leaks out at the ends of the mating surfaces.
10. By means of the mounting tools, draw the hub up the shaft to the correct axial position, injecting oil during this operation.
NOTE: *The correct pull-up distance should be shown on the GA drawing along with max. permissible installation pressure.*
11. Release the interface oil pressure and leave equipment fitted for one hour to allow for oil to drain from mating surfaces.
12. Remove the mounting tool and oil injection equipment.
13. Remeasure the distance from the end of the shaft to the face of the hub to confirm the correct pull-up.
14. Fit the locking washer and shaft-end retaining nut if applicable.



WAIT for 3-4 hours before applying torque.

Adapters

For machines having an integral flanged shaft, the flange may be machined to suit the bolting configuration of the coupling transmission unit. Alternatively, the coupling may be supplied with a customized flange adapter. Refer to the specific GA drawing for location and mounting details.

The shafts should then be aligned

- With one machine firmly bolted down and with the coupling transit gags still in place, set the reference length (the distance between membrane unit flanges) according to drawing dimension (A). The final operating distance must be as close as possible to that shown on the arrangement drawing.
- Align shaft center lines horizontally and vertically.

NOTE: *The misalignment tolerances quoted in literature and on drawings allow for dynamic conditions and variations. For the best service from the coupling, John Crane recommends that installation misalignment is no more than 10% of the maximum allowable misalignment. Allowance should be made for any anticipated movement which will occur during operation (e.g., thermal movements on hot pumps).*

Check the distance between flange faces of the membrane units taking into account, where applicable, any axial movement that may occur in operation.

Shim setting procedure (if supplied)

Shims are supplied to compensate for minor variations in the axial setting of taper-bored hubs. The assembly is supplied with one set of shims fitted and a separate set for installation. If necessary, the distance between transmission unit flange faces can be increased or decreased by adding or removing shims as required.

Required shim thickness can be found from:

$$S = A - CSL$$

Where

- S = Shim thickness
- A = Measured distance between flange faces (DBFF)
- CSL = Cold setting length = $L + \Delta + \zeta$
- L = Transmission unit length
- Δ = Thermal growth to normal operating temperature (where appropriate)
- ζ = Compensation for transient thermal growth (where appropriate)

IMPORTANT Total shim set thickness must not exceed the value stated on the GA drawing.

Check spigot and recess locations on the hubs and transmission unit for burrs or other signs of damage.

Membrane unit compression for the coplanar coupling

Before the spacer can be fitted between the membrane units, it is necessary to compress the membranes. The following instructions detail each membrane unit compression:

1. Remove the red-painted socket-headed bolts from the guard ring flange of the membrane unit (i.e., three bolts for the HSCE and four bolts for the HLCE [see Figures 3A and 3D]).
2. Tighten the blue-painted socket-headed bolts. Refer to Table 1 for the number of tightening turns.

NOTE: Please ensure that the bolts are tightened in stages to ensure even loading (Figure 3B)

Figure 3C shows a sectional view of the membrane assembly in the fully compressed position.

FIGURE 3A

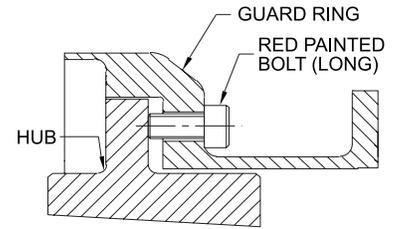


FIGURE 3B

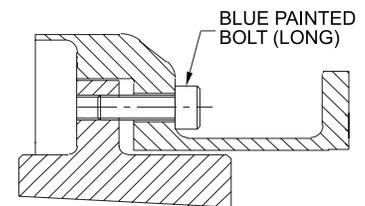


FIGURE 3C. Membrane Pack Compressed

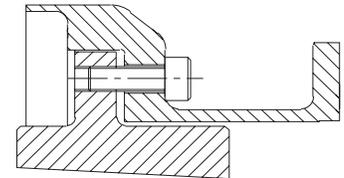


FIGURE 3D

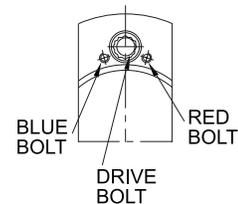


TABLE 1				
Coupling	Gagging Bolt (Blue)	Number	Membrane Compression	Number of Turns
HSCE-0096	M4*0.7	3	2.4	3.4
HSCE-0115	M4*0.7	3	3	4.3
HSCE-0139	M5*0.8	3	3	3.8
HSCE-0159	M5*0.8	3	3	3.8
HSCE-0179	M5*0.8	3	3	3.8
HSCE-0200	M5*0.8	3	4.5	5.6
HSCE-0220	M6*1.0	3	4.5	4.5
HSCE-0240	M6*1.0	3	4.5	4.5
HLCE-0096	M4*0.7	4	1.5	2.1
HLCE-0115	M4*0.7	4	2.1	3.0
HLCE-0139	M5*0.8	4	2.5	3.1
HLCE-0159	M5*0.8	4	2.7	3.4
HLCE-0179	M5*0.8	4	3	3.8
HLCE-0200	M6*1.0	4	3.8	3.8
HLCE-0220	M6*1.0	4	4.2	4.2
HLCE-0240	M8*1.25	4	4.5	3.6
HLCE-0262	M8*1.25	4	4.5	3.6
HLCE-0283	M8*1.25	4	5	4.0
HLCE-0320	M8*1.25	4	5.5	4.4
HLCE-0357	M8*1.25	4	5.5	4.4

Fitting the spacer

IMPORTANT The spacer must be supported throughout this step to ensure that the weight is never imposed on one end only.

- Bring the spacer into position between the flanges, taking care to align any match marks.
- Fit the stripper bolts (4) and nuts (6) loosely to hold the spacer. Remove the gagging screws and store these safely with the sleeves for future use.

IMPORTANT Do not tighten flange bolts with gagging bolts installed.

- Bolts should be tightened in a “diametrically opposite” sequence to the torque values quoted in Table 2. Always check the GA drawing for confirmation; tightening torque values on the drawing take precedence.
- With the coupling in position, check that the ‘as-fitted’ concentricities correspond closely with those quoted on the balancing certificate. If this document is not applicable, ensure that all flanges are set up as concentric as possible. A figure of 0.075 mm TIR should not generally be exceeded.
- If possible, slowly rotate the machinery two or three times to ensure it moves freely.
- Safely store the gagging bolts for future use.

WARNING Transit gags (painted red) must be removed before running the coupling.

TABLE 2

Coupling Designation	Number of Bolts in Each Flange	Diameter mm	Flange Bolt Torque Nm
HSCE-0096	8	6	10
HSCE-0115	12	6	10
HSCE-0139	10	8	25
HSCE-0159	12	8	25
HSCE-0179	16	8	25
HSCE-0200	12	10	50
HSCE-0220	14	10	50
HSCE-0240	12	12	80
HLCE-0096	12	6	10
HLCE-0115	10	8	25
HLCE-0139	12	8	25
HLCE-0159	16	8	25
HLCE-0179	14	10	50
HLCE-0200	14	12	80
HLCE-0220	14	12	80
HLCE-0240	14	14	135
HLCE-0262	16	14	135
HLCE-0283	14	16	205
HLCE-0320	18	16	205
HLCE-0357	22	16	205

Operation

ATTENTION Before starting the machinery, ensure that all necessary safety procedures are being observed.

When operated within the duty conditions for which they were designed, John Crane’s Metastream H-CE couplings will give long and trouble-free service. It is recommended that the tightness of fasteners (4 and 6) are checked periodically.

If the coupled machinery is disturbed at any time, then shaft alignment should be rechecked as a matter of routine. Alignment checking is also recommended if a deterioration of installation alignment during service is suspected.

In the event of failure, it is essential that the true cause of failure is found and corrected before a new unit is put into service. The most likely faults will either be excessive misalignment, extreme overload or a combination of both.

The stripper bolts use prevailing torque locknuts; it is recommended that all the nuts are used no more than five times, or until the prevailing friction torque is lost.

Removal of Coupling

- Remove the spacer flange nuts and bolts while supporting the spacer to ensure the weight is never imposed on one end only.
- Fit the blue-painted compression gagging bolts and compress the membrane units evenly until there is sufficient gap to permit removal of the spacer. Tapped holes are provided in flanges to assist in breaking the spigot/recess fit.

IMPORTANT Do not over-compress either assembly, as this may damage the flexing elements.

Gagging method for the coplanar coupling

The gagging method for the HSCE and HLCE coplanar couplings employs a push-pull bolt arrangement.

The red-painted socket-headed bolt is the push, or stop bolt. Three bolts per membrane unit are required for the HSCE. Four bolts per membrane unit are required for the HLCE.

The blue-painted socket-headed bolt is the puller bolt. Three bolts per membrane unit are required for the HSCE. Four bolts per membrane unit are required for the HLCE.

The following instructions detail the gagging of each membrane unit:

1. Hand-screw the red-painted bolts into the guard ring flange until contact with the hub flange is made. *Only hand tighten the red painted bolts.* See diagrams 3A and 3D. Note clearance under bolt head.
2. The longer blue-painted bolts can now be placed into the holes in the guard ring and hand-screwed into the threaded hub flange until the socket bolt head contacts the guard ring. Tighten the blue bolts in stages to ensure even loading. *Do not over-tighten.* See diagrams 3B and 3D.

The membrane unit is now gagged. Repeat for each membrane unit where applicable.

IMPORTANT NOTE: *The gagging method described above is only intended for transportation and fitting.*

For no-load running, a 'solo plate' should be used.

IMPORTANT Do not dismantle the membrane assemblies as this will invalidate the dynamic balance.

Hub / Membrane Assembly Removal

1. Keyed hubs

- Puller holes are provided as an aid to hub-removal. They are not intended for 'cold' removal of the hub.
- Insert screwed rods and position a puller plate or bar over the rods, bridging a packer bearing on the shaft end.
- Tension the rods up to the safe tightening torque.
- Taking due safety precautions, preferably using an induction heater or heating tape, heat the hub quickly and evenly until it moves and draw off.
- DO NOT use spot heat or exceed 175 °C as this may cause distortion.
- If the hub must be removed 'cold', then use a heavy-duty puller bearing on the back of the hub boss. Avoid contact and load transfer between the puller and the flange, as this may cause distortion.

2. Hubs mounted by oil injection



A suitable stop to control axial movement of the hub/membrane unit must be fitted before oil injection begins.

- For reasons of safety — and to prevent damage to mating surfaces — use the mounting tools to restrict the movement of the hub from the shaft, which may suddenly separate with considerable force.
- Assemble the oil injection equipment. Consult the oil injection system supplier's instructions.
- Inject oil between the components until the required pressure is reached, or it leaks out at the ends of the mating surfaces.
- Gradually release the mounting tool so that the hub/membrane unit slides off smoothly.

3. Adapters

- Refer to the specific GA drawing for location and mounting details.
- Note position on shaft flange and any match markings.
- Support the weight of the adapter.
- Remove the adapter stripper bolts.
- Tapped holes are provided in flanges to assist in breaking the spigot/recess fit.

Maintenance and Inspection

Under normal operating conditions, no servicing or maintenance should be necessary. Periodically, the bolts should be checked for tightness and the flexing elements checked for any visible signs of distress. If the hubs or shafts have been disturbed for any reason, alignment must be checked.

Any dismantling or remedial work on the hub/membrane units will invalidate the dynamic balance.

In the event of failure, it is essential that the true cause of failure is found and corrected before a new unit is put into service.

The most likely faults will either be excessive misalignment, extreme overload or a combination of both.

The bolts use prevailing torque locknuts; it is recommended that the nuts are replaced following the fifth time of use or when the locking feature becomes ineffective.

Caution

All necessary steps have been taken to ensure, as far as is reasonably practical, that couplings are designed and manufactured to be safe when properly used. These instructions are, however, general and it is important that users observe all statutory plant and other safety requirements.

Information is available from John Crane to advise on the selection and limitations of flexible couplings; however the choice of coupling for a particular duty is ultimately the responsibility of the user.

While power transmission couplings are simple in concept, it is assumed that they will be used by appropriately qualified, experienced and competent people, for whom these instructions have been written.

Solo Running

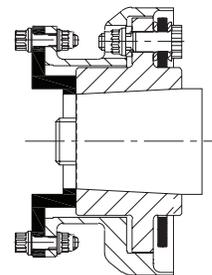
Where the driving machine is required to be run uncoupled, the flexible membrane unit must be immobilized. This is normally achieved by fitting the gagging bolts and sleeves supplied with the coupling (Figure 2). In some circumstances a solo plate or a moment simulator may be used.

Solo plate

The solo plate is designed to make the flexible membrane assembly rigid by clamping it securely to the shaft end. It cannot emulate the T_GE coupling overhung moment.

Moment simulator

The moment simulator is a simple dummy hub designed to match the half-weight and center of gravity of the coupling. The moment simulator is mounted in place of the hub/membrane assembly.



The respect of the Essential Health and Safety Requirements is ensured by conformity with:
 EN ISO 80079-36 : 2016
 EN ISO 80079-37 : 2016

CE / ATEX Marking

All couplings that comply with CE and ATEX legislation will be marked as shown. Zone and Category may be subject to change upon customer request. This will be etched on the spacer element of the transmission unit if enough room is available. Marking has to be readable and indelible; it has to include the following indications:

- o CE Stamp
- o Manufacturing site address
- o Coupling part number
- o INERIS Certificate Reference
- o (Serial number)
- o (Year of construction)
- o II 2 GD OR I M1
- o Ex h IIC T(*) Gb or
- o Ex h IIIC T(*) Db or
- o Ex h I T150°C
- o T. Ambient : (*)

(*) : see Table 4 below.

EXAMPLES

CE Ex II 2 GD Ex h IIC T3 – Ex h IIIC T200°C 76250, France.

TSKS-0055-0055-1000

INERIS 20ATEX3006, xxxxx, 2020

Or

CE Ex I M1 Ex h I T150°C 76250, France.

TSKS-0120-0033-1000

INERIS 20ATEX3006, xxxxx, 2020

ATTENTION

For maximum ambient temperature above 90°C, use in mining is not authorized.

Marking may be carried out in the language of the country of use.

The protective system or equipment has to additionally carry the marking normally stipulated by its construction standards.

TABLE 4. Temperature Classes Based On Ambient Temperature Range

Ambient Temperature Range		Temperature Class		
Min.	Max.	Gas	Dust	Mining
-55°C <	Ta < 150°C	T3	T200°C	N/A
-55°C <	Ta < 90°C	T4	T135°C	150°C
-55°C <	Ta < 55°C	T5	T100°C	150°C
-55°C <	Ta < 40°C	T6	T85°C	150°C

Operation in aggressive atmospheres

The following components contain non-metallic materials. Confirm compatibility or provide suitable protection if the coupling is to operate in an aggressive atmosphere.

- The hub electrical insulation (if supplied option) – reinforced thermosetting plastic
- Limited end float bearings (if supplied option) – PTFE based plastic

Temperature classification of John Crane's Metastream couplings

John Crane's Metastream metal membrane couplings, supplied in conformance with Directive 2014/34/EU, have to meet the classifications specified in Table 4 when used in accordance with instructions and information supplied.

A series couplings, using the elastomeric type flexible elements, are covered by type examination certificate INERIS 20ATEX3019.

T, L and H series couplings, using the disk type flexible elements, are covered by type examination certificate INERIS 20ATEX3006.

M series couplings, using the diaphragm type flexible elements, are covered by type examination certificate INERIS 20ATEX3018.



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Declaration of Conformity

EEC Directive 2014/34/EU of 26.02.2014
and resultant legislation and standards

We, the manufacturers – John Crane UK Ltd, – confirm that the explosion prevention requirements have been implemented for

Metastream® metal-membrane couplings
and Powerstream elastomeric couplings

Equipment complies with the requirements of directive 2014/34/EU. It is in accordance with article 13. (a) of the directive and the fundamental Health and Safety requirements of Annex II, are fulfilled.

The current Type Examination Certificates for the couplings are:-

'T', 'L' & 'H' Series -	INERIS 20ATEX3006
'M' Series -	INERIS 20ATEX3018
'A' Series -	INERIS 20ATEX3019

The technical documentation is deposited with the designated notified body in accordance with article 13 (b) (ii) of the Directive 2014/34/EU.

Ineris
AV du Parc Alata
Verneuil-en-Halatte 60550
France

Signed:

Date: 14th September 2020

S. Pennington
(Senior Manager – Engineering Couplings)



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Declaration of Incorporation

E.C. Machinery Directive (2006/42/EC)

Section 1.0 - Machinery Description:
Flexible Power Transmission Ring and Diaphragm Form Membrane Couplings
Types:

'H', 'T', 'L' & 'M' Series

Section 2.0 - Applicable Harmonised Standards
ISO13709 (API 610) for centrifugal pumps
ISO14691 couplings for - General-purpose applications
ISO10441 (API 671) (opt) couplings for - Special-purpose applications

Section 3.0 - Declaration:
We, John Crane declare that under our sole responsibility for the supply of the machinery defined in Section 1.0 above, the said machinery parts are intended to be incorporated into other machinery or assembled with other machinery to constitute machinery as covered by this Directive.

The machinery parts, covered by this declaration must not be put into service until the machinery into which it is to be incorporated has been declared in conformity with the provisions of the Directive.

Signed:

Date: 20th July 2016

S. Pennington
(Engineering Manager - Couplings)



North America	Europe	Latin America	Middle East & Africa	Asia Pacific
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Fax: 1-847-967-3915	Fax: 44-1753-224224	Fax: 55-11-3371-2599	Fax: 971-488-62830	Fax: 65-6518-1803

If the products featured will be used in a potentially dangerous and/or hazardous process, your John Crane representative should be consulted prior to their selection and use. In the interest of continuous development, John Crane Companies reserve the right to alter designs and specifications without prior notice. It is dangerous to smoke while handling products made from PTFE. Old and new PTFE products must not be incinerated. ISO 9001 and ISO14001 Certified, details available on request.