



GD Rigid Compression Coupling Installation Guide

Please complete the following steps to install QM GD Rigid Compression Couplings.

1. Check the bore size of the Rigid Compression Coupling and the shafts to ensure that it is the correct bore size to fit the application.
2. If necessary, clean and de-burr the shafts.
3. Check to make sure shafts are aligned.
4. Align keyways in shafts with each other. Keyways should be in the upward facing position.
5. Set key(s) in place on shafts.
6. Unbolt Rigid Compression Coupling halves and discard shims. They are not required.
7. Place keyed half of the coupling on the shafts.
8. Bolt up bottom half to top half using Grade 8 assembly hardware supplied – bolt to torque specifications in Table 1.
9. Tighten setscrews over keyway to torque specifications in Table 2.

TABLE 1. Assembly Bolt Torque Values

Part #	Assembly Bolts	Torque (lbs-in)
GD107	(4) 1/2	1320
GD108	(4) 1/2	1320
GD115	(4) 1/2	1320
GD200	(4) 1/2	1320
GD203	(4) 5/8	2640
GD204	(4) 5/8	2640
GD207	(6) 5/8	2640
GD208	(6) 5/8	2640
GD215	(6) 3/4	4560
GD300	(6) 3/4	4560
GD307	(6) 7/8	7200
GD308	(6) 7/8	7200
GD315	(6) 1	10800
GD400	(6) 1	10800
GD407	(6) 1-1/8	17160
GD408	(6) 1-1/8	17160
GD415	(6) 1-1/8	17160
GD500	(6) 1-1/8	17160

TABLE 2. Setscrew Torque Values

Part #	Setscrews	Torque (lbs-in)
GD107	(2) 3/8	290
GD108	(2) 3/8	290
GD115	(2) 1/2	620
GD200	(2) 1/2	620
GD203	(2) 1/2	620
GD204	(2) 1/2	620
GD207	(2) 5/8	1325
GD208	(2) 5/8	1325
GD215	(2) 3/4	2400
GD300	(2) 3/4	2400
GD307	(2) 7/8	5200
GD308	(2) 7/8	5200
GD315	(2) 1	7200
GD400	(2) 1	7200
GD407	(2) 1	7200
GD408	(2) 1	7200
GD415	(2) 1	7200
GD500	(2) 1	7200

North American Locations: Western Canada – Prince George, BC Eastern Canada – Mississauga, ON Western US – Ferndale, WA Southern US – Irving, TX Eastern US – Cuyahoga Falls, OH

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