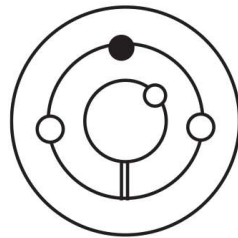
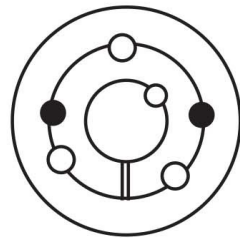


Taper Bushing Installation

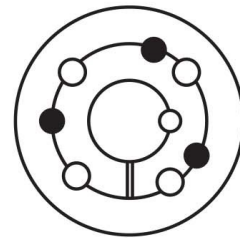
IMPORTANT NOTE: Please follow the instructions on this sheet in order



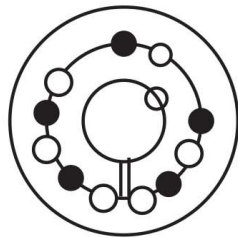
1008 to 3030



3535 to 6050



7060 to 10085



102100

INSTALLATION

1. Clean all oil, dirt, and paint from shaft, bushing bore, outside of bushing and component (sprocket, sheave...etc.) bore.
2. Insert bushing into component. Match the hole pattern, not the threaded holes (each hole will be threaded on one side only.)
3. Thread set or cap screws into those half threaded holes indicated by ○ on above diagram. Mount assembly on shaft.
4. Alternately torque set or cap screws* to recommended torque setting in chart below.
5. On 3535 and larger bushings use a block, sleeve or drift and hammer large end of bushing (do not hammer bushing directly).
6. Repeat steps 4 and 5 until torque wrench reading, after hammering, is the same as before hammering.
7. Fill all unoccupied holes with grease.

REMOVAL

1. Remove all set or cap screws.
2. Insert set or cap screws in holes indicated by ● on drawing. Loosen bushing by alternately tightening set or cap screws.
3. To reinstall, complete all seven (7) installation instructions.

RECOMMENDED TORQUE TABLE

Bushing No.	Set or Cap Screw	Wrench Torque in. / lbs.
1008, 1108	1/4 - 20 Socket Set Screw	55
1210, 1215, 1310	3/8 - 16 Socket Set Screw	175
1610, 1615	3/8 - 16 Socket Set Screw	175
2012	7/16 - 14 Socket Set Screw	280
2517, 2525	1/2 - 13 Socket Set Screw	430
3020, 3030	5/8 - 11 Socket Set Screw	800
3535	1/2 - 13 Socket Head Cap Screw	1,000
4040	5/8 - 11 Socket Head Cap Screw	1,700
4545	3/4 - 10 Socket Head Cap Screw	2,450
5050	7/8 - 9 Socket Head Cap Screw	3,100
6050, 7060, 8065	1-1/4 - 7 Socket Head Cap Screw	7,820
10085, 120100	1 - 1/2 - 6 Socket Head Cap Screw	13,700

* If two bushings are used on same component and shaft, fully tighten one bushing before working on the other.



WARNING: USE OF ANTI-SEIZE LUBRICANT ON TAPERED CONE SURFACES OR ON BOLT THREADS WHEN MOUNTING MAY RESULT IN DAMAGE TO SHEAVES AND SPROCKETS. THIS VOIDS ALL MANUFACTURER'S WARRANTIES.

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 given above must be followed. Inspections should be made as necessary to assure safe operation under prevailing conditions. All rotating power transmission products when used in a drive are potentially dangerous and must be guarded by the user as required by applicable laws, regulations, standards, and good safety practice. (Refer to ANSI Standard B15.1.)