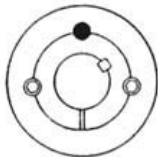
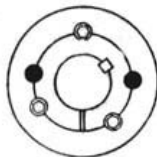


Taper Bushings

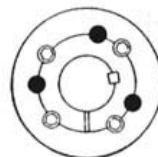
Note: The following information is based on instructions from a manufactures catalog. For further information refer to or ask for a manufactures catalog.



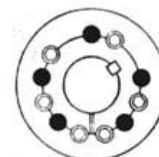
1008 to 3030



3535 to 6050



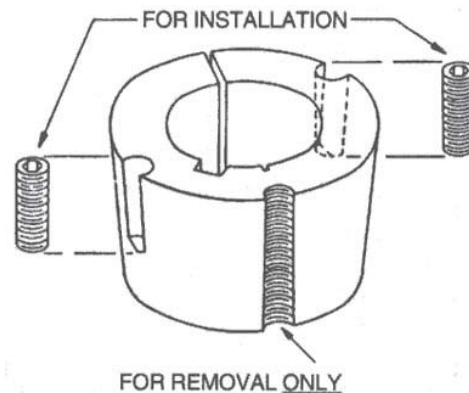
7060 to 10085



120100

How to Install

1. Clean shaft, bore, and outside of bushing, and bore of hub (taking bushing from hub if already assembled). Remove any oil, lacquer, or dirt. Place bushing in hub and match half holes to make complete holes (each complete hole will be threaded on one side only).
2. Oil thread and point of set screws or thread and under head of cap screws. Place screws loosely in holes that are threaded on hub side (shown like this [o], in above diagram).
3. Make sure bushing is free in hub. Slip assembly onto shaft and locate in position desired.
4. Tighten screws (see note*) alternately and evenly until all are pulled up very tightly. Use a piece of pipe on wrench to increase leverage. (See table for wrench torque in table below.)
5. Hammer against large end of bushing using hammer and block or sleeve to avoid damage. Screws can now be turned a little more using the specified wrench torque. Repeat this alternate hammering and screw re-tightening until the specified wrench torque no longer turns the screws after hammering. Fill other holes with grease to exclude dirt.



How to Remove

1. Remove all screws. Oil thread and point of set screws or thread and under head of cap screws.
2. Insert screws in holes that are threaded on bushing side (shown as a solid black dot in diagram). In sizes where washers are found under screw heads, be sure to use these washers. *Note that **one screw** in each hub is left over and is not used in this loosening operation.*
3. Tighten screws alternately until bushing is loosened in hub. If bushing does not loosen immediately, tap on the hub.

Note:

When torque wrench is not available, it is possible to approximate these values by using an ordinary wrench and piece of pipe on wrench. For example, to obtain 1000 pound-inches wrench torque, pull 100 pounds at 10" distance from center of pull to center of screw, or pull 50 pounds at 20" distance.

Recommended Wrench Torque

Bushing Number	Screws	Wrench Torque ▲ (Pounds-Inches)
1008	1/4" SET SCREWS	55
1210	3/8" SET SCREWS	175
1610	3/8" SET SCREWS	175
2012	7/16" SET SCREWS	280
2517	1/2" SET SCREWS	430
3020, 3030	3/4" SET SCREWS	800
3535	1/2" CAP SCREWS	1,000
4040	3/4" CAP SCREWS	1,700
4545	3/4" CAP SCREWS	2,450
5050	7/8" CAP SCREWS	3,100
6050, 7060, 8065	1 1/4" CAP SCREWS	7,820
10085, 120100	1 1/2" CAP SCREWS	13,700

When ordering Bushings give: Number stamped on large end of bushing, bore, and quantity.

★If two bushings are used in the same sheave, pulley, or other unit member, tighten one bushing on shaft per steps 4 and 5 before starting to tighten screws in other bushing.