



TAPER-LOCK BUSHING

INSTALLATION

1. Before installing the bushing, polish the following components:
 - a. Surface of shaft
 - b. Bore of the bushing
 - c. Tapered inside diameter of the Taper-Lock hub
 - d. Tapered outside diameter of the Taper-Lock bushing

Remove all burrs and foreign material. Any particles left on the mating surfaces may cause improper installation.

Note: Do not lubricate mating surfaces.

2. Being careful not to damage bore or hubs, slip shaft into pulley.
3. Slide bushings onto shaft and into hubs. Oil thread point of set screws or thread and under head of capscrews. Place screws loosely in the holes that are threaded on the hub side.
4. Locate shaft in position desired and hand tighten screws in each bushing slightly so that bushings are snug in hubs.
5. Tighten screws alternately and evenly in one bushing only until all screws are very tight. Use a piece of pipe on the wrench to increase leverage. See table on the back for wrench torque.

Avoid excessive wrench torque to prevent damage to the threads. Then use a hammer against a heavy steel or bronze bar held against bushings. Hammer first beside the screw farthest from the bushing split and then hammer on the bushing opposite side of the screw. Avoid hammering close to the OD of the bushing to prevent damage. Working toward the split, hammer on bushing on each side of each screw. Then hammer on each side of the bushing split. Make sure the surfaces on both sides of the split are even. Screws can now be tightened a little more using the specified torque. Repeat this alternate hammering and screw re-tightening until the specified wrench torque no longer turns the screws after hammering.

Check to make sure the surface on both sides of the split are even. Fill the other holes with grease to exclude dirt.

6. Tighten the second bushing per Step 5.

REMOVAL

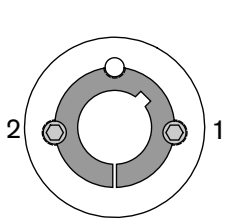
1. Remove all capscrews.
2. Insert screws in holes that are threaded on bushing side. In sizes where washers are found under screw heads, be sure to use these washers. Note that one screw in each hub is left over and is not used for removal.
3. Tighten screws alternately until bushings are loosened in hubs. If bushing does not loosen immediately, tap on bushing with soft hammer.

MAINTENANCE

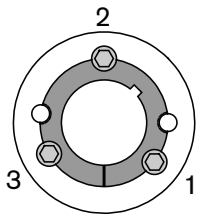
For the first month of operation, inspect bushings and capscrews for proper seating at least once a week and thereafter during periodic shutdowns.

RECOMMENDED WRENCH TORQUE

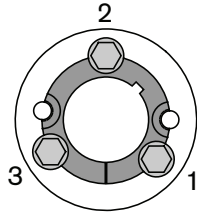
HUB	BUSHING #	NUMBER OF SCREWS	CAP SCREW SIZE	SET SCREW SIZE	WRENCH TORQUE (LBS)
W12	1008	2	1/4 - 20NC x 1/2	-	55
W16	1610	2	3/8 - 16NC x 5/8	-	175
W16	1615	2	3/8 - 16NC x 5/8	-	175
SZ06	2012	2	7/16 - 14NC x 7/8	-	280
W25	2517	2	1/2 - 13NC x 1	-	430
W25	2525	2	1/2 - 13NC x 1	-	430
F30	3020	2	5/8 - 11NC x 1-1/4	-	800
WA30	3030	2	5/8 - 11NC x 1-1/4	-	800
K35	3535	3	-	1/2 - 13NC x 1-1/2	1,000
K40	4040	3	-	5/8 - 11NC x 1-3/4	1,700
K45	4545	3	-	3/4 - 10NC x 2	2,450
K50	5050	3	-	7/8 - 9NC x 2-1/4	3,100
K60	6050	3	-	1-1/4 - 7NC x 3-1/2	7,820
K70	7060	4	-	1-1/4 - 7NC x 3-1/2	7,820
K80	8065	4	-	1-1/4 - 7NC x 3-1/2	7,820
K100	10085	4	-	1-1/2 - 6NC x 4-1/2	13,700
K120	120100	6	-	1-1/2 - 6NC x 4-1/2	13,700



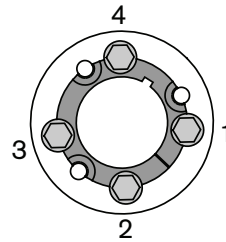
1008 to 3030



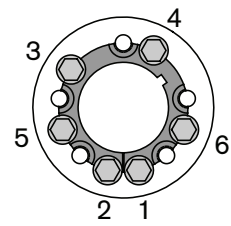
3535 to 5050



6050



7060 to 10085



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