



OPERATION & MAINTENANCE

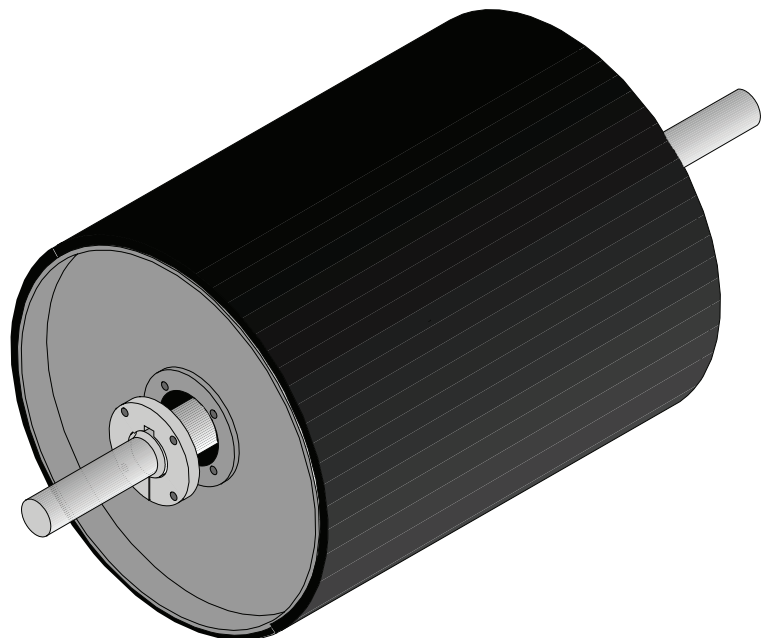
# SHAFT INSTALLATION INSTRUCTIONS

## INSTALLATION

1. Before installing the bushing, polish the following components:
  - a. Surface of shaft
  - b. Bore of the bushing
  - c. Inside diameter of the hub
  - d. Outside diameter of the bushing

Remove all burrs and foreign material, any particles left on the mating surfaces may cause improper installation.  
**DO NOT LUBRICATE MATING SURFACES**

2. If the pulley is to be keyed to shaft, make sure both shaft and bushing keyways are clean, smooth, and free from burrs. Check the key size with both shaft and bushing keyways. Keys should be placed into shaft keyways at this time. Pulley bushing keyways require alignment of both shaft keyways for proper bushing to hub installation.
3. Place shaft into pulley, being careful not to damage the bore of the hubs.
4. Carefully insert a wedge in the bushing split and tap lightly to expand the bushing. Use caution as excessive expansion will cause the bushing to split.
5. Locate shaft position desired and tighten capscrews in each bushing slightly so that bushings are snug in hubs.
6. Using a torque wrench and the recommended torque from bushing installation instructions, tighten capscrews alternately and evenly in one bushing only.
7. Tighten the second bushing per Step 6.



CORPORATE OFFICE • P.O. Box 287 • Pella, IA 50219  
800.247.1228 • 641.628.3115 • 641.628.3658 FAX