Bushing Installation Instructions

IMPORTANT: DO NOT USE LUBRICANTS IN THIS INSTALLATION

To Install Bushing:

1. Remove all oil, grease, etc. from tapered surface of bushing and bore of mating part.

2. If bushing has a keyway, install shaft key.
(Note: If a rectangular key is required, one will be furnished with the bushing.)

3. Select **Standard** or **Reverse** mounting assembly. See Figures 1 and 2.

NOTE: If bushing does not slide freely on shaft, wedge a screwdriver blade into the saw cut at the flange OD to open the bore of the bushing. Caution: Excessive wedging will split the bushing.

4. **Standard Mount** - Slide bushing on shaft, flange first. If using the setscrew, snug it against the key. **Excessive Torque will cause mating part to be eccentric.** Position mating part in place on bushing aligning drilled holes in mating part with tapped holes in bushing flange. Using lockwashers, install capscrews thru the mating hub and into the bushing flange. (**Note:** M thru S bushings can only be Standard Mounted. Be sure the two tapped holes in the mating hub **do not** align near the bushing saw cut. If they do, rotate the bushing 90 degrees.)

5. **Reverse Mount** - Place mating part over and onto shaft as far as possible with large bore end of taper outward. Slide bushing onto shaft so tapered end will engage into the mating part. Tighten setscrew (see #4 above). Align drilled holes in bushing flange with tapped holes in mating part. Using lockwashers, install the capscrews thru the bushing flange and into the mating hub.

6. **Use A Torque Wrench.**Tighten all capscrews evenly and progressively in rotation to the torque value listed in the table. **Excessive wrench torque, closing the gap between the bushing flange and mating hub, or the use of lubricants will break the mating hub.**

To Remove Bushing:

1. Loosen and remove all capscrews.

2. For **Standard Mount**, install capscrews into tapped holes in mating part to jack against bushing flange.
For **Reverse Mount**, install special thread length capscrews into tapped holes in bushing flange to jack against mating hub.Tighten bolts evenly and progressively in rotation to separate the two components.

3. Loosen setscrew to slide bushing from shaft.

Standard Mounting

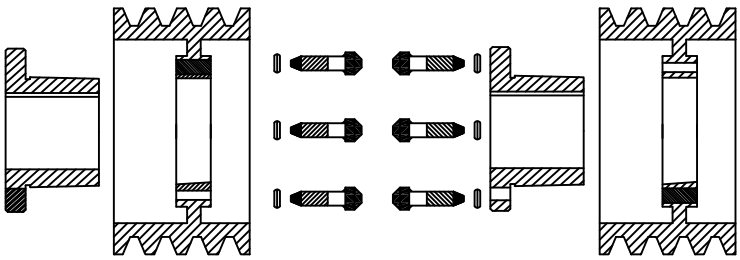

Fig. 1

Reverse Mounting

Fig. 2

Screw Tightening Information

Tapered Bushing	Size & Thread of Capscrew	Ft.Lbs To Apply With Torque Wrench
QT	1/4-20	9
JA	No. 10- 24	5
SH-SDS-SD	1/4-20	9
SK	5/16 - 18	15
SF	3/8 - 16	30
E	1/2-13	60
F	9/16 - 12	110
J	5/8 - 11	135
M	3/4 - 10	225
MS	3/4 - 10	150
N	7/8 - 9	300
NS	7/8 - 9	200
P	1 - 8	450
PS	1 - 8	300
W	1-1/8 - 7	600
WS	1-1/8 - 7	400
S	1-1/4 - 7	750
SS	1-1/4 - 7	500

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