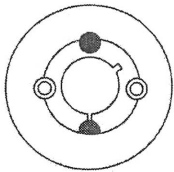
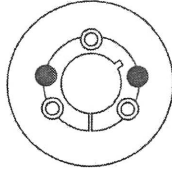


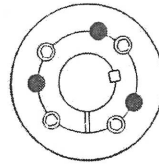
IMPORTANT: Follow all instructions in this manual carefully. This is necessary to insure satisfactory performance.



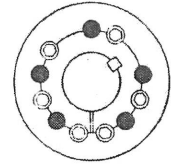
1008 to 3030



3535 to 6050



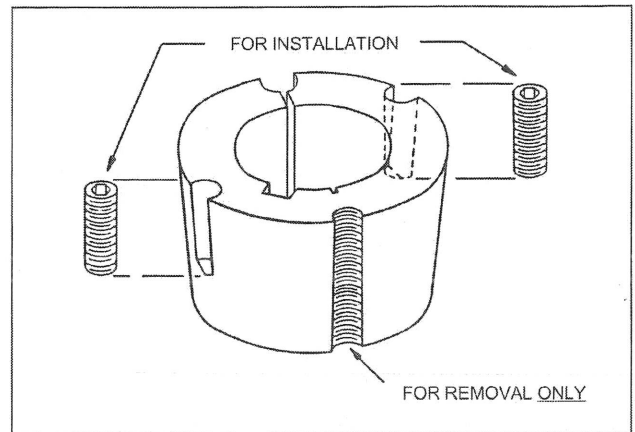
7060 to 10085



120100

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 thus ⊙ in 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 on reverse side.)
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.
6. After drive has been running under load for a short time, stop and check tightness of screws. Fill other holes with grease to exclude dirt.



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 holds that are threaded on bushing side (shown thus ● 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 hub.

Recommended Wrench Torque

Bush Size	1008	1108	1210	1610	1615	2012	2517	3020	3030	3525	3535	4030	4040	4535	4545	5040	5050
Screw Tightening Torque (Nm)	5,6	5,6	20	20	20	30	50	90	90	115	115	170	170	190	190	270	270
Screw Details	Qty	2	2	2	2	2	2	2	2	3	3	3	3	3	3	3	3
	Size (BSW)	¼	¼	⅜	⅜	⅜	½	⅝	⅝	½	½	⅝	⅝	¾	¾	⅞	⅞
	Hex. Socket Size (mm)	3	3	5	5	5	6	6	8	8	10	10	12	12	14	14	14
Large End Dia. (mm)	35,0	38,0	47,5	57,0	57,0	70,0	85,5	108,0	108,0	127,0	127,0	146,0	146,0	162,0	162,0	177,5	177,5
Approx. Mass (kg)	0,1	0,1	0,2	0,3	0,5	0,7	1,5	2,7	3,6	3,8	5,0	5,6	7,7	7,5	10,0	11,1	14,0

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.