

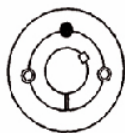
Taper bushing Installation Instructions

Assembly

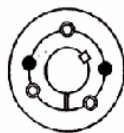
1. Clean contact surfaces and ensure they are free from grease for shaft, taper bushing and taper-bored component.
2. Insert bushing into component and match holes (not threads).
3. Lightly oil screws and insert into holes that are threaded on the component side. Do not tighten yet.
4. Slip bushing and component onto shaft and align in desired position. Note that bushing will grip shaft first and component will move onto bushing. If using a key, fit it in the shaft keyway first. There should be a top clearance between the key and the bushing keyway.
5. Tighten the screws alternately and uniformly in accordance with the recommended torques.
6. Fill the empty holes with grease to prevent corrosion.
7. Check the screw tightening torques after the drive has been operating under load for a short period (half to one hour).

Removal

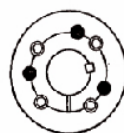
1. Loosen all screws. Remove one or two depending on size, leaving at least one to keep the bushing in the component.
2. Oil thread and insert into jacking off hole(s) on bush.
3. Tighten the screws alternately and uniformly until the bushing disengages.
4. Remove bushing and component from shaft.



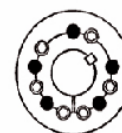
1008 to 3030



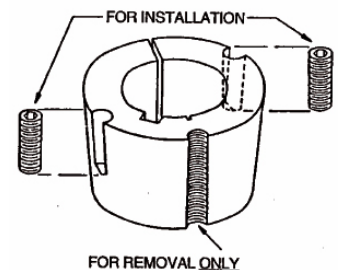
3535 to 6050



7060 to 10085



120100



Recommended Torque Table

Bush Size	Screw Tightening Torque (Nm)	Screw Details	
		Qty	Size (BSW)
1008, 1108	5,6	2	1/4
1210, 1215	20,0	2	3/8
1610, 1615	20,0	2	3/8
2012	30,0	2	7/16
2517, 2525	50,0	2	1/2
3020, 3030	90,0	2	5/8
3525, 3535	115,0	3	1/2
4030, 4040	170,0	3	5/8
4535, 4545	190,0	3	3/4
5040, 5050	270,0	3	7/8
6050, 7060, 8065	880,0	3,4	1 1/4
10085, 120100	1540,0	4,5	1 1/2