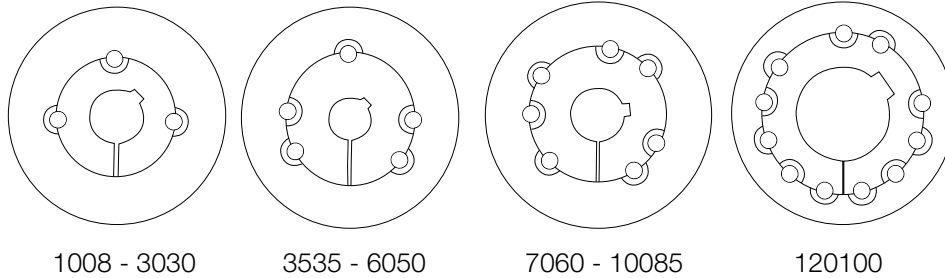



TAPER-LOCK BUSHINGS

Taper-Lock Bushing Installation & Removal




To Install Taper-Lock™ Bushings:

1. Clean shaft, bore and outside of bushing, and bore of hub (taking bushings from hub if already assembled). Remove any oil, grease and dirt.
2. Place hub onto shaft. Slip bushing onto shaft and into hub. Oil threads and points of setscrews or threads and under heads of capscrews. DO NOT lubricate the hub bore or the outside of the bushing. Place screws loosely in holes that are threaded on hub side (shown as  on diagram above).
3. Locate assembly in desired position and tighten screws slightly to seat bushing in hub.
4. Tighten screws alternately and evenly to the fastener torque. Do not overtorque. Using a hammer and drift, hammer against large end of bushing. Hammer first beside the screw farthest from the bushing split and then hammer on the bushing on the opposite side of the screw. Avoid hammering close to the OD of the bushing to prevent damage.

Working towards the split, hammer on the bushing on each side of the setscrews. Then hammer on each side of the bushing split. Make sure that the surfaces on both sides of the split are even. Screws can now be tightened to fastener torque. Repeat sequence, hammering and retightening until the specified fastener torque no longer turns the screws after hammering.

To Remove

1. Remove all screws. Oil threads and points of set screws or threads and under heads of cap screws.
2. Insert screws into holes that are threaded on the bushing side (shown as  on diagram). In sizes where washers are found under the screw heads, be sure to use the washers. Note that one screw in each hub is left over and is not used in the loosening operation.
3. Tighten screws alternately until bushing is loosened in hub. If bushing does not loosen, tap on face of hub.

WARNING: Use NO lubricants on the bushing body or hub bore

Bushing Installation

Bushing Size	Bolts		Fastener Torque	
	Qty.	Size	lb-ft	lb-in
1008-1108	2	1/4-20 Setscrew	4.6	55
1210-1215-1310-1610-1615	2	3/8-16 Setscrew	15	175
2012	2	7/16-14 Setscrew	23	280
2517-2525	2	1/2-13 Setscrew	36	430
3020-3030	2	5/8-11 Setscrew	67	800
3525-3535	3	1/2-13 Setscrew	83	1000
4030-4040	3	5/8-11 Capscrew	142	1700
4535-4545	3	3/4-10 Capscrew	204	2450
5040-5050	3	7/8-9 Capscrew	258	3100
6050	3	1-1/4-7 Capscrew	650	7820
7060-8065	4	1-1/4-7 Capscrew	650	7820
10085	4	1-1/2-6 Capscrew	1140	13680
120100	6	1-1/2-6 Capscrew	1140	13680

Caution: Excessive bolt torque can cause hub and/or bushing breakage.

Note: To insure proper bushing/hub performance, full bushing contact on the shaft is recommended.