



POWER DRIVE LLC

# SPLIT TAPER BUSHINGS

## INSTALLATION INSTRUCTIONS

1. Wipe bushing barrel, bushing bore and shaft clean with a soft dry cloth. Remove paint & other foreign material from bore of mating part. Do not lubricate bushing, bore of mating part, shaft or capscrews.
2. Put bushing loosely into hub. Start capscrews by hand, turning them just enough to engage threads. Do not use a wrench at this time.
3. Slide assembly onto shaft. Line up drive components.
4. Tighten capscrews progressively with a torque wrench until each has been tightened to correct torque. (see table 1)

### WARNING

Do not attempt to pull bushing flange flush with hub end; some gap must remain between flange and hub after tightening. Product should be guarded to confirm to OSHA standards.

### TO REMOVE FROM SHAFT:

Remove capscrews and insert them in tapped holes in bushing flange. Tighten progressively until bushing disengages. Remove assembly from shaft.

## TIGHTENING TORQUES

TABLE 1

Bushing	SAE Grade 5 Cap Screw		Cap Screw Torque			Set Screw Size	Set Screw Torque		
	No.	Size	(In-Lbs)	(Ft-Lbs)	(N-M)		(In-Lbs)	(Ft-Lbs)	(N-M)
G; H	2	1/4-20NC	95	8	10.7	—	—	—	—
P; B	3	5/16-18NC	192	16	21.7	—	—	—	—
Q	3	3/8-16NC	348	29	39.3	5/16-18NC	165	13.8	18.6
R	3	3/8-16NC	348	29	39.3	5/16-18NC	165	13.8	18.6
S	3	1/2-13NC	840	70	94.9	3/8-16NC	290	24.2	32.8
U	3	5/8-11NC	1680	140	189.8	3/8-16NC	290	24.2	32.8
W	4	3/4-10NC	3000	250	339.0	1/2-13NC	620	51.7	70.1
YO	4	1-8NC	7200	600	813.5	1/2-13NC	620	51.7	70.1

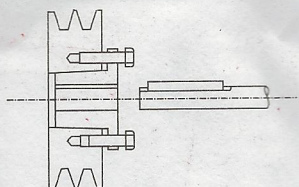


ILLUSTRATION 1A--S/T ASS'Y  
FLANGE INBOARD

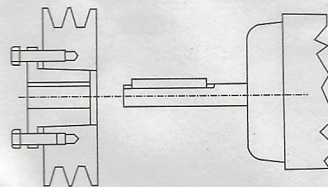
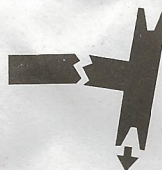


ILLUSTRATION 1B--S/T ASS'Y  
FLANGE OUTBOARD



### ⚠ WARNING

Disconnect power before installation and maintenance. Failure to do can result in severe injury or death.



### ⚠ CAUTION

To avoid damage, supporting structure including shafts and bearings must be designed to handle transmitted loads and belt tension(s).