



# TAPER BUSH INSTALLATION INSTRUCTIONS

## TO ASSEMBLE:

1. Clean and degrease the bore and surfaces of the bush and tapered bore of the hub. Insert the bush into the hub and line up the holes (half thread holes must line up with half unloading holes).
2. Lightly oil the grub screws and screw in but do not tighten yet.
3. Clean and degrease the shaft. Fit the hub with taper bush on the shaft and place in desired position.
4. When using a key, it should be first fitted in the shaft keyway. There should be a top clearance between the key and keyway bore.
5. Gradually tighten the screws in accordance with the torques in the table.
6. When the drive has been operating under load for a short period of time, check and ensure that the screws remained at the appropriate tightening torque.

## TO REMOVE:

1. Loosen and remove all screws and place them in the holes of the bushing.
2. Tighten the screws alternatively till the hub's grip on the bush is loosened. The inner bore of the bushing can be slid on the shaft.
3. Remove the bush from the shaft.

<b>TAPERLOCK BUSH</b>	<b>SCREW TIGHTENING TORQUES (Nm)</b>	<b>SCREW QUANTITY</b>	<b>SCREW SIZE</b>
<b>1008</b> <b>1108</b>	5.6	2	1/4 BSW
<b>1210</b> <b>1215</b>	20	2	3/8 BSW
<b>1310</b> <b>1315</b>	20	2	3/8 BSW
<b>1610</b> <b>1615</b>	20	2	3/8 BSW
<b>2012</b>	31	2	7/16 BSW
<b>2517</b>	48	2	1/2 BSW
<b>3020</b> <b>3030</b>	90	2	5/8 BSW
<b>3535</b>	112	3	1/2 BSW
<b>4030</b> <b>4040</b>	170	3	5/8 BSW
<b>4545</b>	192	3	3/4 BSW
<b>5050</b>	271	3	7/8 BSW