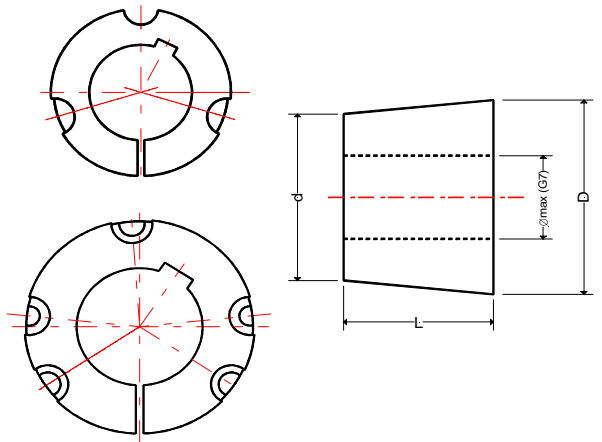


Type	Bush				Hub			Tightening d x l x sw BSW x mm
	∅ max	L	D	d	GG	St		
1008	25	20,3	35,20	32	55	49	2 socket set screws	$1/4 \times 1/2 \times 3$
1108	28	20,3	38,38	36	60	52		
1210	32	25,4	47,62	44	80	73		$3/8 \times 5/8 \times 5$
1215	32	38,1	47,62	42	73	67		
1310	35	25,4	50,80	47	85	76		
1610	42	25,4	57,15	54	90	82		
1615	42	38,1	57,15	52	82	76		
2012	50	30,5	69,85	66	110	98		
2517	65	43,2	85,73	80	125	111		$1/2 \times 1 \times 6$
2525	50	63,5	85,73	77	120	110		
3020	75	50,8	107,95	101	155	143	$5/8 \times 1 1/4 \times 8$	
3030	75	76,2	107,95	97	146	137		
3525	100	63,5	127,00	118	178	165	3 head screws	$1/2 \times 1 1/2 \times 10$
3535	90	89	127,00	115	178	165		
4030	115	76,2	146,05	135	215	197		$5/8 \times 1 3/4 \times 12$
4040	100	101	146,05	132	215	197		
4535	125	89	161,93	150	240	222		$3/4 \times 2 \times 14$
4545	110	114	161,93	146	240	222		
5040	125	101	177,80	164	265	241		$7/8 \times 2 5/16 \times 14$
5050	125	127	177,80	160	265	241		
6050	150	127	235	217	432	350		



Installation instructions for taper bushes

To assemble :

1. Clean and degrease the bore and taper surfaces of the bush and the tapered bore of the pulley. Insert the bush in the pulley hub and line up the holes (half thread holes must line up with half straight holes).
2. Lightly oil the socket set screws (bush size 1008 to 3030) or the head screws (bush size 3525 to 6050) and screw them in, do not tighten yet.
3. Clean and degrease the shaft. Fit pulley with taper bush on shaft and locate in desired position.
4. When using a key it should first be fitted in the shaft keyway. There should be a top clearance between the key and the keyway in the bore.
5. Using a hexagon socket wrench (DIN 911) gradually tighten the socket set/head screws in accordance with the torques as listed in the schedule of screw tightening torques.
6. When the drive has been operating under load for a short period ($1/2$ to 1 hour) check and ensure that the screws remain at the appropriate tightening torque.
7. In order to eliminate the ingress of dirt fill all empty holes with grease.

Removal :

1. Slacken all screws. Depending on the size of the bush remove one or two. After oiling point and thread of socket set screws or under head and thread of head screws insert them into the jacking off hole(s) in bush.
2. Tighten screw(s) uniformly and alternately until the bush is loose in the hub and pulley is free on the shaft.
3. Remove pulley / bush assembly from shaft.