



MTL BUSHING INSTALLATION INSTRUCTIONS

WARNING:

DISCONNECT AND LOCK OUT/TAG OUT POWER BEFORE INSTALLATION AND REMOVAL . FAILURE TO DO SO CAN RESULT IN SEVERE INJURY OR DEATH. ALWAYS FOLLOW ALL OSHA RULES. BELT/COUPLING GUARDS MUST BE INSTALLED IN ACCORDANCE WITH OSHA STANDARDS WHEN THE DRIVE IS IN OPERATION.

INSTALLATION PROCEDURE

1. Clean shaft, bore of bushing, outside tapered surface of bushing, and the bore of the item that the bushing will be mounted into to ensure that all these surfaces are free of oils and debris. **DO NOT USE LUBRICANTS ON THE BUSHING OR SURFACES. USE OF LUBRICANTS WILL MULTIPLY THE FORCES ON THE HUB AND CAN CAUSE IT TO FAIL. USE OF LUBRICANTS VOIDS ALL WARRANTIES.**
2. Insert the bushing into the hub. Match the hole patterns in the figures below for the bushing size that you have. The non-threaded half holes on the bushing will line up with the threaded half holes on the hub.
3. Hand tighten the setscrews (cap screws on larger sizes) into the hole that has the treaded half hole in the hub.
4. With the keystock on the shaft, position assembly loosely onto the shaft aligning the keyway on the bushing with the keystock on the shaft.
5. Line up the sheave assembly and tighten cap screws evenly and progressively to the torque value listed in the table. Do not use worn hex wrenches as this may damage the set screw and may not seat the bushing properly resulting in insufficient gripping power. Torquing beyond these values will cause excessive pressure on the hub and may cause the hub to crack. **OVER TORQUING THE BUSHING CAN CAUSE THE HUB TO FAIL. OVER-TORQUING THE BUSHING WILL VOID THE WARRANTY.**
6. To increase the bushing holding force, tap the face of the bushing lightly using a sleeve (do not strike the bushing directly with a hammer or single point tool like a screwdriver).
7. Re-torque the bushing evenly according to the procedure in step 5.
8. Recheck screw torques after an initial run-in period. Periodic checking of the setscrews is recommended.

INSTALLATION WRENCH TORQUE

BUSHING	SETSCREW (CAPSCREW*)	
	SIZE	IN-LB
1008-1108	1/4 inch	55
1210, 1215, 1310, 1610, 1615	3/8 inch	175
2012	7/16 inch	280
2517-2525	1/2 inch	430
3020-3030	5/8 inch	800
3525-3535	1/2 inch*	1000
4030-4040	5/8 inch*	1700
4535-4545	3/4 inch*	2450
5040-5050	7/8 inch*	3100
6050-8065	1-1/4 INCH*	7820
10085 - 120100	1-1/2 INCH*	13700

* - SOCKET HEAD CAP SCREWS

REMOVAL PROCEDURE

1. REMOVE all screws.
2. Insert screws into threaded half-holes on the bushing.
3. Tighten screws evenly in progression until part releases from the bushing.

