



## TAPER BUSCHES INSTALLATION INSTRUCTIONS

### TO ASSEMBLE

1. Clean and de-grease 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 grub screws (bush size 1008 to 3030) or the cap screws (bush size 3535 to 5050) and screw them in, do not tighten yet.
3. Clean and de-grease 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 grub/cap screws in accordance with the torques as listed in the schedule of screw tightening torque.
6. When the drive has been operating under load for a short period (half to one 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 grub screws or under head and thread of cap 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.