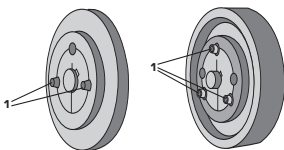


Installation Instructions

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 grub screws (bush size 1008-3030) or the cap screws (bush size 3535-5050) 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's keyway. There should be a top clearance between the key and the keyway in the bore.
- 5)** Using a hexagon socket wrench (Din) gradually tighten the grub/cap screws in accordance with the torques as listed in the table of screw tightening torques.
- 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 torque.
- 7)** In order to eliminate the ingress of dirt fill all empty holes with grease.



Bush	Screw tightening torques (Nm)	Screw	
		Quantity	Size
1008 1108	5.6	2	1/4" BSW
1310 1315	20	2	3/8" BSW
1210 1215	20	2	3/8" BSW
1610 1615	20	2	3/8" BSW
2012	31	2	7/16" BSW
2517	48	2	1/2" BSW
3020 3030	90	2	5/8" BSW
3535	112	3	1/2" BSW
4040	170	3	5/8" BSW
4545	192	3	3/4" BSW
5050	271	3	7/8" BSW

Removal

- 1)** Slacken all screws. Depending on the size of the bush remove one or two. After oiling the 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.