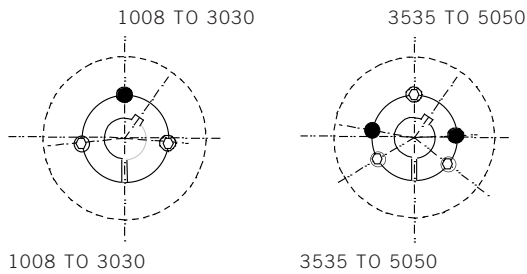



TAPER BUSHING APPLICATION GUIDE

INSTRUCTIONS

At Moline, our goal is to provide you with the most reliable products, helpful service, and expert support. We work to make our instruction sheets clear and easy to understand. But if you have further questions, please contact us directly.



TO INSTALL

1. Clean shaft, bore and outside of bushing, and bore of hub (taking bushing from hub if already assembled). Remove any oil, lacquer or dirt. Place bushing in hub and match half holes to make complete holes (each complete hole will be threaded one side only).
 2. Oil thread and point of set screws or thread and under head of cap screws. Place screws loosely in holes that are threaded on hub side—as shown in diagrams below and above.
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3. Make sure bushing is free in hub. Slip assembly onto shaft and locate in position desired.
 4. Tighten screws alternately and evenly until all are pulled up very tightly. Use a piece of pipe on wrench to increase leverage. (see table for wrench torque)
 5. The screws go into the blind holes in the bushing that are threaded in the installed component.
 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.


IMPORTANT!

Do not use lubricants or anti-seize compounds on tapered bore or bushing surfaces.

Recommended Wrench Torque

TAPER BUSHING	SET SCREWS	WRENCH LENGTH (IN - LBS.)
1008	1/4	55
1210	3/8	175
1610	3/8	175
2012	7/16	280
2517	1/2	430
3020	5/8	800
3030	5/8	800
3535	1/2	1000
4040	5/8	1700
4545	3/4	2450
5050	7/8	3100

TO REMOVE

1. Remove all screws. Oil thread and point of set screws or thread and under head of cap screws.
 2. Insert screws in holes that are threaded on bushing side (shown above in diagram and represented as the black circle below). Note that one screw is left over and is not used in this loosening operation as shown in diagrams above.
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3. Tighten screws alternately until bushing is loosened in hub. If bushing does not loosen immediately, tap on hub.

