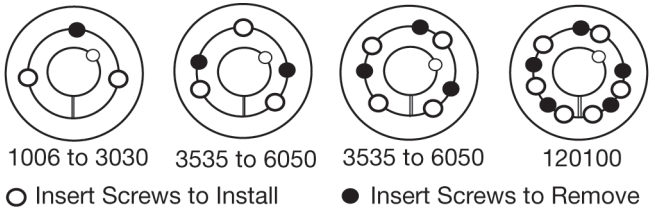
TAPER-LOCK® Bushings

These instructions must be read thoroughly before installation or operation.

WARNING: To ensure that drive is not unexpectedly started, turn off and lock out or tag power source before proceeding. Failure to observe these precautions could result in bodily injury.

INSTALLATION:



1. Clean shaft, bore of bushing, outside of bushing and hub bore of all oil, paint and dirt. File away burrs.
2. Insert bushing into hub. Match the hole pattern, not threaded holes (each complete hole will be threaded on one side only).
3. "LIGHTLY" oil setscrews and thread into those half-threaded holes indicated by ○ on above diagram.

   CAUTION: Do not lubricate the bushing taper, bushing bore, hub taper or the shaft. Doing so could result in breakage of the product.

4. Position assembly onto shaft allowing for the small axial movement which will occur during lightening procedure.
5. Alternately torque setscrews to recommended torque setting in chart below.

   CAUTION: Do not use worn hex key wrenches. Doing so may result in a loose assembly or may damage screws.

6. To increase gripping force, lightly hammer face of bushing using drift or sleeve. (Do not hit bushing directly with hammer.)
7. Re-torque screws after hammering.

   CAUTION: Where bushing is used with lubricated products such as chain, gear or grid couplings be sure to seal all pathways (where lubrication could leak) with RTV or similar material.

8. Recheck screw torques after initial run-in, and periodically thereafter. Repeat steps 5, 6 and 7 if loose.

WARNING: Because of the possible danger to person(s) or property from accidents which may result from the improper use of products, it is important that correct procedures be followed: Products must be used in accordance with the engineering information specified in the catalog. Proper installation, maintenance and operation procedures must be observed. The instructions in the instruction manuals must be followed. Inspections should be made as necessary to assure safe operation under prevailing conditions. Proper guards and other suitable safety devices or procedures as may be desirable or as may be specified in safety codes should be provided, and are neither provided by Baldor Electric nor are the responsibility of Baldor Electric. This unit and its associated equipment must be installed, adjusted and maintained by qualified personnel who are familiar with the construction and operation of all equipment in the system and the potential hazards involved. When risk to persons or property may be involved, a holding device must be an integral part of the driven equipment beyond the speed reducer output shaft.

DODGE®

TO REMOVE:

1. Remove all screws.
2. Insert screws in holes indicated by ● on drawing. Loosen bushing by alternately tightening screws.

NOTE: If two bushings are used on the same component and shaft, fully tighten one bushing before working on another. When installing bushing in sintered steel product (sheave,coupling, etc.) follow torque recommendation shown on product hub if present.

Recommended Installation Wrench Torque		
Bushing No.	Lb.-In.	Nm
1008 1108 1210 1215 1310 1610 1615	55 55 175 175 175 175 175	6,2 6,2 19,9 19,9 19,9 19,9 19,9
2012 2517 2525 3020 3030	280 430 430 800 800	31,8 48,8 48,8 90,8 90,8
3525 3535 4030 4040 4535 4545	1000 1000 1700 1700 2450 2450	114 114 193 193 278 278
5040 5050 6050 7060 8065 10085 12010	3100 3100 7820 7820 7820 13700 13700	352 352 888 888 888 1556 1556

NOTE: When using TAPER-LOCK bushings with conveyor pulleys, refer to the DODGE Instruction Manual for TAPER-LOCK, H.E. , and QD Conveyor Pulley Bushings.

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