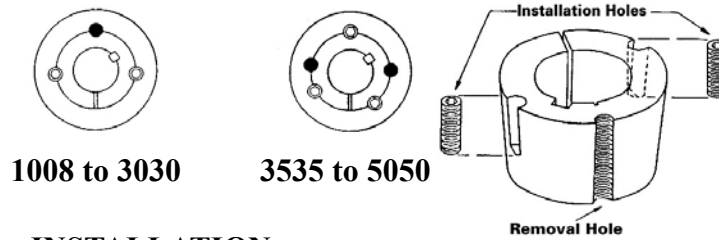


TB BUSHINGS INSTALLATION



INSTALLATION

1. Properly clean shaft, bore and taper surface of bushing. Remove or degrease any oil, paint or dirt.
2. Install the bushing into the pulley hub. Be sure to match the hole pattern, not the threaded holes. Match the half threaded holes with the half straight holes (a complete hole will be threaded on one side only.)
3. Lightly oil the set screws (1008 to 3030) or the cap screws (3525 to 5050), be sure to oil under the cap screw head. Install the screws into the holes that are threaded on the hub side (shown as ● in diagram). DO NOT LUBRICATE THE BUSHING TAPER OR BORE. BREAKAGE OF PRODUCT MAY OCCUR.
4. Fit the pulley with the bushing onto the shaft and locate in the proper location. Install key into the keyway of the shaft and bushing.
5. Tighten screws alternately and gradually in accordance with the torques listed on the Recommended Wrench Torque chart.
6. Using a hammer with a block or sleeve (do not hit bushing directly with hammer) tap on large end of the bushing and re-tighten screws per the appropriate Wrench Torque Values.
7. Fill screw heads with grease to eliminate dirt build up.

REMOVAL

1. Remove all screws and lightly oil the point and threads. Oil under cap screws if used.
2. Install screws into the holes that are threaded only on the bushing side (shown as ● in diagram).
3. Tighten screws uniformly and alternately until the bushing is loose from in the hub and pulley is free from the shaft. Tap on small end of bushing to assist removal if it does not loosen. Note: One screw is not used for removal.

Recommended Wrench Torque			
Bushing #	Lb-In	Nm ²	Set Screw Hex Size
1008, 1108	53	6	1/8"
1210, 1215	176	20	3/16"
1310	176	20	3/16"
1610, 1615	176	20	3/16"
2012	273	31	7/32"
2517, 2525	422	48	1/4"
3020, 3030	790	90	5/16"
3535	986	112	3/8"
4040	1,670	190	1/2"
4545	2,380	270	5/8"
5050	3,080	350	3/4"

Note: The Metric System does not refer to the keyseat or keyway dimensions as does the English System. Instead dimensions are given for the key itself which is rectangular in shape *Not Square* as in the English System. Ordering Example: (1008-14MM) or (4545-105MM)