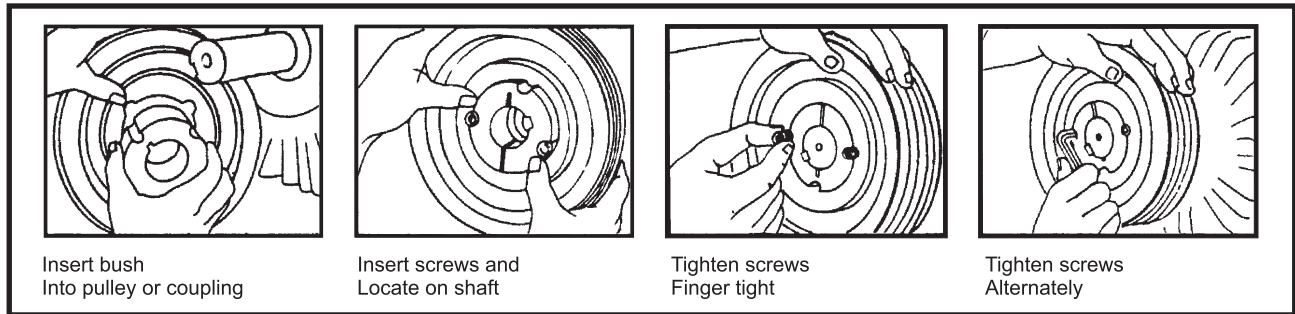


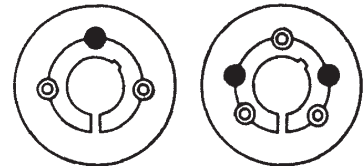
Fenner Taper-Lock® Bushes

Installation Instructions



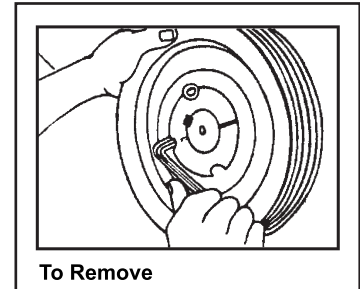
TO INSTALL

1. Remove the protective coating from the bore, outside of bush and bore of hub. After ensuring that the mating tapered surfaces are completely clean and free from oil and dirt, insert bush in hub, so that the holes line up.
2. Oil thread and point of grub screws, or thread and under-head of cap screws. Place screws loosely in holes threaded in hub, shown thus @ in diagram.
3. Clean shaft and fit hub and bush to shaft as one unit. Locate in position desired, remembering that the bush will grip the shaft first and then the hub will be slightly drawn on to the bush.
4. Using a hexagon wrench tighten screws gradually and alternately until they are fully secured. Use a piece of pipe on wrench to increase leverage.



TO REMOVE

1. Slacken all screws by several turns. Remove one or two according to number of jacking-off holes, shown thus • in diagram. Insert screws in jacking off holes after oiling thread and point of grub screws or thread and under-head of cap screws.
2. Tighten screws alternately until bush is loosened in the hub and assembly is free on the shaft.
3. Remove assembly from shaft.
5. For normal drives a key is unnecessary. But when a key is not used hammer against large end of bush using a block or sleeve to prevent damage. (This will ensure that the bush is seated squarely in the bore). Screws will now turn a little more. Repeat this alternate hammering and screw tightening once or twice until correct tightening torque is obtained.
6. If a key is to be fitted, place it in the shaft keyway before fitting the bush. It is essential that only a side-fitting parallel key with TOP CLEARANCE be used.
7. After drive has been running under load for a short time stop and check tightness of screws.
8. Fill empty holes with grease to exclude dirt.



Bush		1008 1108	1310	1210 1215	1510 1615	2012	2517 2525	3020 3030	3525 3535	4040	4545	5050
Screw tightening torque	(Nm.)	56	20	20	20	31	48	90	113	170	192	271
Screw	Qty.	2	2	2	2	2	2	2	3	3	3	3
Details	Size (BSW)	1/4"	3/8"	3/8"	3/8"	7/16"	1/2"	5/8"	1/2"	5/8"	3/4"	7/8"