

# TAPER-LOCK AND BUSHINGS

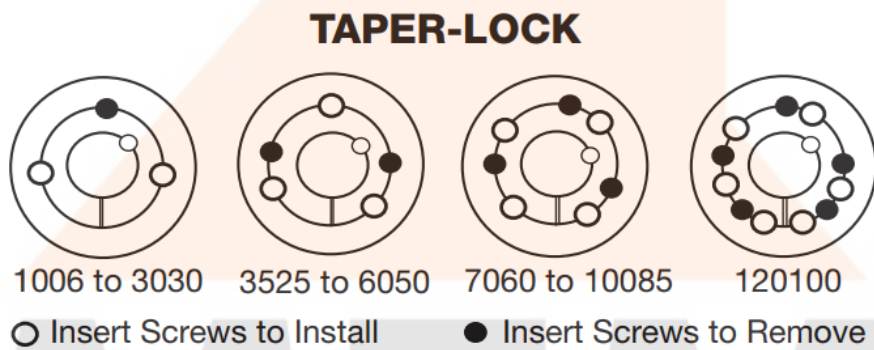
## INSTRUCTION MANUAL

### INSTALLATION/REMOVAL

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This procedure provides general direction and guidelines for the installation, operation, and storage of conveyor pulley bushing.

#### TAPER-LOCK



#### Installation

1. Determine the bushing size by identification on the face of the bushing.
2. Clean the shaft, bore and outer surface of the bushings, and bore of the hubs (take the bushings from the hubs if it has already been assembled). Remove any oil, grease and dirt.
3. Slip the shaft into the pulley hubs and bushings onto the shaft then into the hubs (Shaft → Pulley hubs then Bushings → Shaft and Hubs). Place the screws loosely in holes that are threaded on the hub side (shown as O on the diagram).
4. Allocate the shaft in desired position and tighten screws in each bushing slightly to seat bushings in the hubs.
5. Tighten the screws alternately and evenly in one bushing only until all the screws are pulled up to the proper torque listed in the Table.
6. Hammer against the large end of bushing. Hammer first beside the screw farthest from the bushing split and then hammer on the bushing on the opposite side of screw. Avoid hammering close to the outer diameter of the bushing to prevent damage.
7. Working toward the split, hammer on the bushing on each side of each screw, then hammer on each sides of the bushing split. Make sure that the surfaces on both sides of the split are even.

8. screws can now be tightened a little more the torque wrench.
9. Repeat alternating, hammering, and retightening until the torque wrench can no longer turn the screw after hammering.
10. Check to make sure the surfaces on both side of the split are even. Fill all other holes with grease to exclude dirt. If the key seated bushing is used without a key, use a fluid resistant material to prevent moisture from filling in the key seat until a key is found.
11. Tighten the second bushing as per Step 5 – 10.

## Removal

1. Remove all the screws on the bushing.
2. Insert screw(s) into the holes that are threaded on the bushing side (Shown as • on the diagram).  
**Note: One screw in each hub is left over and is not used in the removal process.**
3. Tighten the screw(s) alternatively until the bushings are loosened in the hubs. If bushing does not loosen, tap on the face of the hub.

	Bushing Type	Screw		Torque			Hammer Size (TL Only)
		Qty	Size (inches)	Nm	Lb-ft	In/lb	
TL	1008, 1108	2	1/4-20 NC	5.9	4.4	55	6 LB
	1210, 1215, 1310, 1610, 1615	2	3/8-16 NC	18.9	14	175	6 LB
	2012, 2017	2	7/16-14 NC	29.8	22.4	280	6 LB
	2517, 2525	2	1/2-13 NC	46.6	34.4	430	6 LB
	3020, 3030	2	5/8-11 NC	88.1	65	800	6 LB
	3525, 3535	3	1/2-13 NC	108.4	80	1000	12 LB
	4030, 4040	3	5/8-11 NC	184.3	136	1700	12 LB
	4535, 4545	3	3/4-10 NC	265.7	196	2450	12 LB
	5040, 5050	3	7/8-9 NC	336.2	248	3100	12 LB
	6050, 6060	3	1-1/4-7 NC	848.2	625.6	7820	20 LB

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