Instruction Manual for PTI Taper Bushings

Assembly

Warning: To ensure that the drive is not unexpectedly started, turn off and lockout the power source before proceeding. Failure to observe these precautions could result in bodily injury.

1. Clean shaft and tapered surfaces of the bushing and the tapered bore of the drive product thoroughly. Insert the bushing into the bore of the pulley, coupling hub or drive hub and line up the holes. (The half thread holes must line up with the straight holes. **Note: the holes in the hub, pulley or sheave which contain half threads are used to tighten the bushing to the shaft, and the half threaded hole(s) in the bushing is used to remove the bushing.**

2. Lightly oil the oval point setscrews (bushing sizes 1008 to 3030), or cap screws for bushing sizes (3535 to 5050), screw them in, but do not tighten yet.

3. Locate the hub, pulley or sheave in the desired location, being sure to install a key in the shaft key-way if a keyway is provided. There should be a small top clearance between the top of the key and the keyway in the bore

4. Use a hex socket wrench to gradually tighten the set screw or cap screw according to chart 1.

5. After the drive has operated for approx. 30-60 minutes under load, check to ensure that the screws remain at the appropriate tightening torque.

6. In order to keep dirt or other contaminants out of bushing holes, fill all empty holes with grease**.**

Removal

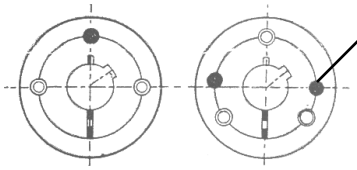
1. Loosen all screws. Depending on the size of the bushing remove one or two screws. Oil the screws that were just removed and insert them into the bushing removal holes. (The removal holes have half threads on the bushing side and the larger bushings 3030 and larger have two removal screw locations).

2. Tighten screw(s) uniformly and alternately until the bushing is loose in the hub, pulley or sheave and on the shaft.

3. Remove the bushing and hub, pulley or sheave assembly from the shaft.

Bushing	Screw Torque		Qty	Size
	N-m	Ft-lbs		
1008 & 1108	5.7	5	2	1/4-20
1210, 1610 & 1615	20	15	2	3/8-16
2012	31	23	2	7/16-14
2517	49	37	2	1/2-12 BSW or 1/2-13 UNC
3020. 3030	92	70	3	5/8-11
3535	115	85	3	1/2-12 BSW or 1/2-13 UNC
4040	172	130	3	5/8-11
4545	195	146	3	3/4-10
5050	275	200	3	7/8-9

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 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 P.T. International, nor are the responsibility of P.T. International. This unit and associated equipment in the system must be installed, adjusted and maintained by qualified personnel who are familiar with the construction and operation of all equipment and in the system and the potential hazards involved. When risk to persons or property may be invoked, a holding device must be an integral part of the driven equipment beyond the speed reducer output shaft.



ISO-9001 Certified

P.T. International Corp.
1817 Westinghouse Blvd.
P.O. Box 411244 (28241)
Charlotte, NC 28273

Ph: 704-588-1091 Fax: 704-588-5738