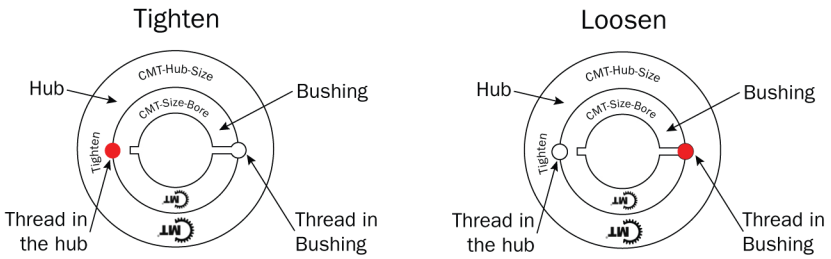
Assembly Instructions



TO TIGHTEN: insert bushing in hub as shown with half threaded hole in hub aligned with half plain hole in bushing. Insert set screw and torque to recommended value.	**TO LOOSEN:** insert set screw in hole opposite tightening position and torque until bushing breaks free from hub.

WARNING: Before working on any machinery be sure proper lockout and tag out procedures have been followed. Failure to follow these procedures may result in serious bodily injury.

TO INSTALL

Clean shaft, bore of bushing, outside of bushing and hub bore of all oil, paint and dirt. Make sure there are no sharp edges and remove all burrs.

> CAUTION: Do not lubricate any of the components during assembly. Doing so may result in less than desirable results and possible breakage of the components. All parts should slide together without lubrication.

Insert the bushing in the hub so that one half of a threaded hole lines up with one half of a non threaded hole in the mating part.

Insert the supplied set screw into the hole that has the threads on the hub component. This hole is opposite the half threaded bushing hole with the slit in it.

> CAUTION: Only use the set screw that is supplied with the bushing. It has been specifically designed and machined to work in the bushing system. Failure to use the correct screw may prevent the components from being disassembled or achieving the proper holding torque.

Tighten the set screw loosely until the two components come together and then back the screw off two full turns. The bushing should be free to float in the hub but will not fall out.

Screw Size	in-lbs*	Nm*
M2.5	6.0	.68
M3	9.0	1.00
M4	19.0	2.10
M5	42.0	4.70
M6	68.0	7.70
M8	158.0	17.80

*Maximum torques

Position the assembly on the shaft in its approximate final location. Tighten the set screw loosely until the bushing begins to grip the shaft. Move the component to its final axial and rotational position and finish tightening the set screw to the recommended tightening torque in the chart below to provide the drive torque.

> CAUTION: The shaft must be of proper size and tolerance (h6), for the bushing bore (H7) being used. Failure to assure the proper size shaft is being used could result in component failure, reduction of holding torque, or the inability to assemble the components.

*Do not over tighten the set screw. Over tightening will not necessarily produce more torque, but it could deform the components, cause problems disassembling the components, and may cause component failure.

Recheck set screw torque after initial run in and periodically thereafter. Retighten if necessary.

TO REMOVE

Remove the set screw from the assembly hole and reinsert it in the hole opposite the assembly hole.

Continue turning the screw with a hex wrench until the bushing is pushed out of the hub thereby releasing it from the shaft. This may require torques greater than the installation torque.

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 the correct procedures be followed. Products must be used in accordance with their engineering information in the catalog. Proper installation, maintenance and operation procedures and instructions 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. Such devices are neither provided by Custom Machine & Tool Co., Inc. nor are the responsibility of Custom Machine & Tool Co., Inc. This product must be installed, adjusted and maintained by qualified personnel who are familiar with the construction and operation of all equipment in the system and potential hazards involved.