

LYNX PRODUCTS CORP.
TAPER-LOCK® BUSHING INSTRUCTIONS

Warning:

To prevent bodily injury due to unexpected starting of the drive, turn off or lock out power source before installation is to occur.

Installation:

Note: Follow all instructions carefully to ensure satisfactory performance of both pulley and bushings. **For factory installed shafts, retighten the cap screws with a torque wrench set at the proper value shown in Table 1.**

Prior to installation, ensure the following components are free of grease and debris:

- Surface of shaft
- Bore of the bushing
- Tapered inside diameter of the Taper-Lock hub
- Tapered outside diameter of the Taper-Lock bushing

Particles left on the mating surfaces may cause improper installation.

Note: DO NOT LUBRICATE MATING SURFACE

1. If pulley is to be keyed to shaft, be certain both shaft and bushing keyways are clean, smooth, and free of burrs. Check key size with both shaft and bushing keyways. Place keys into the shaft keyways. Pulley bushing keyways require alignment of both shaft keyways for proper bushing-to-hub installation.
2. Place shaft in to the pulley, being certain not to damage the bore of the hubs.
3. Lightly oil setscrews and thread into half threaded holes indicated on diagram.
4. Position the assembly onto the shaft. Allow a small amount of axial movement on the shaft for the tightening procedure
5. Slide bushings on to the shaft and into the hubs keeping the holes of the bushings lined up with the holes of the hub. Place the setscrews into the drilled holes of each bushing
6. Position the shaft as desired and alternately tighten the setscrews in each bushing to the specified torque setting recommended in the chart provided.

WARNING: DO NOT USE A WORN HEX KEY WRENCH, AS THIS MAY DAMAGE THE SETSCREWS.

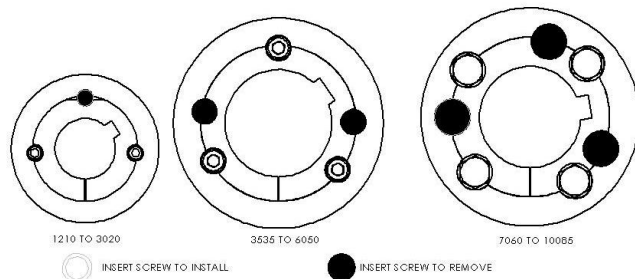


Figure 1

7. For increased gripping force, hammer the face of the bushing using a drift or sleeve (do not hit the bushing directly with hammer as this may damage the bushing)
8. Re-torque setscrews after hammering the bushing.

WARNING: DO NOT LUBRICATE THE BUSHING TAPER, BUSHING BORE, HUB TAPER OR THE SHAFT. THIS MAY RESULT IN BREAKAGE OF THE PRODUCT

Table 1

Bushing No.	Lb.-In*
1210, 1610	175
2012	280
2517	430
3020	800
3535	1,000
4040	1,700
4545	2,450
5050	3,100
6050, 7060, 8065	7,820
10085, 120100	13,700

Note: If 2 bushings are used on same component and shaft-fully tighten one bushing before beginning the other.

***When installing bushing in sintered steel product (sheave, coupling, etc.) follow torque recommendations shown on product hub, if present.**

Maintenance: During the first 30 days of operation, inspect the bushings and set-screws for proper torque and at least once a week and thereafter during periodic shutdowns.

Removal:

1. Remove all set-screws.
2. Insert screws in holes as indicated in Figure 1.
3. Tighten the screws **alternately** and **evenly** in one bushing only. If the bushing does not loosen immediately, tap on the bushing with a rubber mallet.
4. Remove the bushing from the shaft.