

## INSTRUCTIONS

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### QD Bushing

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At Moline, our goal is to provide you with the most reliable products, helpful service, and expert support. We work to make our instruction sheets clear and easy to understand. But if you have further questions, please feel free to call 800.242.4633 or email [support@molinebearing.com](mailto:support@molinebearing.com). We are here to help.

#### INSTALLATION INSTRUCTIONS

- 1 Be sure the tapered cone surfaces of the bushing and the inside of the sprocket hub are clean.
- 2 Place bushing in sprocket.
- 3 Put the cap screws and lock washers loosely in the pull-up holes. The bushing remains fully expanded to assure sliding fit on the shaft.
- 4 With key on shaft, slide sprocket to the desired position on the shaft. Be sure the heads of the cap screws are on the outside.
- 5 Align the sprocket. Tighten the screws alternately and progressively—until they are pulled up tight. To increase leverage, use a wrench or length of pipe (see wrench torque chart below). Do not allow the sprocket to be drawn in contact with the flange of the bushing; there should be a gap from 1/8 to 1/4 inch.

#### REMOVAL

- 1 Loosen and remove cap screws.
- 2 Insert cap screws in tapped removal holes.
- 3 Tighten inserted screws until sprocket is loose on shaft.
- 4 Remove sprocket from shaft.



#### CAUTION

When mounting screws, apply pressure by hand only. If extreme tightening forces are applied, bursting pressures will be created in the sprocket hub. There should be a gap of 1/8 to 1/4 inch between the face of the sprocket hub and the flange of the QD bushing. **This gap must not be closed.** If the gap is closed under normal tightening, the shaft is seriously undersized.

#### WRENCH TORQUE VALUES FOR TIGHTENING BUSHINGS

Bushing	Wrench Torque	Wrench Length	Wrench Pull
JA	60 pounds	4 inches	15 pounds
SH	108 pounds	4 inches	27 pounds
SDS	108 pounds	4 inches	27 pounds
SD	108 pounds	4 inches	27 pounds
SK	180 pounds	6 inches	30 pounds
SF	360 pounds	6 inches	60 pounds
E	720 pounds	12 inches	60 pounds
F	900 pounds	12 inches	75 pounds
J	1,350 pounds	12 inches	113 pounds
M	1,800 pounds	15 inches	120 pounds
N	2,250 pounds	15 inches	150 pounds
P	3,300 pounds	18 inches	183 pounds

#### BUSHING INSTALLATION TORQUE

When a wrench or length of pipe is used to increase leverage in tightening the bushing screws, it is imperative to adhere to the wrench torque values given in the chart above. Following the recommended torque in mounting the bushing is important because the tightening force on the screws is multiplied many times by the wedging action of the tapered surface. This action compresses the bushing for a snug fit on the shaft. The bushing screws should always be tightened alternately and progressively.



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