

QD BUSHING APPLICATION GUIDE

The QD Type bushing offers flexible and easy installation while providing exceptional holding power. To ensure that the bushing performs as specified, it must be installed properly:

INSTALLATION

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). Do not allow the sprocket to be drawn in contact with the flange of the bushing; there should be a gap from $\frac{1}{8}$ " to $\frac{1}{4}$ ".

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 $\frac{1}{8}$ " to $\frac{1}{4}$ " 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.

QD BUSHING	TORQUE CAP (IN LBS.)	WRENCH TORQUE FOR NORMAL APPLICATION (IN LBS.)
JA	1,000	54
SH	3,500	108
SDS	5,000	108
SD	7,000	108
SK	11,000	180
SF	20,000	360
E	30,000	720
F	30,000	900
J	45,000	1,620
M	85,000	2,700
N	150,000	3,600
P	250,000	5,400

