Sure motion

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3. With the key in the shaft keyway, position the assembly onto the shaft at the desired location. Allow for small axial sprocket movement on bushing during tightening.
4. Alternately torque screws to the recommended torque level specified in the table. Do not over-torque!

Sprocket Installation

Bushing Size	Bolts		Wrench Tools		Torque Wrench	
	Qty.	Size	Type	Size (in)	lb·ft	lb·in
1108	2	1/4-20 x 1/2	Hex	1/8	4.6	55
1210	2	3/8-16 x 5/8	Hex	3/16	14.6	175
1610	2	3/8-16 x 5/8	Hex	3/16	14.6	175
2012	2	7/16-14 x 7/8	Hex	7/32	23.3	280
2517	2	1/2-13 x 1	Hex	1/4	35.8	430

Taper-Lock Type Bushing Removal:

1. Release belt tension and lift belt off of sprocket.
2. Loosen and remove screws securing sprocket to bushing.
3. Insert screws into removal holes.
4. Alternately tighten screw or screws in small but equal increments until sprocket is disengaged from bushing.

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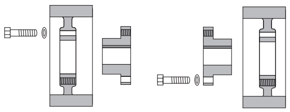

Conventional Mounting **Reverse Mounting**

QD Type Bushing Installation:

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2. Determine the type of mounting that will be used.
3. Conventional Mounting:
   A. Insert key into the shaft keyway
   B. Insert a screw driver blade (or similar) into the bushing flange saw cut to enlarge bore slightly (Caution: excessive enlargement can split bushing).
   C. Slide bushing onto shaft with the flange side towards the equipment. Position bushing and tighten set screw to prevent sliding on shaft.
   D. Place sprocket onto bushing and insert cap screws. Align drilled holes in sprocket hub with tapped holes in bushing flange.
4. Reverse Mounting:
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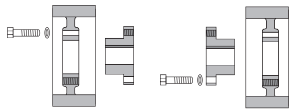

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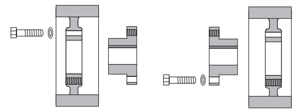

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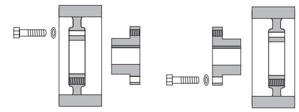

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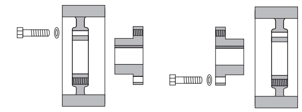

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