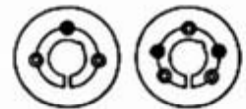


Aecoflex Taper - Lock Bushes

Using Aecoflex Taper-Lock Bushes, it is possible for unskilled labour to achieve 'shrink fit' of Pulleys, Couplings, etc. on to shafts only using a hexagon wrench.

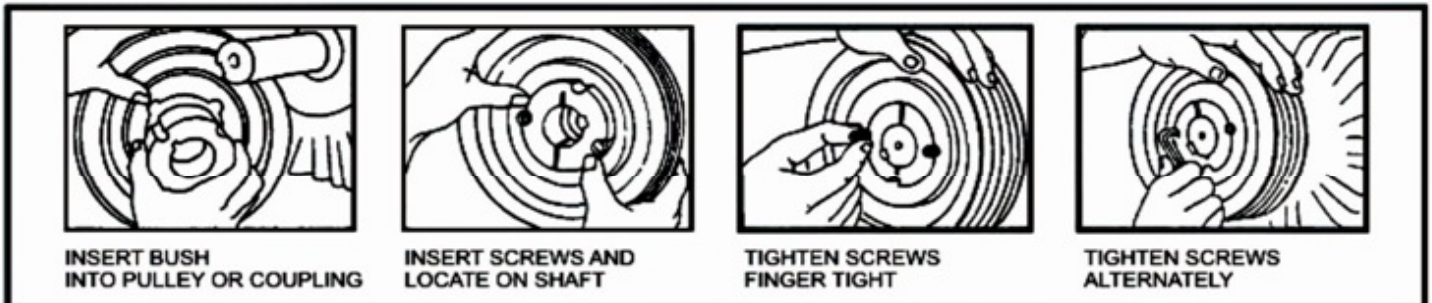


Bush		1008 1108	1310	1210 1215	1610 1615	2012	2517 2525	3020 3030	3525 3535	4040	4545	5050
Screw tightening torque (Nm.)		56	20	20	20	31	48	90	113	170	192	271
Screw	Qty.	2	2	2	2	2	2	2	3	3	3	3
	Size (BSW)	1/4"	3/8"	3/8"	3/8"	7/16"	1/2"	5/8"	1/2"	5/8"	3/4"	7/8"



The benefits of using Taper-Lock® Bushes can be extended to include components which have a parallel bore by incorporating Taper-Lock® Adaptors, Taper-Lock® Bolt-on-Hubs or Taper-Lock® Weld-on-Hubs.

Installation Instructions

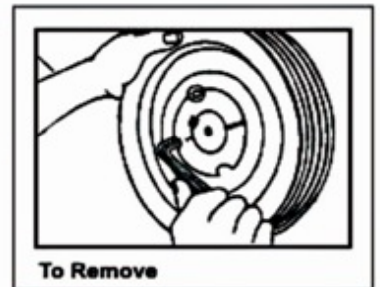


TO INSTALL

1. Remove the protective coating from the bore, outside of bush and bore of hub. After ensuring that the mating tapered surfaces are completely clean and free from oil and dirt, insert bush in hub, so that the holes line up.
2. Oil thread and point of grub screws, or thread and under-head of cap screws. Place screws loosely in holes threaded in hub, shown thus ⊕ in diagram.
3. Clean shaft and fit hub and bush to shaft as one unit. Locate in position desired, remembering that the bush will grip the shaft first and then the hub will be slightly drawn on to the bush.
4. Using a hexagon wrench tighten screws gradually and alternately until they are fully secured. Use a piece of pipe on wrench to increase leverage.

TO REMOVE

1. Slacken all screws by several turns. Remove one or two according to number of jacking-off holes, shown thus ⊖ in diagram. Insert screws in jacking off holes after oiling thread and point of grub screws or thread and under-head of cap screws.
2. Tighten screws alternately until bush is loosened in the hub and assembly is free on the shaft.
3. Remove assembly from shaft.
4. For normal drives a key is unnecessary. But when a key is not used hammer against large end of bush using a block or sleeve to prevent damage. (This will ensure that the bush is seated squarely in the bore). Screws will now turn a little more. Repeat this alternate hammering and screw tightening once or twice until correct tightening torque is obtained.
5. If a key is to be fitted, place it in the shaft keyway before fitting the bush. It is essential that only a side-fitting parallel key with TOP CLEARANCE be used.
6. After drive has been running under load for a short time stop and check tightness of screws.
7. Fill empty holes with grease to exclude dirt.



To Remove

Taper Lock Bush Size	1008	1108	1210	1215	1310	1610	1615	2012	2517	2525	3020	3030	3525	3535	4040	4545	5050	5555
Nominal dia at large end of taper	3.50	38.0	47.5	47.5	51.0	57.0	57.0	70.0	85.5	85.5	108.0	108.0	127.0	127.0	146.0	162.0	177.5	244
Face Width	22	22	25	38	25	25	38	32	45	65	51	76	65	89	102	114	127	175
Minium Bore	0	0	11	11	14	14	14	14	16	10	25	35	48	35	40	55	70	80
Maxium Bore	28	28	32	32	35	42	42	50	60	60	75	75	75	90	90	110	125	160
Boss Dia	60	60	83	83	85	92	92	112	124	124	159	159	178	178	216	242	267	340

Aecoflex Taper - Lock Bushes

METRIC BORES AND KEYWAYS

Bore Dia.	Keyway		Shallow Keyway Depth																	
	Width	Depth		1008 AO	1108 BO	1210 CO	1215 DO	1310 EO	1610 GO	1615 HO	2012 KO	2517 MO	2525 NO	3020 PO	3030 QO	3525 JO	3535 RO	4040 SO	4545 TO	5050 UO
9	3	1.4	-	...009	009															
10	3	1.4	-	...010	010															
11	4	1.8	-	...011	011	011	011													
12	4	1.8	-	...012	012	012	012													
14	5	2.3	-	...014	014	014	014	014	014	014	014									
16	5	2.3	-	...016	016	016	016	016	016	016	016	016								
18	6	2.8	-	...018	018	018	018	018	018	018	018	018	018							
19	6	2.8	-	...019	019	019	019	019	019	019	019	019	019	019						
20	6	2.8	-	...020	020	020	020	020	020	020	020	020	020	020						
22	6	2.8	-	...022	022	022	022	022	022	022	022	022	022	022						
24	8	3.3	1.3	...024*	024	024	024	024	024	024	024	024	024	024						
25	8	3.3	1.3	...025*	025	025	025	025	025	025	025	025	025	025	025					
28	8	3.3	1.3		028*	028	028	028	028	028	028	028	028	028	028					
30	8	3.3	-			030	030	030	030	030	030	030	030	030	030					
32	10	3.3	1.3			032*	032*	032	032	032	032	032	032	032	032					
35	10	3.3	1.3					035*	035	035	035	035	035	035	035	035	035	035		
38	10	3.3	-						038	038	038	038	038	038	038	038	038	038		
40	12	3.3	1.3						040*	040*	040	040	040	040	040	040	040	040	040	
42	12	3.3	1.3						042*	042*	042	042	042	042	042	042	042	042	042	
45	14	3.8	-								045	045	045	045	045	045	045	045	045	
48	14	3.8	-								048	048	048	048	048	048	048	048	048	
50	14	3.8	2.8								050*	050	050	050	050	050	050	050	050	
55	16	4.3	-									055	055	055	055	055	055	055	055	055
60	18	4.4	-									060	060	060	060	060	060	060	060	060
65	18	4.4	-										065	065	065	065	065	065	065	065
70	20	4.9	-										070	070	070	070	070	070	070	070
75	20	4.9	-										075	075	075	075	075	075	075	075
80	22	5.4	-												080	080	080	080	080	080
85	22	5.4	-												085	085	085	085	085	085
90	25	5.4	3.4												090*	090*	090	090	090	090
95	25	5.4	-														095	095	095	095
100	28	6.4	5.4														100*	100	100	100
105	28	6.4	-																105	105
110	28	6.4	-																110	110
115	32	7.4	-																	115
120	32	7.4	-																	120
125	32	7.4	-																	125
Nominal dia at large end of Taper				35.0	38.0	47.5	47.5	51.0	57.0	57.0	70.0	85.5	85.5	108.0	108.0	127.0	127.0	146.0	162.0	177.5
Approx. Mass of Bush (Kg)				0.1	0.1	0.2	0.3	0.3	0.3	0.5	0.7	1.5	1.9	2.7	3.6	3.8	5.0	7.7	10.0	14.0



Dimensions in millimeters

Keyways are British Standard and recommendations except for the bore sizes marked * which are shallower.

Aecoflex Taper - Lock Bushes

IMPERIAL BORES AND KEYWAYS

Bore Dia.	Keyway		Shallow Keyway Depth																	
	Width	Depth		1008	1108	1210	1215	1310	1610	1615	2012	2517	2525	3020	3030	3525	3535	4040	4545	5050
0.375	0.125	0.060	-	0375	0375															
0.500	0.125	0.060	-	0500	0500	0500	0500	0500	0500	0500										
0.625	0.188	0.088	-	0625	0625	0625	0625	0625	0625	0625										
0.750	0.188	0.088	-	0750	0750	0750	0750	0750	0750	0750	0750	0750								
0.875	0.250	0.115	-	0875	0875	0875	0875	0875	0875	0875	0875	0875	0875							
1.000	0.250	0.115	0.052	1000*	1000	1000	1000	1000	1000	1000	1000	1000	1000	1000						
1.125	0.312	0.112	0.064		1125*	1125	1125	1125	1125	1125	1125	1125	1125							
1.250	0.312	0.112	-			1250	1250	1250	1250	1250	1250	1250	1250	1250	1250					
1.375	0.375	0.108	-					1375	1375	1375	1375	1375	1375	1375	1375					
1.500	0.375	0.108	-						1500	1500	1500	1500	1500	1500	1500	1500	1500	1500		
1.625	0.438	0.135	0.103						1625*	1625*	1625	1625	1625	1625	1625	1625	1625	1625		
1.750	0.438	0.135	-								1750	1750	1750	1750	1750	1750	1750	1750	1750	
1.875	0.500	0.131	-								1875	1875	1875	1875	1875	1875	1875	1875	1875	
2.000	0.500	0.131	-								2000	2000	2000	2000	2000	2000	2000	2000	2000	
2.125	0.625	0.185	-									2125	2125	2125	2125	2125	2125	2125		
2.250	0.625	0.185	-										2250	2250	2250	2250	2250	2250	2250	2250
2.375	0.625	0.185	-											2375	2375	2375	2375	2375	2375	2375
2.500	0.625	0.185	0.153											2500*	2500*	2500	2500	2500	2500	2500
2.625	0.750	0.209	-												2625	2625	2625	2625	2625	2625
2.750	0.750	0.209	-												2750	2750	2750	2750	2750	2750
2.875	0.750	0.209	-												2875	2875	2875	2875	2875	2875
3.000	0.750	0.209	-												3000	3000	3000	3000	3000	3000
3.125	0.875	0.264	-													3125	3125	3125	3125	3125
3.250	0.875	0.264	-													3250	3250	3250	3250	3250
3.375	0.875	0.264	-													3375	3375	3375	3375	3375
3.500	0.875	0.264	-													3500	3500	3500	3500	3500
3.750	1.000	0.318	-															3750	3750	3750
4.000	1.000	0.318	-															4000	4000	4000
4.250	1.250	0.366	-																4250	4250
4.500	1.250	0.366	-																4500	4500
4.750	1.250	0.366	-																	4750
5.000	1.250	0.366	-																	5000
Nominal dia at large end of Taper (in mm) .				35.0	38.0	47.5	47.5	51.0	57.0	57.0	70.0	85.5	85.5	108.0	108.0	127.0	127.0	146.0	162.0	177.5
Approx. mass of Bush (kg)				0.1	0.1	0.2	0.3	0.3	0.3	0.5	0.7	1.5	1.9	2.7	3.6	3.8	5.0	7.7	10.0	14.0



Dimensions in inches

Keyways are British Standard and recommendations except for the bore sizes marked * which are shallower.