

Title:

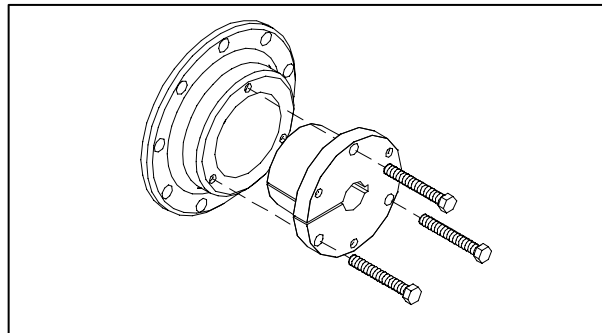
Bushing Installation Instructions

Preparation

1. Using a clean dry cloth, remove any dirt, lubricant, or sediment from the bore, the bushing taper and the tapered fan hub.

Important- Do not use any lubricant or thread locking compound during installation. The use of such products will cause improper bolt torque and will crack the fan hub.

2. Slide the bushing into the tapered bore of the fan hub. Do not press the bushing into place.
3. Place the bushing bolts through the untapped holes of the bushing into the threaded holes of the hub.
- 3a. If there are untapped holes in the hub, the bolts can be placed through the untapped holes of the hub into the threaded bushing holes.
4. Tighten the bushing bolts by hand to hold the bushing loosely in the hub.



Fan Installation

1. Slide the bushing and fan assembly onto the shaft.
2. Insert the key into the keyway. Some bushings are manufactured with a shallow keyway. If a key is included in the bushing package, use the key supplied by the bushing manufacturer.
3. Using a torque wrench, tighten the bushing bolts evenly one half turn until the proper installation torque is achieved. Proper installation torque is listed on the bushing bolt torque chart.
4. Continue tightening until all bolts are at recommended torque.

Do not exceed the torque specification listed on the bushing bolt torque chart. Exceeding the recommended torque will crack the fan hub.

Bushing	Bolt Thread	Bolt Torque Foot - Pounds
JA	10-24	5
G	1/4" - 20	6
H	1/4" - 20	6
SH	1/4" - 20	8
SD	1/4" - 20	9
SDS	1/4" - 20	9
P-1	5/16" - 18	13
SK	5/16" - 18	15
SF	3/8" - 16	23
Q-1	3/8" - 16	29
R-1	3/8" - 16	29

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