

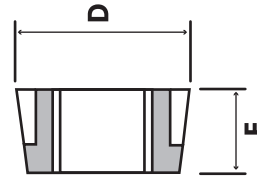
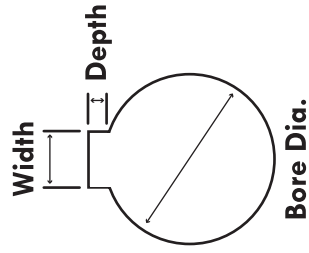


## Features & Benefits

- Manufactured from high grade cast iron
- Slow cooling process increases resistance to cracking and breaking
- Key position fixed in relation to grub screws
- POWERDRIVE bushes are available in Metric and Imperial bores
- Series range from 1008-5050
- All bush surfaces are ground and checked in fit gauges
- Attractively packaged for the aftermarket

**TAPER LOCK BUSHES - IMPERIAL BORES**

**Taper Lock Bush Diagrams:**



Bore Dia.	Keyway		Product Code															
	Width	Depth	TL1008	TL1108	TL1210	TL1215	TL1610	TL1615	TL2012	TL2517	TL3020	TL3525	TL3535	TL4040	TL4535	TL4545	TL5050	
3/8	0.125	0.06																
1/2																		
5/8	0.187	0.09																
11/16																		
3/4																		
7/8	0.250	0.12																
15/16																		
1																		
1 1/8	0.312	0.11																
1 1/4																		
1 3/8	0.375	0.11																
1 1/2																		
1 5/8	0.437	0.13																
1 3/4																		
1 7/8	0.500	0.13																
2																		
2 1/8																		
2 1/4	0.625	0.18																
2 3/8																		
2 1/2																		
2 5/8																		
2 3/4	0.750	0.21																
2 7/8																		
3																		
3 1/8																		
3 1/4	0.875	0.26																
3 3/8																		
3 1/2																		
3 3/4	1.000	0.32																
4																		
F	D		35.0	38.0	47.5	47.5	57	57	70	85.5	108	127	127	146	162	162	177.5	
	(inches)		7/8"	7/8"	1"	1"	1 1/2"	1 1/2"	1 1/4"	1 3/4"	2"	2 1/2"	2 1/2"	4"	3 1/2"	4 1/2"	5"	

**TAPER LOCK BUSHES - METRIC BORES**

Bore Dia.	Keyway		Product Code														D	F			
	Width	Depth	TL1008	TL1108	TL1210	TL1215	TL1610	TL1615	TL2012	TL2517	TL3020	TL3030	TL3525	TL3535	TL4030	TL4040			TL4535	TL4545	TL5040
10	3	1.4																			
11	4	1.8																			
12																					
14	5	2.3																			
15																					
16																					
17																					
18	6	2.8																			
19																					
20																					
22																					
24																					
25	8	3.3																			
26																					
28																					
30																					
32																					
35	10	3.3																			
36																					
38																					
40	12	3.3																			
42																					
45																					
48	14	3.8																			
50																					
55	16	4.3																			
60																					
62	18	4.4																			
65																					
70	20	4.9																			
75																					
80	22	5.4																			
85																					
90	25	5.4																			
95																					
100	28	6.4																			
115																					
120	32	7.4																			
125																					
			35.0	38.0	47.5	47.5	57	57	70	85.5	108	108	127	127	146	146	162	162	177.5	177.5	
			22.2	22.2	25.4	25.4	38.1	38.1	31.75	44.45	50.8	76.2	88.9	88.9	101.6	101.6	114.3	114.3	101.6	127	
		(mm)																			

**TAPER BUSHES - INSTALLATION INSTRUCTIONS**

**To Assemble**

- 1, Clean and de-grease the bore and taper surfaces of the bush and the tapered bore of the pulley insert the bush in the pulley hub and line up the holes (half thread holes must line up with half straight holes)
- 2, Lightly oil the grub screws (bush size 1008 to 3030) or the cap screws (bush size 3535 to 5050) and screw them in, do not tighten yet.
- 3, Clean and de-grease the shaft fit pulley with taper bush on shaft and locate in desired position.
- 4, When using the key it should be a top clearance between the key and the keyway in the bore.
- 5, Using a hexagon socket wrench (DIN911) gradually tighten the grub/cap screws in accordance with the torques as listed in the schedule of screw tightening torque.
- 6, When the drive has been operating under load for a short period (half to one hour) check and ensure that the screws remain at the appropriate tightening torque.
- 7, In order to eliminate the ingress of dirt fill all empty holes with grease.

**Removal**

- 1, Slacken all screws. Depending on the size of the bush remove one or two. After oiling point and thread of grub screws or under head and thread of cap screws insert them into the jacking off hole(s) in bush.
- 2, Tighten screw(s) uniformly and alternately until the bush is loose in the hub and pulley is free on the shaft.
- 3, Remove the pulley bush assembly from shaft.

Bush	Screw tightening Torques (Nm)	Screw	
		Quantity	Size
1008 1108	5.6	2	1/4" BSW
1310 1315	20	2	3/8" BSW
1210 1215	20	2	3/8" BSW
1610 1615	20	2	3/8" BSW
2012	31	2	7/16" BSW
2517	48	2	1/2" BSW
3020 3030	90	2	5/8" BSW
3535	90	3	1/2" BSW
4040	170	3	5/8" BSW
4545	192	3	3/4" BSW
5050	271	3	7/8" BSW