

## Taper Lock® Installation Instructions

### TO INSTALL

1. After ensuring that the mating tapered surfaces, bore and shaft are completely clean and free from oil or dirt, insert bush in hub so that holes line up.
2. Sparingly 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. If a key is to be fitted place it in the shaft keyway before fitting the bush. It is essential that it is a parallel key and side fitting only and has TOP CLEARANCE.
4. Clean shaft and fit hub to shaft as one unit and locate in position desired, remembering that bush will nip the shaft first and then hub will be slightly drawn on to the brush.
5. Using a hexagon wrench tighten screws gradually and alternately to torque shown in table below.
6. 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 to achieve maximum grip on the shaft.
7. After drive has been running under load for a short time stop and check tightness of screws.
8. Fill empty holes with grease to exclude dirt.

Visit [www.fptgroup.com](http://www.fptgroup.com) to view the Taper Lock installation video.



INSERT BUSH



INSERT SCREWS AND LOCATE ON SHAFT



TIGHTEN SCREWS FINGER TIGHT



TIGHTEN SCREWS ALTERNATELY



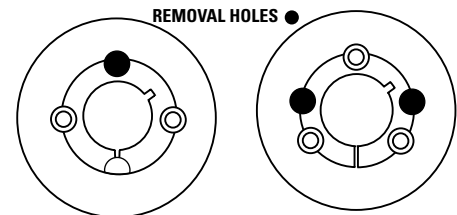
TIGHTEN SCREWS TO THE CORRECT TORQUE SETTING



REMOVAL

### TO REMOVE

1. Slacken all screws by several turns, remove one or two according to number of removal holes shown thus ● in diagram. Insert screws into removal holes after oiling thread and under head of cap screws.
2. Tighten screws alternately until bush is loosened in hub and assembly is free on the shaft.
3. Remove assembly from shaft.



Bush size	1008	1108	1210	1610	1615	2012	2517	3020	3030	3525	3535	4030	4040	4535	4545	5040	5050	
Screw tightening Torque (Nm)	5.6	2.6	20	20	20	30	50	90	90	115	115	170	170	190	190	270	270	
Qty	2	2	2	2	2	2	2	2	2	3	3	3	3	3	3	3	3	
Screw Details	Size (BSW)	1/4"	1/4"	3/8"	3/8"	3/8"	7/16"	1/2"	5/8"	5/8"	1/2"	1/2"	5/8"	5/8"	3/4"	3/4"	7/8"	7/8"
	Hex. Scket Size (mm)	3	3	5	5	5	6	6	8	8	10	10	12	12	14	14	14	14
Large end dia. (mm)	35.0	38.0	47.5	57.0	57.0	70.0	85.5	108.6	108	127	127	146	146	162	162	178	178	
Bush length (mm)	22.3	22.3	25.4	25.4	38.1	38.1	44.5	50.8	76.2	63.5	89.0	76.2	102	89.0	114	102	127	
Approx mass (kg)	0.1	0.1	0.2	0.3	0.5	0.7	1.5	2.7	3.6	3.8	5.0	5.6	7.7	7.5	10.0	11.1	14.0	