

XT® BUSHING INSTALLATION AND OPERATION INSTRUCTIONS FOR CONVEYOR PULLEYS EQUIPPED WITH XT HUBS DO NOT USE XT® BUSHINGS IN ANY PRODUCT OTHER THAN XT HUBS

BEFORE INSTALLATION:

1. Make sure that the shaft, barrel & bore of the bushing, XT bushed conveyor pulley hub bores, keys and keyways are clean and free of burrs, paint, etc.
2. For proper operation, make sure that the shaft size is within the size limits shown in Table 1. Some applications may benefit from tighter shaft tolerances.

⚠ CAUTION Mounting a XT Bushing on a shaft smaller than the size limits shown in Table 1 may result in a faulty assembly. The assembly may come off the shaft or undesirable assembly run out may result.

MOUNTING:

3. Using a hoist or other appropriate means, place the shaft through the pulley being careful not to damage the bore of the hub(s) and locate in the desired position. When mounting on an inclined surface, if required, make sure the conveyor pulley and shaft do not drop during installation.

4. It may be necessary to slightly wedge open the saw slot on some Bushings in order to start the bore and position the bushing onto the shaft. A narrow edged regular screw driver may be used.

⚠ CAUTION Excessive wedging forces in Bushing saw slot may damage or break Bushing. **AVOID.**

5. Align the shaft keyseat with the Bushing bore keyway and install the key. Make sure the key runs the entire length of the bushing bore. For XT Conveyor Pulleys requiring two bushings, shaft keyways must be in line with each other for proper bushing installation. Some Bushings with shallow keyways are supplied with shaft keys. For proper operation use the key supplied with the bushing.

⚠ CAUTION To assure proper transmission of torque, all bushings used in drive pulleys must be keyed to the shaft.

6. Align the non-threaded holes (A) in the bushing flanges with the threaded holes in the hubs (B). Insert the cap screws and thread them by hand three or four turns. See Diagram 1 below.

7. Position the assembly axially on the shaft such that it is aligned with its running mate(s). Be sure to check for adequate clearance between the assembly and other nearby components if applicable.

8. Using a torque wrench and appropriate socket, tighten the cap screws sequentially in order as shown on the diagrams below. Tighten to the torque shown in Table 2. When the cap screw torque is at or near recommended torque, make at least two more sequential rounds to assure all cap screws are at Table 2.

⚠ CAUTION Tightening the cap screws to a torque higher than shown in Table 2 may lead to product failure. **AVOID.**



XT15 to 80
DIAGRAM 2



XT100
DIAGRAM 3



XT120
DIAGRAM 4



XT140
DIAGRAM 5

1, 2, 3, etc. are installation sequences. 1, 8, etc. are removal sequences.

9. When two Bushings are used, completely tighten the screws on one Bushing before proceeding to tighten the other one.
10. Since tightening the cap screws may affect the axial position of the Product, confirm that it is still properly aligned with its running mate. If not, determine how much the assembly must be moved to be in proper alignment.
11. If axial adjustment is required, (following REMOVAL procedure), reposition the assembly, and repeat steps 8 and 9.
12. Check installation gap - There must be a gap between the Bushing flange and the hub face. If there is no gap between them, disassemble the parts (follow REMOVAL procedure) and determine the reason(s) for the faulty assembly.

	<p>⚠ WARNING</p> <p>Disconnect power before installation and maintenance. Failure to do so can result in severe injury or death.</p>
	<p>⚠ CAUTION</p> <p>To avoid damage, supporting structure including shafts and bearings must be designed to handle transmitted loads and belt tension(s).</p>
	<p>⚠ WARNING</p> <p>Lubricant on bushing barrel, hub or screws could lead to breakage.</p>

DIAGRAM 1



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Hao Wang, Caigan Du



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