



MANUFACTURING CORPORATION
 410 Industrial Park RD; Holly Springs, MS 38635



Single Groove Sheave



Double Groove Sheave

INSTALLATION AND REMOVAL OF HQ BUSHINGS

INSTALLATION:

1. Make sure the bore of the sheave and the tapered cone surface of the bushing are free of all foreign substances such as paint, dirt, lubricants, etc. Do not use lubricants on installation.
2. Assemble as illustrated, by inserting two cap screws through clearance holes in bushing. Cap Screws are to be loosely inserted in sheave so that bushing easily slides on to shaft.
3. Place keystone in keyseat between shaft and bore of bushing.
4. Tighten screws progressively. (See tightening instructions.)

TIGHTENING INSTRUCTIONS:

When mounting HQ Bushings which are slotted all the way through to maintain even torque (Ful-Grip Design), tightening forces on the screws are multiplied many times by the wedging action of the tapered surface. If extreme screw tightening forces are applied in mounting the HQ Bushing, bursting pressure will be created in the hub of the mounted sheave which may cause it to crack, and void the warranty.

CAUTION: Do not use lubricants on screw threads or tapered surfaces Refer to the recommended torque ratings.
Tighten bushing screws evenly and progressively.

REMOVAL INSTRUCTIONS:

1. Loosen and remove cap screws.
2. Insert cap screws in threaded holes of bushing.
3. Tighten evenly until sheave is loose on shaft.

WRENCH TORQUE VALUE FOR TIGHTENING HQ FUL-GRIP BUSHING

Bushing	Wrench Torque In Pounds	Wrench Length In Inches	Wrench Pull In Pounds
HQ	90	4	22
HQ	90	10	9