

Instruction Manual for DODGE® Idler Bushings

These instructions must be read thoroughly before installing or operating this product.

Installation technique can have a significant effect on the service life of an idler bushing. It is imperative that this procedure be followed in order to help prevent overloading of idler bushing bearings.

TAPER-LOCK® Bushing

1. Slip sheave onto idler bushing and hand tighten TAPER-LOCK bushing installation screws. DO NOT fully tighten these screws at this time.
2. Install the above assembly onto mounting bracket and secure with idler retaining nut.
3. Hold the mounting bolt stationary to prevent rotation and tighten idler retaining nut as shown in Figure 1.

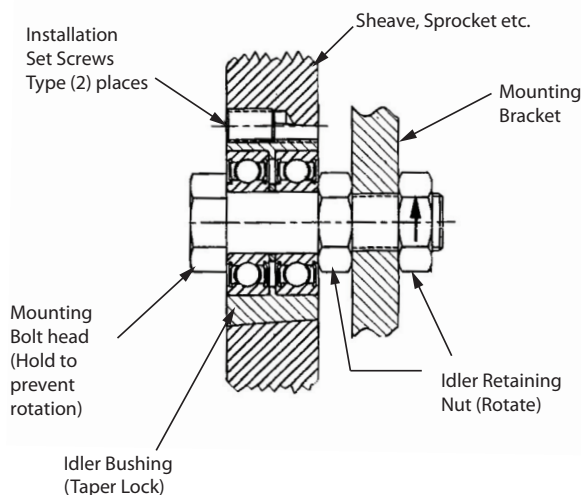


Figure 1 -- Preferred Assembly TAPERLOCK Bushings

Use Alternate Assembly if Preferred method is not possible. Use lock washer between retaining nut and bracket as shown. Hold retaining nut and tighten mounting bolt to 40 pounds-feet max.

NOTE: Shaft torque for Alternate Assembly must be held to 40 lb-ft. DO NOT OVERTIGHTEN.

WARNING Because of the possible danger to persons(s) or property from accidents which may result from the improper use of products, it is important that correct procedures be followed. Products must be used in accordance with the engineering information specified in the catalog. Proper installation, maintenance and operation procedures must be observed. The instructions in the instruction manuals must be followed. Inspections should be made as necessary to assure safe operation under prevailing conditions. Proper guards and other suitable safety devices or procedures as may be desirable or as may be specified in safety codes should be provided, and are neither provided by Baldor Electric Company nor are the responsibility of Baldor Electric Company. This unit and its associated equipment must be installed, adjusted and maintained by qualified personnel who are familiar with the construction and operation of all equipment in the system and the potential hazards involved. When risk to persons or property may be involved, a holding device must be an integral part of the driven equipment beyond the speed reducer output shaft.

4. Tighten the bushing installation screws to fully lock the idler bushing to the sheave or sprocket per Table 1.

Table 1 - Installation Torque for Taper-Lock Idler Bushing Installation Screws	
Size	Wrench Torque
	in. lbs.
1610	175
2012	280
2517	430

5. Spin the assembly by hand to ensure that it rotates freely.

NOTE: When using a threaded idler mounting bracket, install the idler bushing in the sheave/sprocket FULLY per standard TAPER-LOCK instruction manual available on www.baldor.com. Then screw this assembly into the bracket arm to 40 lb-ft and lock the shaft by tightening the bracket arm set screws.

QD Bushing

1. Slip the sheave onto the idler bushing and hand tighten the three (3) bushing retaining bolts. DO NOT fully tighten the bushing retaining bolts at this time.
2. Install above assembly onto mounting bracket and install idler retaining nut.
3. Hold the bolt head stationary to prevent bolt rotation and tighten idler retaining nut as shown in Figure 2.

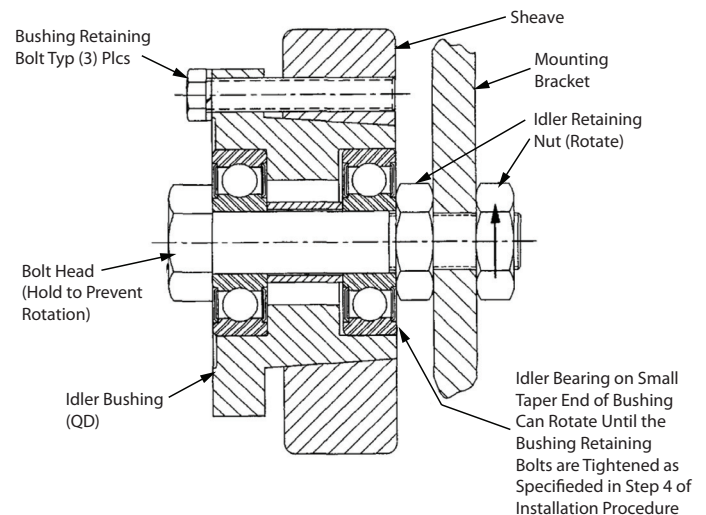
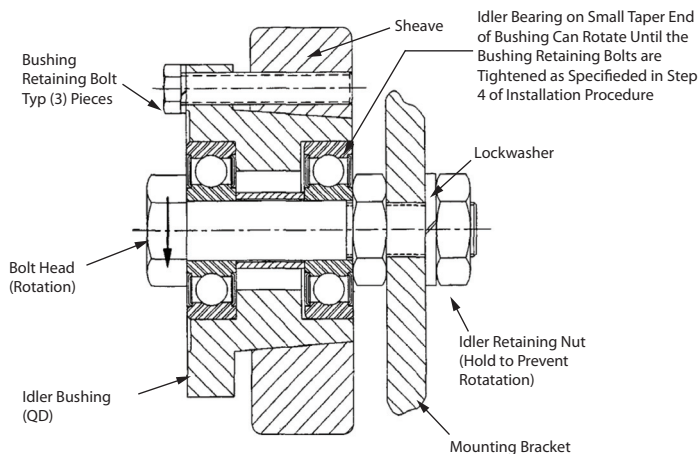


Figure 2 - Preferred Assembly QD Bushings

If, due to space limitation, the bolt must be rotated and the idler retaining nut held, a lock washer should be used between mounting bracket and lock nut, as shown in Figure 3.

NOTE: Installation torque must then be held to 40 pound-feet. DO NOT OVERTIGHTEN!





Notes:

1. When using a threaded idler mounting bracket, install the idler bushing in the sheave fully per QD instruction manual available at www.baldor.com. Then screw this assembly into the bracket arm to 40 pound-feet and lock the bolt by tightening the bracket arm set screws.
2. Idler bearing on small taper end of bushing can rotate until the bushing retaining bolts are tightened as specified in step 4 of installation procedure. (Idler bearing on large end and internal sleeve could also rotate due to differences in manufacturers' tolerances.)

**Figure 3 - Preferred Assembly QD Bushings
(Hold Idler Retaining Nut/Rotate Bolt Head to
40 ft-lb Max)**

4. Tighten the three (3) bushing retaining bolts to lock the idler bushing to the sheave per Table 2.

Table 2 - Installation Torque for QD Idler Bushing Installation Screws	
Size	Wrench Torque
	in. lbs.
SH	108
SD	108
SK	180
SK-Lg	180
SF	360
E	720
E-Lg	720

5. Spin the assembly by hand to ensure that it rotates freely.



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