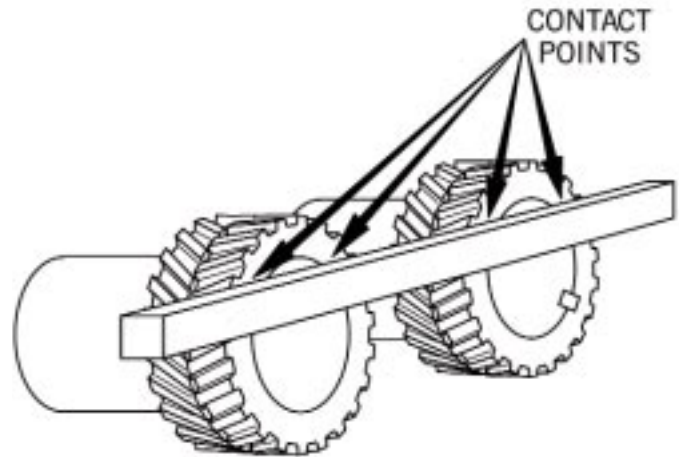




# TECHNICAL INFORMATION

5. With capscrews to the outside, place the sprocket and bushing assembly on the shaft, positioning the assembly as close as possible to the motor bearing.
6. Repeat Steps 2–5 for the other sprocket.
7. Check that the teeth of both sprockets are pointing in the same direction.
8. Snug the capscrews so that the sprocket/bushing assembly can still move on the shaft.
9. Align the sprockets using a straightedge. Check for contact in four places as shown. Do not use bearings or drive shafts as reference points for sprocket alignment.
10. Using a torque wrench, tighten the capscrews to the torque values listed below. If there is not a gap of 1/8" to 1/4" between the bushing flange and the sprocket hub then disassemble the parts and determine the reason for the faulty assembly.
11. The sprocket will draw onto the bushing during tightening. Always recheck alignment after tightening the capscrews. If alignment has changed, return to Step 8.
12. Tighten the setscrews over the keyway to the torque values listed in the table to the right.
13. If the sprockets are straight bore, use the above alignment procedure and then tighten the setscrews to the correct torque for the setscrew size listed in the Torque Specifications table.

QD bushings can be installed with the capscrews on either side, excluding H, M, and N sizes. Drives with opposing shafts require one of the sprockets be mounted with the capscrews on the flange side and one with the capscrews on the hub side.



## TORQUE SPECIFICATIONS

BUSHING	CAPSCREW TORQUE		SETSCREW TORQUE	SETSCREW SIZE
	(in-lb)	(ft-lb)	(in-lb)	(in)
H	95	8	–	–
SH	108	9	87	1/4
SDS	108	9	87	1/4
SK	180	15	87	1/4
SF	360	30	166	5/16
E	720	60	290	3/8
F	900	75	290	3/8
J	1620	135	290	3/8
M	2700	225	290	3/8
N	3600	300	620	1/2