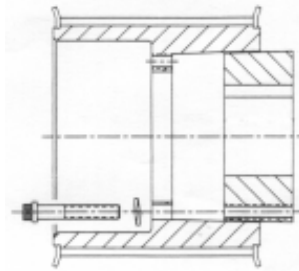




**"L" Series Flangeless  
Sure-Grip Bushings  
Installation Instructions**

Form 1036A



**To Install: IMPORTANT: DO NOT USE LUBRICANTS IN THIS INSTALLATION**

1. Inspect shafts, bushing, and mating hub. Remove all nicks, dirt, grease, etc. from mating surfaces.
2. Place key in shaft's keyseat.
3. Slide bushing onto shaft and key. **Small End of Taper Must Be Outboard.**
4. Slide tapered mating hub over bushing. Align (1) the shaft key with one of the slots in the mating hub and (2) the drilled holes in mating hub with the threaded holes in the bushing.
5. Put lockwashers on capscrews and insert one capscrew thru each drilled hole in the mating hub and into the threaded hole in the bushing.
6. **Use a Torque Wrench.** Tighten all capscrews evenly and progressively in rotation. Torque around all the capscrews as often as necessary until the listed torque value remains on each capscrew.

Bushing	Torque ft. lbs. (NM)	
SKL	15	(20)
SFL	15	(20)
EL	30	(41)
FL	55	(75)

**CAUTION**  
The use of lubricants or excessive wrench torques may cause hub stresses high enough to break the mating hub!

**To Remove:**

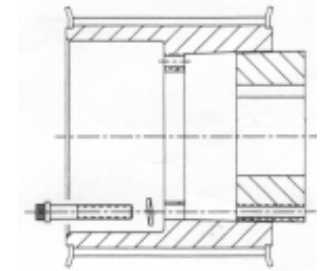
1. Loosen and remove all capscrews from assembly.
2. Install one capscrew in each threaded hole in the mating hub.
3. Evenly torque each capscrew in rotation to force the mating hub off the bushing.

T. B. Wood's Incorporated / 440 N. Fifth Avenue / Chambersburg, PA 17201



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