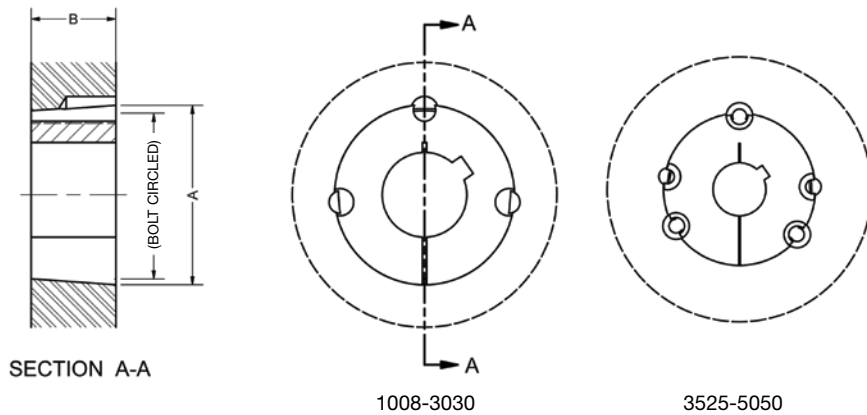




**Taper-Lock™
Bushings**
Product
Overview &
Price Guide



Taper-Lock™ Bushings



Bushings Size	Torque Capacity (lb-in)	Bore Range			Dimensions		Bolt Circle (in)	Mounting Screws	
		Min. Bore	Max Bore		A	B		Qty.	Size
			Standard Keyseat	Shallow Keyseat**					
1008	1,200	0.500	0.875	1.000	1.386	0.875	1.328	2	1/4x1/2
1108	1,300	0.500	1.000	1.125	1.511	0.875	1.453	2	1/4x1/2
1210	3,600	0.500	1.250	-	1.875	1.000	1.750	2	3/8x5/8
1215	3,550	0.500	1.250	-	1.875	1.500	1.750	2	3/8x5/8
1610	4,300	0.500	1.500	1.688	2.250	1.000	2.125	2	3/8x5/8
1615	4,300	0.500	1.500	1.688	2.25	1.500	2.125	2	3/8x5/8
2012	7,150	0.500	1.875	2.125	2.750	1.250	2.625	2	7/16x7/8
2517	11,600	0.500	2.250	2.688	3.375	1.750	3.250	2	1/2x1
2525	11,300	0.750	2.250	2.500	3.375	2.500	3.250	2	1/2x1
3020	24,000	0.875	2.750	3.250	4.250	2.000	4.000	2	5/8x1-1/4
3030	24,000	0.938	2.750	3.250	4.250	3.000	4.000	2	1/2x1
3535	44,800	1.188	3.250	3.938	5.000	3.500	4.830	3	1/2x1-1/2
4040	77,300	1.438	3.625	4.438	5.750	4.000	5.540	3	5/8x1-3/4
4545	110,000	1.938	4.250	4.938	6.375	4.500	6.130	3	3/4x2
5050	126,000	2.438	4.500	5.000	7.000	5.000	6.720	3	3/4x2

Taper-Lock™ is a trademark of Baldor Electric Company.
 **Key is furnished with each bushing having a shallow keyseat.



Standard Stock Bores (Inches)



Bushing	List Price \$	Stock Bore	Keyseat
1008	13.92	1/2 • 9/16 5/8 • 11/16 • 3/4 13/16 • 7/8 15/16 • 1	1/8 x 1/16 3/16 x 3/32 3/16 x 3/32 1/4 x 1/16**
1108	14.40	1/2 • 9/16 5/8 • 11/16 • 3/4 13/16 • 7/8 15/16 • 1 1 1/16 • 1 1/8	1/8 x 1/16 3/16 x 3/32 3/16 x 3/32 1/4 x 1/8 1/4 x 1/16**
1210	15.36	1/2 • 9/16 5/8 • 11/16 • 3/4 13/16 • 7/8 15/16 • 1 • 1 1/16 1 1/8 • 1 3/16 • 1 1/4	1/8 x 1/16 3/16 x 3/32 3/16 x 3/32 1/4 x 1/8 1/4 x 1/8
1215	16.80	1/2 • 9/16 5/8 • 11/16 • 3/4 13/16 • 7/8 15/16 • 1 • 1 1/16 1 1/8 • 1 3/16 • 1 1/4	1/8 X 1/16 3/16 X 3/32 3/16 X 3/32 1/4 X 1/8 1/4 X 1/8
1610	17.76 16.13[†]	1/2 • 9/16 5/8 • 11/16 • 3/4 13/16 • 7/8 15/16 • 1 [†] • 1 1/16 1 1/8* • 1 3/16 • 1 1/4 1 5/16 • 1 3/8 [†] 1 7/16 • 1 1/2 [†] 1 9/16 • 1 5/8 • 1 11/16	1/8 X 1/16 3/16 X 3/32 3/16 X 3/32 1/4 X 1/8 1/4 X 1/8 5/16 X 5/32 3/8 X 3/16 3/8 X 1/8**
1615	18.48	1/2 • 9/16 5/8 • 11/16 • 3/4 13/16 • 7/8 15/16 • 1 • 1 1/16 1 1/8 • 1 3/16 • 1 1/4 1 5/16 • 1 3/8 1 7/16 • 1 1/2 1 9/16 • 1 5/8 • 1 11/16	1/8 X 1/16 3/16 X 3/32 3/16 X 3/32 1/4 X 1/8 1/4 X 1/8 5/16 X 5/32 3/8x3/16 3/8 X 1/8 **

** Shallow Keyseat

Bushing	List Price \$	Stock Bore	Keyseat
2012	24.00 21.80[†]	1/2 • 9/16 5/8 • 11/16 • 3/4 13/16 • 7/8 15/16 • 1 • 1 1/16 1 1/8 • 1 3/16 • 1 1/4 1 5/16 • 1 3/8 [†] 1 7/16 [†] • 1 1/2 [†] • 1 9/16 1 5/8 • 1 11/16 • 1 3/4 1 13/16 • 1 7/8 [†] 1 15/16 • 2 2 1/8	1/8 X 1/16 3/16 X 3/32 3/16 X 3/32 1/4 X 1/8 1/4 X 1/8 5/16 X 5/32 3/8 X 3/16 3/8 X 3/16 1/2 X 1/4 1/2 X 3/16** 1/2 X 1/8**
2517	29.52 26.81[†]	1/2 5/8 • 11/16 • 3/4 13/16 • 7/8 15/16 • 1 • 1 1/16 1 1/8 • 1 3/16 • 1 1/4 [†] 1 5/16 • 1 3/8 1 7/16 • 1 1/2 • 1 9/16 1 5/8 • 1 11/16 • 1 3/4 1 13/16 • 1 7/8 1 15/16 [†] • 2 • 2 1/16 2 1/8 • 2 3/16 • 2 1/4 2 5/16 • 2 3/8 • 2 7/16 2 1/2 • 2 5/8 • 2 11/16	1/8 x 1/16 3/16 x 3/32 3/16 x 3/32 1/4 x 1/8 1/4 x 1/8 5/16 x 5/32 3/8 x 3/16 3/8 x 3/16 1/2 x 1/4 1/2 x 1/4 1/2 x 1/4 5/8 x 3/16** 5/8 x 3/16**
2525	43.68	3/4 • 7/8 1 • 1 1/8 • 1 3/16 1 1/4 1 3/8 1 7/16 • 1 1/2 • 1 5/8 1 11/16 • 1 3/4 1 13/16 • 1 7/8 1 15/16 • 2 • 2 1/8 2 3/16 • 2 1/4 2 5/16 • 2 3/8 • 2 7/16 2 1/2	3/16 x 3/32 1/4 x 1/8 1/4 x 1/8 5/16 x 5/32 3/8 x 3/16 3/8 x 3/16 1/2 x 1/4 1/2 x 1/4 1/2 x 1/4 5/8 x 3/16** 5/8 x 3/16**

** Shallow Keyseat



Standard Stock Bores (Inches)



Bushing	List Price \$	Stock Bore	Keyseat
3020	44.40	7/8	3/16 x 3/32
		15/16 • 1 • 1 1/8	1/4 x 1/8
		1 3/16 • 1 1/4	1/4 x 1/8
		1 5/16 • 1 3/8	5/16 x 5/32
		1 7/16 • 1 1/2 • 1 9/16	3/8 x 3/16
		1 5/8 • 1 11/16 • 1 3/4	3/8 x 3/16
		1 13/16 • 1 7/8	1/2 x 1/4
		1 15/16 • 2 • 2 1/16	1/2 x 1/4
		2 1/8 • 2 3/16 • 2 1/4	1/2 x 1/4
		2 5/16 • 2 3/8 • 2 7/16	5/8 x 5/16
		2 1/2 • 2 5/8 • 2 11/16	5/8 x 5/16
		2 3/4	5/8 x 5/16
		2 13/16 • 2 7/8 • 2 15/16	3/4 x 1/4**
		3 • 3 1/8 • 3 3/16 • 3 1/4	3/4 x 1/4**
3030	64.80	15/16 • 1 • 1 1/8 • 1 3/16	1/4 x 1/8
		1 1/4	1/4 x 1/8
		1 5/16 • 1 3/8	5/16 x 5/32
		1 7/16 • 1 1/2 • 1 9/16	3/8 x 3/16
		1 5/8 • 1 11/16 • 1 3/4	3/8 x 3/16
		1 13/16 • 1 7/8 • 1 15/16	1/2 x 1/4
		2 • 2 1/16 • 2 1/8 • 2 3/16	1/2 x 1/4
		2 1/4	1/2 x 1/4
		2 5/16 • 2 3/8 • 2 7/16	5/8 x 5/16
		2 1/2 • 2 5/8 • 2 11/16	5/8 x 5/16
		2 3/4	5/8 x 5/16
		2 7/8 • 2 13/16 • 2 15/16 • 3	3/4 x 1/4**
		3 1/8 • 3 3/16 • 3 1/4	3/4 x 1/4**
		3535	91.20
1 3/8	5/16 x 5/32		
1 7/16 • 1 1/2 • 1 5/8	3/8 x 3/16		
1 11/16 • 1 3/4	3/8 x 3/16		
1 7/8 • 1 15/16 • 2	1/2 x 1/4		
2 1/8 • 2 3/16 • 2 1/4	1/2 x 1/4		
2 3/8 • 2 7/16 • 2 5/16 • 2 1/2	5/8 x 5/16		
2 5/8 • 2 11/16 • 2 3/4	5/8 x 5/16		
2 7/8 • 2 15/16 • 3	3/4 x 3/8		
3 1/8 • 3 3/16 • 3 1/4	3/4 x 3/8		
3 5/16 • 3 3/8 • 3 7/16	7/8 x 1/4**		
3 1/2 • 3 5/8 • 3 11/16	7/8 x 1/4**		
3 3/4	7/8 x 1/4**		
3 7/8 • 3 15/16	1 x 1/4**		

** Shallow Keyseat

Bushing	List Price \$	Stock Bore	Keyseat		
4040	146.40	1 7/16 • 1 1/2 • 1 5/8	3/8 x 3/16		
		1 11/16 • 1 3/4	3/8 x 3/16		
		1 7/8 • 1 15/16 • 2	1/2 x 1/4		
		2 1/8 • 2 3/16 • 2 1/4	1/2 x 1/4		
		2 3/8 • 2 7/16 • 2 1/2	5/8 x 5/16		
		2 5/8 • 2 11/16 • 2 3/4	5/8 x 5/16		
		2 7/8 • 2 15/16 • 3 • 3 1/8	3/4 x 3/8		
		3 3/16 • 3 1/4	3/4 x 3/8		
		3 3/8 • 3 7/16 • 3 1/2	7/8 x 7/16		
		3 5/8	7/8 x 7/16		
		3 11/16 • 3 3/4	7/8 x 1/4*		
		3 7/8 • 3 15/16 • 4	1 x 1/4**		
		4 1/8 • 4 3/16 • 4 1/4	1 x 1/4**		
		4 3/8 • 4 7/16	1 x 1/4**		
4545	182.40	1 15/16 • 2 • 2 3/16	1/2 x 1/4		
		2 3/8 • 2 7/16 • 2 5/8	5/8 x 5/16		
		2 3/4	5/8 x 5/16		
		2 7/8 • 2 15/16 • 3	3/4 x 3/8		
		3 1/8 • 3 3/16 • 3 1/4	3/4 x 3/8		
		3 3/8 • 3 7/16 • 3 1/2	7/8 x 7/16		
		3 5/8 • 3 3/4	7/8 x 7/16		
		3 7/8 • 3 15/16 • 4	1 x 1/2		
		4 1/8 • 4 3/16 • 4 1/4	1 x 1/2		
		4 3/8 • 4 7/16 • 4 1/2	1 x 1/4**		
		4 3/4 • 4 7/8 • 4 15/16	1 1/4 x 1/4**		
		5050	295.20	2 7/16 • 2 11/16	5/8 x 5/16
				2 15/16	3/4 x 3/8
			268.14†	3 3/8 • 3 7/16 • 3 5/8	7/8 x 7/16
3 7/8 • 3 15/16 • 4	1 x 1/2				
4 1/4 • 4 3/8 • 4 7/16	1 x 1/2				
4 1/2	1 x 1/2				
4 7/8 • 4 15/16 • 5†	1 1/4 x 7/16**				

** Shallow Keyseat



Standard Stock Bores (Millimeters)



Bushing	List Price \$	Stock Bore	Key
1008	13.92	14 • 16 18 • 19 • 20 • 22 24	5 x 5 6 x 6 8 x 7
1108	14.40	14 • 16 18 • 19 • 20 • 22 24 • 25	5 x 5 6 x 6 8 x 7
1210	15.36	14 • 16 18 • 19 • 20 24 • 25 • 28 • 30	5 x 5 6 x 6 8 x 7 10 x 8
1610	17.76	19 • 20 • 22 24 • 25 • 28 • 30 32 • 35 • 38 40	6 x 6 8 x 7 10 x 8 12 x 8
2012	24.00	14 • 16 18 • 19 • 20 • 22 24 • 25 • 28 • 30 32 • 35 • 38 40 • 42 45	5 x 5 6 x 6 8 x 7 10 x 8 12 x 8 14 x 9
2517	29.52	14 • 16 18 • 20 • 22 24 • 25 • 28 • 30 32 • 35 • 38 40 • 42 45 • 48 • 50 55 60	5 x 5 6 x 6 8 x 7 10 x 8 12 x 8 14 x 9 16 x 10 18 x 11
3020	44.40	24 • 25 • 28 40 45 • 48 • 50 55 60 • 65	8 x 7 12 x 8 14 x 9 16 x 10 18 x 11





Taper-Lock Bushings



Installation Instructions

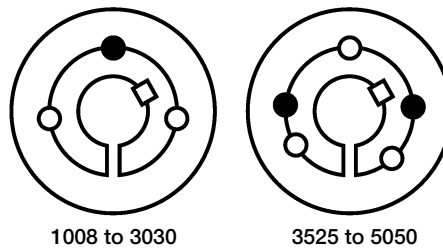


Figure 1

To Install TAPER-LOCK Type Bushings

1. Clean the shaft, bore of bushing, outside of bushing and the sprocket hub bore of all oil, paint and dirt. File away any burrs. **Note:** The use of lubricants can cause sprocket breakage. USE NO LUBRICANTS IN THIS INSTALLATION.
2. Insert the bushing into the sprocket hub. Match the hole pattern, not threaded holes (each complete hole will be threaded on one side only).
3. LIGHTLY oil the set screws and thread them into those half-threaded holes indicated by on the diagram above. **Note:** Do not lubricate the bushing taper, hub taper, bushing bore, or the shaft. Doing so could result in sprocket breakage.
4. With the key in the shaft keyway, position the assembly onto the shaft allowing for small axial movement of the sprocket which will occur during the tightening process. **Note:** When mounting sprockets on a vertical shaft, precautions must be taken to positively prevent the sprocket and/or bushing from falling during installation.
5. Alternately torque the set screws until the sprocket and bushing tapers are completely seated together (at approximately half of the recommended torque; see table below). **Note:** Do not use worn hex key wrenches. Doing so may result in a loose assembly or may damage screws.
6. Check the alignment and sprocket axial runout (wobble), and correct as necessary.
7. Continue alternate tightening of the cap screws to the recommended torque values specified in the table below.
8. To increase the bushing gripping force, hammer the face of the bushing using a drift or sleeve (do not hit the bushing directly with the hammer).
9. Re-torque the bushing screws after hammering.
10. Recheck all screw torque values after the initial drive run-in, and periodically thereafter. Repeat steps 5 through 9 if loose.



Taper-Lock Bushings



To Remove

1. Loosen and remove all mounting screws.
2. Insert screws into all jack screw holes indicated by • (see figure 1).
3. Loosen the bushing by alternately tightening the screws in small but equal increments until the tapered sprocket and bushing surfaces disengage.

Sprocket Installation

Bushing Size	Bolt		Mounting Screws	
	Qty.	Size	lb-ft	lb-in
1008, 1108	2	1/4-20 x 1/2	4.6	55
1210, 1215	2	3/8-16 x 5/8	14.6	175
1610, 1615	2	3/8-16 x 5/8	14.6	175
2012	2	7/16-14 x 7/8	23.3	280
2517, 2525	2	1/2-13 x 1	35.8	430
3020, 3030	2	5/8-11 x 1-1/4	66.7	800
3535	3	1/2-13 x 1-1/2	83.3	1000
4040	3	5/8-11 x 1-3/4	141.7	1700
4545	3	3/4-10 x 2	204.2	2450
5050	3	3/4-10 x 2	258.3	3100

Caution: Excessive bolt torque can cause sprocket and/or bushing breakage.

Note: To insure proper bushing/sprocket performance, full bushing contact on the shaft is recommended.

Belted Drives and Sheaves

TB Wood's

Belted Drives

Chambersburg, PA - USA
1-888-829-6637 – Press #5

For application assistance:
 1-888-829-6637 – Press #7

Couplings

Ameridrives Couplings

*Mill Spindles, Ameriflex,
 Ameridisc*

Erie, PA - USA
1-814-480-5000

Gear Couplings

San Marcos, TX - USA
1-800-458-0887

Ameridrives Power Transmission

*Universal Joints, Drive Shafts,
 Mill Gear Couplings*

Green Bay, WI - USA
1-920-593-2444

Bibby Turboflex

*Disc, Gear, Grid Couplings,
 Overload Clutches*

Dewsbury, England
+44 (0) 1924 460801

Boksburg, South Africa
+27(0) 11 918 4270

Guardian Couplings

*Engineered Flywheel Couplings,
 Engine Housings and Pump Mounts,
 Flexible Shaft Couplings*

Michigan City, IN - USA
1-219-874-5248

Huco Dynatork

*Precision Couplings and
 Air Motors*

Hertford, England
+44 (0) 1992 501900

Chambersburg, PA - USA
1-888-829-6637

Couplings Cont.

Lamiflex Couplings

*Flexible Couplings, Bearing
 Isolators, and Coupling Guards*

Cotia, SP - Brasil
+55 (11) 4615-6300

TB Wood's

Elastomeric Couplings

Chambersburg, PA - USA
1-888-829-6637 – Press #5

For application assistance:
 1-888-829-6637 – Press #7

General Purpose Disc Couplings

San Marcos, TX - USA
1-888-449-9439

**Electromagnetic
 Clutches and Brakes**

Inertia Dynamics

*Spring Set Brakes; Power On and
 Wrap Spring Clutch/Brakes*

New Hartford, CT - USA
1-800-800-6445

Matrix International

*Electromagnetic Clutches
 and Brakes, Pressure Operated
 Clutches and Brakes*

Brechin, Scotland
+44 (0) 1356 602000

New Hartford, CT - USA
1-800-825-6544

Warner Electric

*Electromagnetic Clutches
 and Brakes*

New Hartford, CT - USA
1-800-825-6544

For application assistance:
 1-800-825-9050

Saint Barthélemy d'Anjou, France
+33 (0)2 41 21 24 24

*Precision Electric Coils and
 Electromagnetic Clutches and
 Brakes*

Columbia City, IN - USA
1-260-244-6183

**Engineered
 Bearing Assemblies**

Kilian Manufacturing

*Engineered Bearing
 Assemblies*

Syracuse, NY - USA
1-315-432-0700

Gearing

Bauer Gear Motor

Geared Motors

Esslingen, Germany
+49 (711) 3518-0

Somerset, NJ - USA
1-732-469-8770

Boston Gear

*Enclosed and Open Gearing,
 Electrical and Mechanical
 P.T. Components*

Charlotte, NC - USA
1-800-825-6544

For application assistance:
 1-800-816-5608

**Nuttall Gear and
 Delroyd Worm Gear**

*Worm Gear and
 Helical Speed Reducers*

Niagara Falls, NY - USA
1-716-298-4100

**Heavy Duty
 Clutches and Brakes**

Industrial Clutch

*Pneumatic and Oil Immersed
 Clutches and Brakes*

Waukesha, WI - USA
1-262-547-3357

Svendborg Brakes

*Industrial Brakes and
 Brake Systems*

Vejstrup, Denmark
+45 63 255 255

Twiflex Limited

Caliper Brakes and Thrusters

Wichita Falls, TX - USA
1-844-723-3483

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+44 (0) 20 8894 1161

**Heavy Duty
 Clutches and Brakes Cont.**

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*Pneumatic Clutches
 and Brakes*

Wichita Falls, TX - USA
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Bedford, England
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Linear Products

Warner Linear

Linear Actuators

Belvidere, IL - USA
1-800-825-6544

For application assistance:
 1-800-825-9050

Saint Barthélemy d'Anjou,
 France
+33 (0)2 41 21 24 24

Overrunning Clutches

Formsprag Clutch

*Overrunning Clutches
 and Holdbacks*

Warren, MI - USA
1-800-348-0881 – Press #1

For application assistance:
 1-800-348-0881 – Press #2

Marland Clutch

*Roller Ramp and Sprag Type
 Overrunning Clutches
 and Backstops*

South Beloit, IL - USA
1-800-216-3515

Stieber Clutch

*Overrunning Clutches
 and Holdbacks*

Heidelberg, Germany
+49 (0) 6221-30470

For information concerning our
 sales offices in Asia Pacific
 check our website
www.altramotion.com.cn



www.tbwoods.com

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