



Stainless Conveyor Drive

Output Shaft Bushing Kits

1. Determine whether a pocketed keyway bushing kit or a slotted keyway bushing kit is to be installed.
2. Follow the assembly steps below for the appropriate bushing kit and drive end orientation as required.



POCKETED KEYWAY BUSHING KIT - TYPE (K)

- (1) Plain Bushing
- (1) Keyed Bushing
- (2) Rectangular Drive Keys

POCKETED KEYWAY BUSHING KIT - INSTALLATION PROCEDURES

1. Determine the driving end of the hollow shaft. This is the end where the keyed bushing will be installed. The plain bushing (No Keyway) will be installed in the non-driving end. If the driving end is near the conveyor, follow steps 2-9 below. If the driving end is away from the conveyor, follow steps 10-17 below

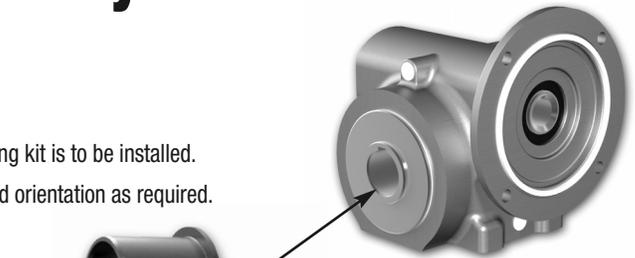
NOTE: Use of an anti-seize lubricant is recommended and will facilitate disassembly.

FOR DRIVE END NEAR THE CONVEYOR

2. Loosely install a shaft clamping collar onto the solid driven shaft.
3. Install the key into the outer slot of the bushing and insert the bushing/key assembly into the driving end of the hollow shaft.
4. Install the second key into the keyway on the solid driven shaft.
5. Align the key in the solid shaft with the keyway in the driving end bushing and slide the reducer onto the solid shaft.
6. Install the plain bushing between the solid and hollow shaft.
7. Install the second shaft clamping collar loosely onto the shaft.
8. Install torque arm assembly if required (sold separately).
9. Tighten clamp collars against the bushings to hold the keys, bushings and reducer in place on the solid shaft.

FOR DRIVE END AWAY FROM THE CONVEYOR

10. Loosely install a shaft clamping collar onto the solid driven shaft.
11. Install the plain bushing onto the solid driven shaft.
12. Install the shaft key into the pocket in the solid driven shaft.
13. Carefully slide the reducer hollow shaft over the key and engage the hollow shaft with the plain bushing.
14. Install the hollow shaft key into the pocketed bushing and install the pocketed bushing by aligning the 2 keys with their respective keyways.
15. Loosely install the outer shaft clamping collar onto the solid shaft.
16. Rotate reducer to proper alignment and install torque arm assembly if required. (Sold Separately)
17. Tighten the clamp collars against the bushings to retain the bushings, keys and reducer.



SLOTTED KEYWAY BUSHING KIT - TYPE (S)

- (1) Plain Bushing
- (1) Slotted Bushing
- (1) Stepped Rectangular Drive Key

SLOTTED KEYWAY BUSHING KIT - INSTALLATION PROCEDURES

1. Determine the driving end of the hollow shaft. This is the end where the keyed bushing will be installed. The plain bushing (No Keyway) will be installed in the non-driving end. If the driving end is near the conveyor, follow steps 2-9 below. If the driving end is away from the conveyor, follow steps 10-15 below.

NOTE: Use of an anti-seize lubricant is recommended and will facilitate disassembly.

FOR DRIVE END NEAR THE CONVEYOR

2. Loosely install a shaft clamping collar onto the solid driven shaft.
3. Install the slotted bushing onto the solid shaft. Install the key into the keyway on the solid shaft and engage the bushing with the key.
4. Align the key/keyway and slide the reducer onto the solid shaft.
5. Install the plain bushing between the solid and hollow shaft.
6. Loosely install the outer shaft clamping collar to the solid shaft.
7. Install torque arm assembly if required (sold separately).
8. Tighten clamp collars against the bushings to hold the keys, bushings and reducer in place on the solid shaft.

FOR DRIVE END AWAY FROM THE CONVEYOR

9. Loosely install a shaft clamping collar onto the solid driven shaft.
10. Install the plain bushing into the hollow shaft.
11. Slide the reducer onto the solid shaft.
12. Install the key into the keyway on the solid driven shaft.
13. Install the slotted bushing into the driving end of the hollow shaft.
14. Loosely install the second shaft clamping collar onto the solid shaft.
15. Install torque arm assembly if required (sold separately).
16. Tighten clamp collars against the bushings to hold the keys, bushings and reducer in place on the solid shaft.

To order HOLLOW OUTPUT SHAFT BUSHING and SHAFT COLLAR BUSHING KITS, see reverse side of this bulletin.



HOLLOW OUTPUT SHAFT BUSHING KITS

Size	Bushing I.D.**	Kit Type	Kit #
S20	1.000	K	WKS850468
	1.188	S	WKS850625
	1.250	S	WKS850469
S24	1.000	S	WKS850653
	1.188	S	WKS850662
	1.250	S	WKS850470
S26	1.000	K	WKS850627
	1.250	S	WKS850479
	1.438	S	WKS850472
	1.500	S	WKS850473
S30	1.250	K	WKS850481
	1.438	S	WKS850474



SHAFT COLLAR BUSHING KITS

Bore	Thk.	O.D.	Kit #
1.000	0.50	1.75	CK52228
1.188		2.06	CK52230
1.250		CK52231	
1.438	0.56	2.25	CK52233
1.500		2.38	CK52234
1.688	0.69	2.75	CK52235
1.938		3.00	CK52237

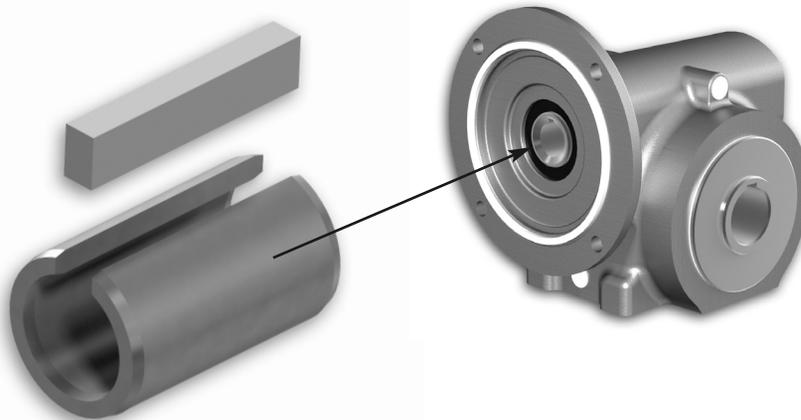


Dimensions are in inches.

** Bore Tolerance +.002/.000. Dimensions are in inches.

Quill Input Shaft Bushing Kits

BUSHING KIT CONTENTS
(1) BUSHING (0.625)
(1) RECTANGULAR KEY



INSTALLATION PROCEDURES

1. Install bushing onto the driving shaft
2. Align the bushing slot with that of the driving shaft keyway
3. Install the key in the driving shaft.

4. Align the key of the driving shaft and the keyway of the driven shaft, being careful not to bend the shaft.
5. Reposition the key and bushing as necessary on the driving shaft. Extend the key fully into the driven shaft for maximum engagement.

NOTE: Use of an anti-seize lubricant is recommended and will facilitate disassembly.

INPUT SHAFT BUSHING KIT

Motor Flange (Shaft Diameter)	Reducer Input Adaptor (Bore Size)	Bushing Length	Keyway Size	Kit #
56C (0.625)	140TC (0.875)	1.44	3/16 X 3/32	WK9810170



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PWS-198993-June 1/15
Printed in U.S.A.