



Aluminum and Cast Iron Sheave Bushing Installation Instructions

Read complete instructions before proceeding:

1. Wipe the shaft, bushing bore, bushing taper, and sheave bore with a cleaning solvent to remove any dirt or oil.
2. Tighten each bolt a little at a time so that the bushing draws evenly into the sheave hub without cocking to one side or the other. Torque the bolts as specified on the chart below. Rotate the sheave to verify that it does not wobble.
3. **Do not attempt to bottom-out the bushing in the sheave. After proper bolt torque is applied, there should still be a gap between the bushing flange and the sheave hub.**

Aluminium Sheave Size	Bushing Type	Bolt Torque (FT-LBS)
2B3.6 to 2B4.4	SH	6
2B4.6 to 2B6.8	SDS	6
2B7.0, 2B16.0	SK	13
2B20.0	SF	22
4B4.2 to 4B6.6	SD	6
4B6.8 to 4B9.4	SK	13
4B16.0, 4B20.0	SF	19
4B25.0, 5B25.0	E	35
6B5.0 to 6B5.4	SD	6
6B5.6 to 6B6.8	SK	13
6B7.0, 6B7.4, 6B9.4	SF	22
6B30.0, 6B38.0	E	35
8B5.6	SK	13
8B7.4 to 8B8.2	SF	22
8B8.8 to 8B9.4	E	35
8B38.0, 8B50.0	F	55
Cast Iron Sheave Size	Bushing Type	Bolt Torque (FT-LBS)
3B38, 4B25 to 4B38, 5B20 to 5B38, 6B20 to 6B38	E	60
2B25 to 2B38, 3B20 to 3B30, 4B15.4 to 4B20, 5B7.0 to 5B18.4, 6B7.0 to 6B18.4	SF	30
3B4.6 to 3B6.8, 4B3.4 to 4B6.8, 5B3.4 to 5B5.2, 6B3.4 to 6B5.2	SD	9
1B3.4 to 1B4.4, 2B3.4 to 2B4.4, 3B3.4 to 3B4.4	SH	9
1B4.6 to 1B13.6, 2B4.6 to 2B6.8	SDS	9
1B15.4 to 1B20, 2B7.0 to 2B18.4, 3B7.0 to 3B18.4, 4B7.0 to 4B13.6, 5B5.4 to 5B6.8, 6B5.4 to 6B6.8	SK	15



BAC CAUTION TIP:

Failure to follow these instructions may result in a cracked sheave! Do not use “Never Seize” or any lubricants on the bolts!