



"WF" Bushings for "K" Series Reducers

Single Sided Bushing – Installation Instructions

NOTE: The gap from the pressure ring (39.010) to the clamp ring (39.020) should remain the "U" dimension as shown in Table No. 1 until the unit is mounted onto the shaft. The "Spacer Bolts" are installed to maintain this distance. **DO NOT REMOVE** the spacer bolts until the unit is installed onto the shaft.

Mounting of Reducer

1. The machine shaft should have a chamfer of $1/32 \times 45^\circ$ minimum for ease of installation. Mount the gearbox with bushing installed onto a clean shaft. Guide the shaft through the bore of the quill until it penetrates the support ring on the opposite side. The shaft must be long enough to engage the support ring (39.050) in order to be "wobble free".
2. Remove the spacer bolts.
3. Tighten the capscrews (39.100) to the torque shown in Table No. 1. **Use a torque wrench.** The tightening should be done gradually in a rotating sequence and will require more than one (1) rotation to tighten properly.

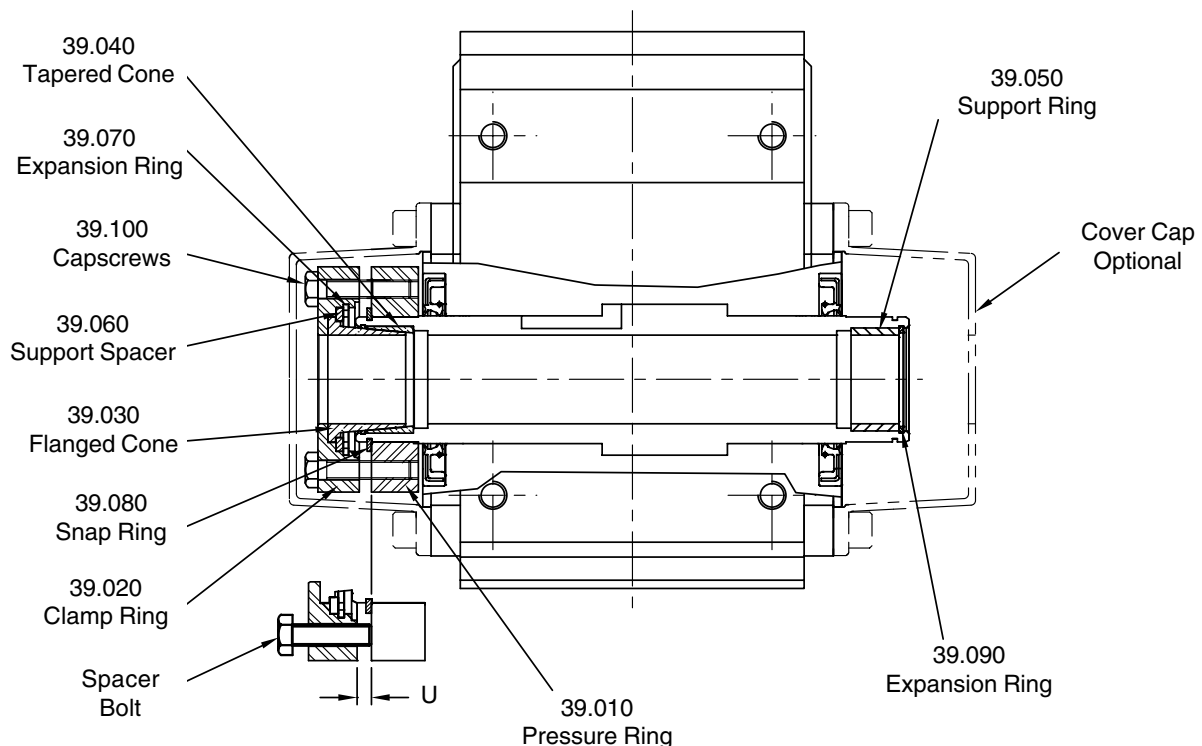
After two (2) hours (minimum) running time, check capscrews and retighten to the specified torque, if necessary.

Removal of WF Bushing

1. Loosen all capscrews (39.100).
2. Mount two (2) of the capscrews into the tapped holes of the clamp ring (39.020) to back off the clamp ring assembly and release pressure between the flanged cone and the tapered cone.

Table No. 1

Base Module	Capscrews		Tightening Torque		U	
	Qty.	Size x Length	Nm.	in. lbs.	mm	inches
K102	6	M6x25mm	10	89	5	.20
K202/K203	6	M6 x 30 mm	10	89	5	.20
K302/F303	8	M6 x 30 mm	10	89	5	.20
K402/K403	8	M8 x 30 mm	25	221	6	.24
K513/K514	8	M8 x 30 mm	25	221	7	.28
K613/K614	8	M10 x 35 mm	49	434	8.5	.33
K713/K714	8	M10 x 40 mm	49	434	5.5	.22
K813/K814	8	M12 x 40 mm	85	752	7	.28



Also available as a double bushing. See Form No. 2010.

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Printed in U.S.A. • Form No. 2006K • October 2006



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