



# TAPER-LOCK BUSHINGS

## DID YOU KNOW THAT...

- Available in inches & millimeters
- Flush mounting
- Sizes 1008 – 5050

## HOW TO ORDER

EXAMPLE: **2012X1-3/8**

**2012**

**X1-3/8**

**2012:** BUSHING SIZE

The Taper-Lock bushing size is defined by 4 digits representing two numbers. The first two digits represent the maximum bore size and the second two digits represent the bushing length. For example, product number 1008 has a max. bore of 1.0" and a total length of 0.8"

**X1-3/8:** BORE SIZE (1-3/8")

**Bore size:** Inch bore sizes are designated with the whole inch followed by the fraction. For example, a 1.5" diameter bore would be 1-1/2. Metric bore sizes are designated with "MM" after the metric dimension (X 25MM).

## To Install:

1. Clean all parts of the bushing and bore of hub thus removing any oil, lacquer or dirt. Install bushing in hub and match half holes to make complete holes (each complete hole will be threaded on one side only).
2. Oil thread and either the end of set screws or under the head of the cap screws. Install screws loosely in holes that are threaded on the hub side.

3. Make sure that the bushing is free in the hub. Slip assembly onto shaft and align in the desired position.
4. Tighten screws evenly and alternately until the part has tightened. (See table below for wrench torque)
5. Hammer with a block or sleeve the large end of the bushing. Re-tighten screws using the correct torque. Repeat this procedure until the screws no longer turn. Fill remaining holes with grease to prevent dirt buildup.

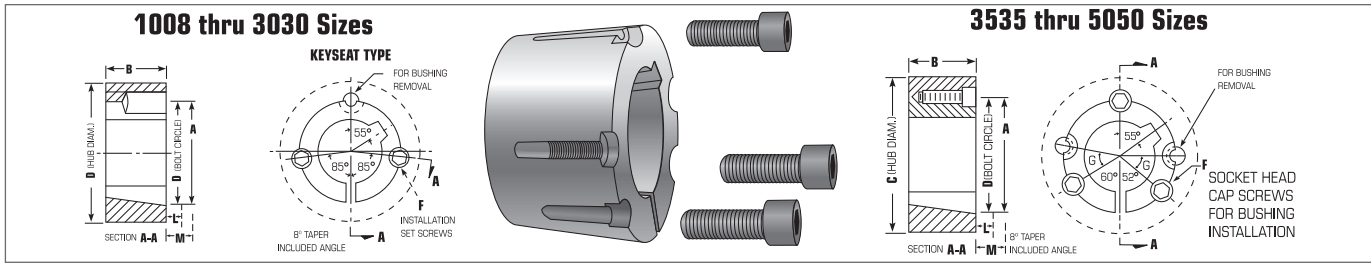
**To Remove:**

1. Remove all screws. Oil thread and either the end of set screws or under the head of cap screws.
2. Insert screws in hole(s) that are threaded on the bushing side (see diagram on following page). Note that there will be one extra screw left over.
3. Tighten screws alternately until the bushing is loose in the hub. It may be necessary to tap on the hub to loosen the bushing.

## PROPER WRENCH TORQUE TO TIGHTEN SCREWS

Bushing No.	SCREWS	Wrench torque (Pounds-Inches)	Wrench torque (Pounds-Feet)
<b>1008, 1108</b>	1/4" Set Screws	55	4.5
<b>1210, 1215, 1310</b>	3/8" Set Screws	175	14.5
<b>1610, 1615</b>	3/8" Set Screws	175	14.5
<b>2012</b>	7/16" Set Screws	280	23.0
<b>2517, 2525</b>	1/2" Set Screws	430	36.0
<b>3020, 3030</b>	5/8" Set Screws	800	67.0
<b>3535</b>	1/2" Cap Screws	1,000	83.0
<b>4040</b>	5/8" Cap Screws	1,700	142.0
<b>4545</b>	3/4" Cap Screws	2,450	204.0
<b>5050</b>	7/8" Cap Screws	3,100	258.0

# TAPER-LOCK BUSHINGS



## DIMENSIONS FOR 1008 THRU 5050

Bushing Size	Rating • Torque Capacity (lb - in.)	Hub Diam. Ref.				Installation Screw +		G	L *		M *		Approx. Wt. (lbs)
		A	B	C Gray Iron	D	Qty	Size		Std Hex Key	Short Key €	Std Hex Key	Short Key €	
1008	1,200	1 3/8	7/8	2 3/16	1 21/64	2	1/4 x 1/2		1 1/8	5/8	1 1/4	3/4	0.2
1108	1,300	1 1/2	7/8	2 5/16	1 29/64	2	1/4 x 1/2		1 1/8	5/8	1 1/4	3/4	0.2
1210	3,600	1 7/8	1	3 1/4	1 3/4	2	3/8 x 5/8		1 3/8	13/16	1 5/8	1 1/16	0.5
1215	3,550	1 7/8	1 1/2	2 7/8	1 3/4	2	3/8 x 5/8		1 3/8	13/16	1 5/8	1 1/16	0.3
1310	3,850	2	1	3 3/8	1 7/8	2	3/8 x 5/8		1 3/8	13/16	1 5/8	1 1/16	0.6
1610	4,300	2 1/4	1	3 5/8	2 1/8	2	3/8 x 5/8		1 3/8	13/16	1 5/8	1 1/16	0.7
1615	4,300	2 1/4	1 1/2	3 1/4	2 1/8	2	3/8 x 5/8		1 3/8	1 3/16	1 5/8	1 11/16	1.0
2012	7,150	2 3/4	1 1/4	4 3/8	2 5/8	2	7/16 x 7/8		1 9/16	15/16	2	1 3/8	1.4
2517	11,600	3 3/8	1 3/4	4 7/8	3 1/4	2	1/2 x 1		1 5/8	1	2 1/4	1 5/8	3.1
2525	11,300	3 3/8	2 1/2	4 1/2	3 1/4	2	1/2 x 1		1 5/8	1	2 1/4	1 5/8	3.5
3020	24,000	4 1/4	2	6 1/4	4	2	5/8 x 1 1/4		1 13/16	1 3/16	2 11/16	2 1/16	5.0
3030	24,000	4 1/4	3	5 3/4	4	2	5/8 x 1 1/4		1 13/16	1 3/16	2 11/16	2 1/16	7.4
3535	44,800	5	3 1/2	7	4 27/32	3	1/2 x 1 1/2	39	2	1 5/16	3 3/8	2 11/16	9.8
4040	77,300	5 3/4	4	8 1/2	5 35/64	3	5/8 x 1 3/4	40	2 3/8	1 5/8	4 1/8	3 3/8	15.4
4545	110,000	6 3/8	4 1/2	9 1/2	6 1/8	3	3/4 x 2	40	2 5/8	1 15/16	4 3/4	4 1/16	21.0
5050	126,000	7	5	10 1/2	6 23/32	3	7/8 x 2 1/4	37	2 13/16	2 5/16	5 1/4	4 13/16	29.0

+ Use in position shown in drawing above for tightening bushing on shaft. When loosening bushing, remove screws and use all except one in the other holes.

\* Space required to remove bushing using jackscrews - no puller required.

€ Standard hex key cut to minimum useable length.

• Peak torque loads must not exceed torque capacity rating shown. Capacity values shown are for light starting and steady running conditions. For more severe duty, divide torque capacity by service factor suggested in table below.

Note: Approx. weight in lbs. for an average size bore.



## SERVICE FACTOR

Service Factor	Type of Loading
1.0	Light starting & steady running
1.5	Light starting & uneven running
2.0	Fairly heavy starting & steady or uneven running
2.5	Light or heavy starting & moderate shock running
3.0	Light or heavy starting & severe shock running, or reversing loads

# TAPER-LOCK BUSHINGS

## STANDARD STOCK BORES (INCHES)

Bushing	List Price \$	Stock Bore	Keyseat
<b>1008</b>	<b>11.60</b>	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*
<b>1108</b>	<b>12.00</b>	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*
<b>1210</b>	<b>12.80</b>	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 · 3/32 3/16 · 3/32 1/4 x 1/8 1/4 x 1/8
<b>1215</b>	<b>14.00</b>	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
<b>1310</b>	<b>14.40</b>	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	1/8 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 1/8
<b>1610</b>	<b>14.80</b>	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*
<b>1615</b>	<b>15.40</b>	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*
<b>2012</b>	<b>20.00</b>	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*

Bushing	List Price \$	Stock Bore	Keyseat
<b>2517</b>	<b>24.60</b>	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 · 3/32 3/16 · 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 5/8 x 3/16* 5/8 x 3/16*
<b>2525</b>	<b>36.40</b>	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*
<b>3020</b>	<b>37.00</b>	7/8 15/16 · 1 · 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 2 3/4 2 13/16 · 2 7/8 · 2 15/16 3 · 3 1/8 · 3 3/16 · 3 1/4	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 5/16 5/8 x 5/16 5/8 x 5/16 3/4 x 1/4* 3/4 x 1/4*
<b>3030</b>	<b>54.00</b>	15/16 · 1 · 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 2 3/4 2 7/8 · 2 15/16 · 3 3 1/8 · 3 3/16 · 3 1/4	1/4 x 1/8 1/4 x 1/8 5/16 x 3/32 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 5/16 5/8 x 5/16 5/8 x 5/16 3/4 x 1/4* 3/4 x 1/4*

\* Shallow keyseat

BUSHINGS & HUBS

# TAPER-LOCK BUSHINGS

## STANDARD STOCK BORES (INCHES)

BUSHINGS & HUBS

Bushing	List Price \$	Stock Bore	Keyseat
3535	76.00	1 3/16 · 1 1/4	1/4 x 1/8
		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 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*		
4040	122.00	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	152.00	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	246.00	2 7/16 · 2 11/16	5/8 x 5/16
		2 15/16	3/4 x 3/8
		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		
<b>1008</b>	<b>11.60</b>	14 · 16	5 x 5		
		18 · 19 · 20 · 22	6 x 6		
		(24)	8 x 7		
<b>1108</b>	<b>12.00</b>	(12)	4 x 4		
		14 · (15) · 16	5 x 5		
		18 · 19 · 20 · 22	6 x 6		
		24 · 25	8 x 7		
<b>1210</b>	<b>12.80</b>	14 · (15) · 16	5 x 5		
		18 · 19 · 20 · 22	6 x 6		
		24 · 25 · 28 · 30	8 x 7		
		(32)	10 x 8		
<b>1215</b>	<b>14.00</b>	16	5 x 5		
		19 · 20	6 x 6		
		24 · 25 · 28 · 30	8 x 7		
		32	10 x 8		
<b>1310</b>	<b>14.40</b>	14 · 16	5 x 5		
		18 · 19 · 20 · 22	6 x 6		
		24 · 25 · 28 · 30	8 x 7		
		32 · 35	10 x 8		
<b>1610</b>	<b>14.80</b>	14 · 16	5 x 5		
		18 · 19 · 20 · 22	6 x 6		
		24 · 25 · 28 · 30	8 x 7		
		32 · 35 · 38	10 x 8		
		40	12 x 8		
		12	4 x 4		
		14 · 15 · 16	5 x 5		
		18 · 19 · 20 · 22	6 x 6		
<b>1615</b>	<b>15.40</b>	24 · 25 · 28 · 30	8 x 7		
		32 · 35 · 36 · 38	10 x 8		
		39 · 40	12 x 8		
		42	12 x 8*		
		<b>2012</b>	<b>20.00</b>	14 · 16	5 x 5
				18 · 19 · 20 · 22	6 x 6
24 · 25 · 28 · 30	8 x 7				
32 · 35 · 38	10 x 8				
40 · 42	12 x 8				
<b>2517</b>	<b>24.60</b>	45 · 48	14 x 9		
		14 · 16	5 x 5		
		18 · 19 · 20 · 22	6 x 6		
		24 · 25 · 28 · 30	8 x 7		
		32 · 35 · 38	10 x 8		
		40 · 42	12 x 8		
		45 · 48 · 50	14 x 9		
		55	16 x 10		
		60 · 65	18 x 11		

( ) = Contact Maska for availability  
 \* Shallow keyseat

Bushing	List Price \$	Stock Bore	Key
<b>2525</b>	<b>36.40</b>	19 · 20 · 22	6 x 6
		24 · 25 · 28 · 30	8 x 7
		32 · 35 · 36 · 38	10 x 8
		39 · 40 · 42	12 x 8
		45 · 48 · 50	14 x 9
		55	16 x 10
		60	18 x 11
		<b>3020</b>	<b>37.00</b>
32 · 35 · 38	10 x 8		
40 · 42	12 x 8		
45 · 48 · 50	14 x 9		
55	16 x 10		
		60 · 65	18 x 11
		70 · 75	20 x 12
		22	6 x 6
		24 · 25 · 28 · 30	8 x 7
<b>3030</b>	<b>54.00</b>	32 · 35 · 36 · 38	10 x 8
		39 · 40 · 42	12 x 8
		45 · 48 · 50	14 x 9
		55	16 x 10
		60 · 65	18 x 11
		70 · 75	20 x 12
<b>3535</b>	<b>76.00</b>	35 · 38	10 x 8
		40 · 42	12 x 8
		45 · 48 · 50	14 x 9
		55	16 x 10
		60 · 65	18 x 11
		70 · 75	20 x 12
		80 · 85	22 x 14
		90	25 x 14
<b>(4040)</b>	<b>122.00</b>	48	14 x 9
		55	16 x 10
		60 · 65	18 x 11
		70 · 75	20 x 12
		80 · 85	22 x 14
		90 · 95	25 x 14
		100 · 110	28 x 16
		55	16 x 10
		60 · 65	18 x 11
		70 · 75	20 x 12
		80 · 85	22 x 14
		90 · 95	25 x 14
<b>(4545)</b>	<b>152.00</b>	100 · 105 · 110	28 x 16
		115 · 120	32 x 18
		55	16 x 10
		60 · 65	18 x 11
		70 · 75	20 x 12
<b>(5050)</b>	<b>246.00</b>	80 · 85	22 x 14
		90 · 95	25 x 14
		100 · 110	28 x 16
		115 · 120 · 125	32 x 18
		55	16 x 10
		60 · 65	18 x 11
		70 · 75	20 x 12
		80 · 85	22 x 14
		90 · 95	25 x 14
		100 · 110	28 x 16

BUSHINGS & HUBS