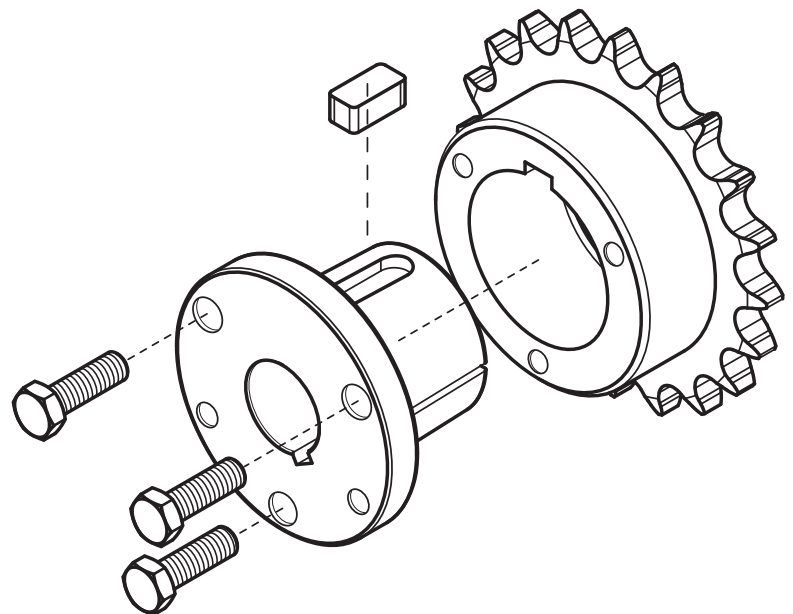


The MST® bushings are easy to install and remove. They are split through the barrel and have a taper to provide a true clamp on the shaft. They are keyed to both the shaft and the hub to help during “blind” installations.

INSTALLATION

1. Be sure the tapered cone surfaces of the bushing and the inside of the driven product are clean and free of anti-seize lubricants.
2. Place bushing in sprocket or other Martin MST® part.
3. Place cap screws loosely in pull-up holes. Bushing remains loose to assure sliding fit on shaft
4. With key on shaft, slide sprocket to desired position on shaft. Be sure heads of cap screws are accessible.
5. Align sprocket. Tighten screws alternately and progressively - until they are pulled up tight (see table below). Do not use extensions on wrench handles. Do not allow sprocket to be drawn in contact with flange of bushing. There should be a gap between bushing flange and sprocket. **CAUTION: THIS GAP MUST NOT BE CLOSED**



REMOVAL

1. Loosen and remove cap screws.
2. Insert cap screws in tapped removal holes.
3. Tighten inserted screws until sprocket is loose on shaft.
4. Remove sprocket from shaft.

WRENCH TORQUE VALUE FOR TIGHTENING BUSHING

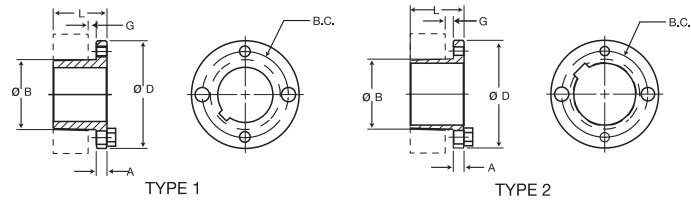
MST® Bushing Size	Size of Cap Screw	Wrench Torque in/lb
G	1/4 × 5/8	95
H	1/4 × 3/4	95
P	5/16 × 1	192
Q	3/8 × 1 1/4	348
R	3/8 × 1 3/4	348
S	1/2 × 2 1/4	840
U	5/8 × 2 3/4	1680
W	3/4 × 3	3000

CAUTION

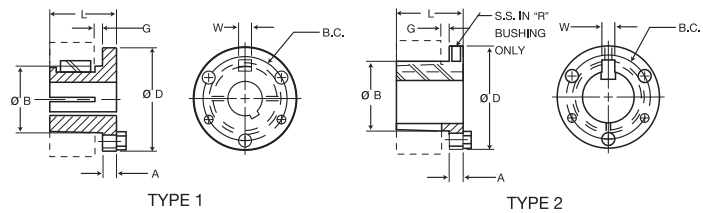
WARNING: USE OF ANTI-SEIZE LUBRICANT ON TAPERED CONE SURFACE OR ON BOLT THREADS WHEN MOUNTING MAY RESULT IN DAMAGE TO SHEAVE AND SPROCKETS. THIS VOIDS ALL MANUFACTURER’S WARRANTIES

WARNING: Because of the possible danger to person(s) or property from accidents which may result from the improper use of products, it is important that correct procedures be followed: Products must be used in accordance with the engineering information specified in the catalog. Proper installation, maintenance and operation procedures must be observed. The instructions given above must be followed. Inspections should be made as necessary to assure safe operation under prevailing conditions. All rotating power transmission products when used in a drive are potentially dangerous and must be guarded by the user as required by applicable laws, regulations, standards, and good safety practice. (Refer to ANSI Standard B15.1.)

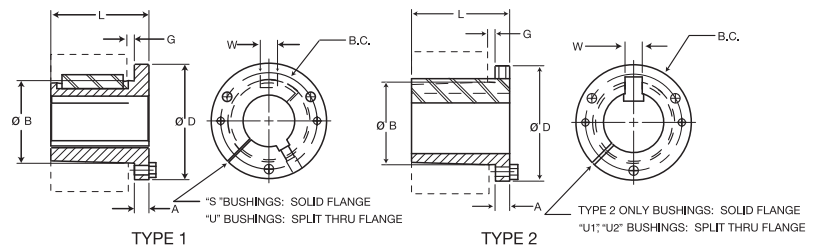
MST® Bushings



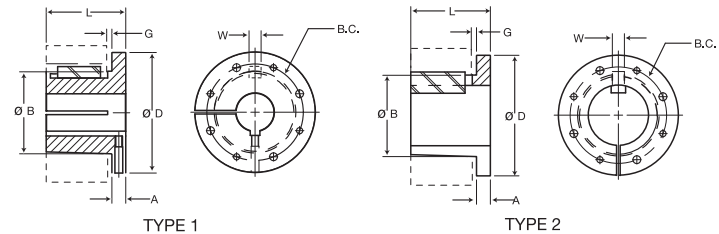
"G" & "H" BUSHINGS



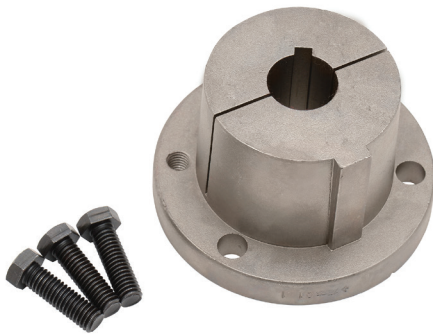
"P", "Q" & "R" BUSHINGS



"S" & "U" BUSHINGS



"W" BUSHINGS



Bushing Specifications

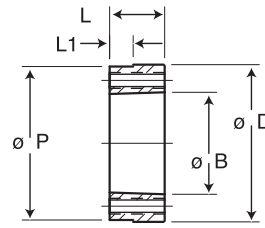
Part Number	Bushing Torque Capacity (in-lb)	Dimensions							Stock Bore Range		Cap Screws		Av. Wt. (lb)	Wrench Torque In./lbs.
		D	L	A	B Large End	G	B.C.	W	Type 1	Type 2	No.	Size		
G	1,000	2.000	1.000	0.250	1.172	0.190	1.560	—	0.375 - 0.938	1.000	2	1/4 × 5/8	.5	95
H	2,500	2.500	1.250	0.250	1.625	0.190	2.000	—	0.375 - 1.375	1.438 - 1.500	2	1/4 × 3/4	.8	95
P1	8,500	3.000	1.940	0.410	1.938	0.220	2.440	0.375	0.500 - 1.438	1.500 - 1.750	3	5/16 × 1	1.3	192
P2	12,000	3.000	2.940	0.410	1.938	0.220	2.440	0.375	0.750 - 1.438	1.500 - 1.750	3	5/16 × 1	1.5	192
P3	14,000	3.000	4.440	0.410	1.938	0.220	2.440	0.375	1.125 - 1.375	1.625	3	5/16 × 1	2.0	192
Q1	21,000	4.120	2.500	0.530	2.875	0.220	3.380	0.500	0.750 - 2.063	2.125 - 2.688	3	3/8 × 1 1/4	3.5	348
Q2	26,000	4.120	3.500	0.530	2.875	0.220	3.380	0.500	1.000 - 2.063	2.125 - 2.625	3	3/8 × 1 1/4	4.5	348
Q3	36,000	4.120	5.000	0.530	2.875	0.220	3.380	0.500	1.375 - 2.063	2.125 - 2.500	3	3/8 × 1 1/4	5.5	348
R1	33,000	5.380	2.880	0.620	4.000	0.250	4.620	0.750	1.125 - 2.813	2.875 - 3.750	3	3/8 × 1 3/4	7.5	348
R2	53,000	5.380	4.880	0.620	4.000	0.250	4.620	0.750	1.375 - 2.813	2.875 - 3.625	3	3/8 × 1 3/4	11.0	348
S1	52,000	6.380	4.380	0.750	4.625	0.310	5.380	0.750	1.688 - 3.188	3.250 - 4.250	3	1/2 × 2 1/4	13.5	840
S2	81,000	6.380	6.750	0.750	4.625	0.310	5.380	0.750	1.875 - 3.188	3.250 - 4.188	3	1/2 × 2 1/4	19.0	840
U0	105,000	8.380	5.250	1.060	6.000	0.440	7.000	1.250	2.375 - 3.063	—	3	5/8 × 2 3/4	30.0	1680
U0	105,000	8.380	4.940	0.75	6.000	0.440	7.000	1.250	3.250 - 4.250	4.375 - 5.500	3	5/8 × 2 3/4	27.0	1680
U1	151,000	8.380	7.120	1.060	6.000	0.440	7.000	1.250	2.375 - 4.250	4.375 - 5.500	3	5/8 × 2 3/4	40.0	1680
U2	215,000	8.380	10.120	1.060	6.000	0.440	7.000	1.250	2.438 - 4.250	4.375 - 5.000	3	5/8 × 2 3/4	50.0	1680
W1	287,000	12.500	8.250	1.440	8.500	0.440	10.000	1.250	3.375 - 6.188	6.250 - 7.438	4	3/4 × 3	104.0	3000
W2	391,000	12.500	11.250	1.440	8.500	0.440	10.000	1.250	3.375 - 6.188	6.250 - 7.438	4	3/4 × 3	133.0	3000

All tapers are .75" per 12" on Diameter.

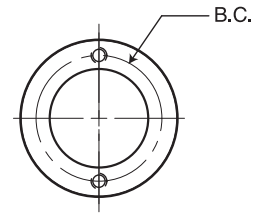
All dimensions are in inches except, as noted.

All bushings are cast iron, ductile iron, sintered steel, or steel. Consult manufacturer for clarification.

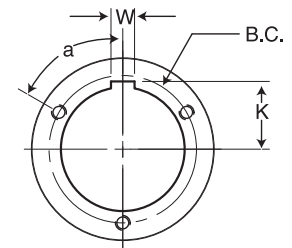
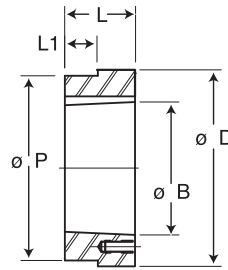
Metric bushings also available.



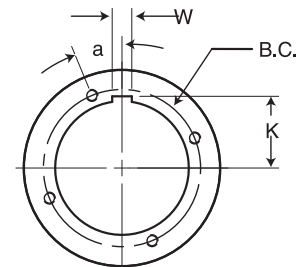
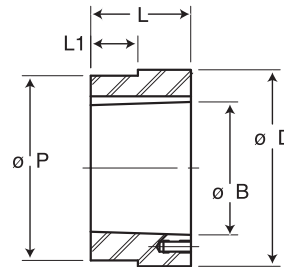
ALL TAPERS .75" PER FT. ON DIAMETER



"H" HUBS



"P", "Q", "R", "S", "Y" "U" HUBS



"W" HUBS

Bushing Specifications

Part Number	For Bushing	Dimensions									Tapped Holes		Wt. Lbs.
		D	L	P	L1	B	K	B.C.	W	a°	No.	Size	
HH1	H	2.500	0.880	2.375	0.174	1.621	—	2.000	—	—	2	1/4 - 20	.6
HCH1	H	2.500	0.880	2.375	0.625	1.621	—	2.000	—	—	2	1/4 - 20	.7
HP1	P1	3.000	1.310	2.875	0.292	1.938	1.094	2.438	0.375	60	3	5/16 - 18	1.4
HCP1	P1	3.000	1.310	2.875	1.000	1.938	1.094	2.438	0.375	60	3	5/16 - 18	1.1
HP2	P2	3.000	2.310	2.875	1.100	1.938	1.094	2.438	0.375	60	3	5/16 - 18	2.5
HQ1	Q1	4.500	1.750	4.375	0.709	2.875	1.562	3.375	0.500	60	3	3/8 - 16	4.4
HCQ1	Q1	4.500	1.750	4.375	1.250	2.875	1.562	3.375	0.500	60	3	3/8 - 16	4.4
HQ2	Q2	4.500	2.750	4.375	1.606	2.875	1.562	3.375	0.500	60	3	3/8 - 16	6.9
HR1	R1	5.750	2.000	5.625	0.709	4.000	2.188	4.625	0.750	60	3	3/8 - 16	7.3
HR2	R2	5.750	4.000	5.625	1.606	4.000	2.188	4.625	0.750	60	3	3/8 - 16	15.4
HS1	S1	6.750	3.310	6.500	0.946	4.625	2.562	5.375	0.750	60	3	1/2 - 13	17.3
HS2	S2	6.750	5.690	6.500	2.963	4.625	2.562	5.375	0.750	60	3	1/2 - 13	30.4
HU0	U0	8.500	3.750	8.250	2.000	6.000	3.250	7.000	1.250	60	3	5/8 - 11	32.0
HU1	U1	8.500	5.620	8.250	2.963	6.000	3.250	7.000	1.250	60	3	5/8 - 11	44.6
HU2	U2	8.500	8.620	8.250	6.016	6.000	3.250	7.000	1.250	60	3	5/8 - 11	69.0
HW1	W1	12.500	6.380	12.250	2.963	8.500	4.562	10.000	1.250	22.5	4	3/4 - 10	130.0

All tapers are .75" per 12" on Diameter.

All dimensions are in inches, except as noted.