



QD® Bushings Bolt Torque Values

Bushing Style	Bolts (in)		Torque Wrench	
	Qty.	Size	lb-ft	lb-in
H	2	1/4 x 3/4	7.9	95
JA	3	10-24 x 1	4.5	54
SH & SDS	3	1/4-20 x 1 3/8	9.0	108
SD	3	1/4-20 x 1 7/8	9.0	108
SK	3	5/16-18 x 2	15.0	180
SF	3	3/8-16 x 2	30.0	360
E	3	1/2-13 x 2 3/4	60.0	720
F	3	9/16-12 x 3 5/8	75.0	900
J	3	5/8-11 x 4 1/2	135.0	1620
M	4	3/4-10 x 6 3/4	225.0	2700
N	4	7/8-9 x 8	300.0	3600
P	4	1-8 x 9 1/2	450.0	5400
W	4	1 1/8-7 x 11 1/2	600.0	7200
S	5	1 1/4-7 x 15 1/2	750.0	9000

- To insure proper performance, full bushing contact on the shaft is recommended.
- Alternately tighten the cap screws until the sprocket/sheave and bushing tapers are completely seated together (use half of the recommended bolt torque)
- Check and correct the alignment and axial sprocket/sheave run out (wobble).
- Continue alternate tightening of the cap screws to the recommended torque values
- Do not tighten cap screws past the recommended torque values. Excessive torque can cause the sprocket/sheave or bushing to break.
- When properly mounted, a gap between the bushing flange and sprocket/sheave should exist.

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