

Grip Tight® Fan Bushing

These instructions must be read thoroughly before installation or operation. This instruction manual was accurate at the time of printing. Please see dodgeindustrial.com for updated instruction manuals.

WARNING: To ensure the drive is not unexpectedly started, turn off and lock-out or tag power source before proceeding. Failure to observe these precautions could result in bodily injury.

WARNING: All products over 25 kg (55 lbs) are noted on the shipping package. Proper lifting practices are required for these products.

ASSEMBLE GRIP TIGHT FAN BUSHING

This process is only necessary if Grip Tight Fan Bushing has been disassembled.

1. Place locknut on bushing sleeve on groove.
2. Insert threaded adapter sleeve through bushing sleeve, opposite the nut side, until it rests against the locknut.
3. Rotate locknut clockwise until adapter sleeve threads engage.



Adapter Sleeve Bushing Sleeve Locknut

Figure 1 - Grip Tight Fan Bushing Assembly

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 in the instruction manuals must be followed. Inspections should be made as necessary to assure safe operation under prevailing conditions. Proper guards and other suitable safety devices or procedures as may be desirable or as may be specified in safety codes should be provided, and are neither provided by Dodge® nor are the responsibility of Dodge. This unit and its associated equipment must be installed, adjusted and maintained by qualified personnel who are familiar with the construction and operation of all equipment in the system and the potential hazards involved. When risk to persons or property may be involved, a holding device must be an integral part of the driven equipment beyond the speed reducer output shaft.

SHAFT & MOUNTING SURFACE INSPECTION

Shaft should be smooth, straight, & within commercial tolerances (Table 1). Remove any burrs from the shaft and bore of the mounting surface with emory cloth and then clean.

Table 1 - Shaft Tolerances

Shaft Size (in)	Commercial Shaft Tolerances (in)
Up to 1-1/2"	+0.000" to -0.002"
1-5/8" to 2-1/2"	+0.000" to -0.003"
2-11/16" to 3-7/16"	+0.000" to -0.004"

INSTALLATION

NOTE: When mounting (two) Grip Tight Fan Bushings to the same shaft, special attention must be given to the installation process as the mounting procedure of the second bushing assembly differs from the first.

FIRST GRIP TIGHT FAN BUSHING

Remove all weight from shaft. Slide the first Grip Tight Fan Bushing assembly over the shaft and into the bore of the component. Component bore should be within tolerance listed in Table 2.

Table 2 - Housing Bore Tolerance

Bushing O.D. (in)	Housing Bore Tolerance (in)
1.256 - 1.932	+0.0040/-0.0000
2.080 - 3.083	+0.0047/-0.0000
3.410 - 3.962	+0.0055/-0.0000

If the unit will not slip onto the shaft hold the adapter and rotate the locknut counter-clockwise to expand the adapter sleeve.

1. Using gloves, rotate locknut clockwise by hand as tight as possible. When this step is completed neither the fan nor adapter sleeve should be able to slide axially on the shaft. It may be necessary to tap on the O.D. of the locknut during the tightening process if the adapter is spinning with the locknut.
2. Scribe a line on the locknut above the adapter sleeve slot. Lock the assembly by rotating the locknut with a spanner wrench or drift pin and hammer; clockwise by the amount shown in Table 3.

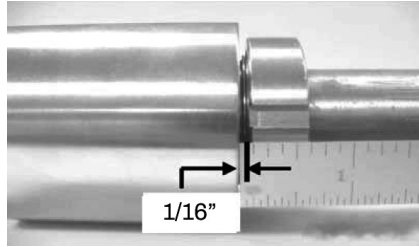
Table 3 - Locknut Tightening Rotation

Shaft Size (in)	Locknut Rotation
Up to 1-11/16"	2/3 Turn
1-15/16" to 3-7/16"	1 Turn

3. Tighten setscrew, found in the O.D. of the locknut, with a 3/32" hex key to 25 in.-lbs., or until hex key bends.

SECOND GRIP TIGHT FAN BUSHING

4. Slide the second Grip Tight Fan Bushing assembly over the shaft and into the bore of the component leaving a $\frac{1}{16}$ " gap between the bushing face and component shoulder (Figure 2).



**Figure 2 - Gap for Second Grip
Tight Fan Bushing**

5. Maintaining the $\frac{1}{16}$ " gap, using gloves, rotate locknut clockwise by hand until it is tight such that the adapter sleeve grips and does not spin on the shaft. Tapping the O.D. of the locknut may be required.
6. Continue mounting following steps 2 and 3 above.

DISMOUNTING

1. Remove all weight from shaft.
2. Completely loosen set screw which is found on the O.D. of the locknut.
3. While tapping on the O.D. of the locknut with a hammer, rotate locknut counter-clockwise until assembly freely slides from the shaft.

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