

## INSTRUCTION MANUAL FOR QD &amp; XT Conveyor Pulley Bushings

**WARNING:** To ensure that 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.

**INSTALLATION:**

1. Determine bushing size from marking(s) on the bushing face.
2. Clean shaft, bore and outside of bushings, and bore of hubs (remove bushings from hubs if already assembled). Remove all oil, grease and dirt.
3. Slide shaft into pulley and slip bushings onto shaft and into hubs. If required, carefully insert a wedge into bushing split and tap lightly to allow bushing to slide onto shaft. Align unthreaded holes in bushing with threaded holes in hub. Place screws loosely in bushing holes that are not threaded.
4. Locate shaft in desired position, remove wedges if used and tighten screws in each bushing slightly to seat bushings in hubs.
5. Tighten screws alternately and evenly in one bushing only until all screws are pulled up to the proper wrench torque listed in the table. Do not over-torque. If a keyseated bushing is used without a key, fill the keyseat with grease.
6. Check to ensure the bushing flange does not contact the hub.
7. Now tighten the second bushing per steps 5 & 6 above.

**REMOVAL:**

1. Remove all screws. Oil threads and points of capscrews.
2. Insert screws into threaded holes on the bushing flange.
3. Tighten screws alternately until bushings are

loosened in hubs. If bushing does not loosen, carefully insert a wedge into the bushing split and tap lightly to allow bushing to slide on shaft.

**GENERAL OPERATION INSTRUCTIONS:**

1. Do not allow material to be trapped between the belt and pulley face. Do not allow material to build up on pulley face.
2. Do not allow edge of conveyor belt to wander past the edge of the pulley.
3. Do not skew the pulley in an attempt to track the conveyor belt.
4. Do not re-torque bolts.

**MAINTENANCE:** Inspect the bushings and check the torque setting before startup and once a week for the first month of operation. Thereafter repeat at periodic maintenance intervals.

Recommended Wrench Torque				
Bushing Type	Screws		Torque Ft-Lbs.	
	Qty.	Size		
QD	DBQ-SH	3	1/4"-20 NC	9
	DBQ-SDS	3	1/4"-20 NC	9
	DBQ-SF	3	3/8"-16 NC	30
	DBQ-E	3	1/2"-13 NC	60
	DBQ-F	3	9/16"-12 NC	75
	DBQ-JS	3	5/8"-11 NC	135
	DBQ-MS	4	3/4"-10 NC	225
	DBQ-NS	4	7/8"-9 NC	300
	DBQ-PS	4	1"-8 NC	450
	DBQ-WS	4	1-1/8"-7 NC	600
XT	DBX-15	4	1/4"-20 NC	8
	DBX-20	4	5/16"-18 NC	17
	DBX-25	4	3/8"-16 NC	30
	DBX-30	4	7/16"-14 NC	46
	DBX-35	4	1/2"-13 NC	70
	DBX-40	4	9/16"-12 NC	100
	DBX-45	4	5/8"-11 NC	140
	DBX-50	4	3/4"-10 NC	250
	DBX-60	4	7/8"-9 NC	400
	DBX-70	4	1"-8 NC	600
DBX-80	4	1-1/8"-7 NC	750	
DBX-100	6	1-1/8"-7 NC	750	

**WARNING:** Because of 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 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 specified in safety codes should be provided. These are neither provided by Douglas Manufacturing Co. nor are the responsibility of Douglas Manufacturing Co. These bushings must be installed, adjusted and maintained by qualified personnel who are familiar with the construction and operation of all equipment in the system and 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.