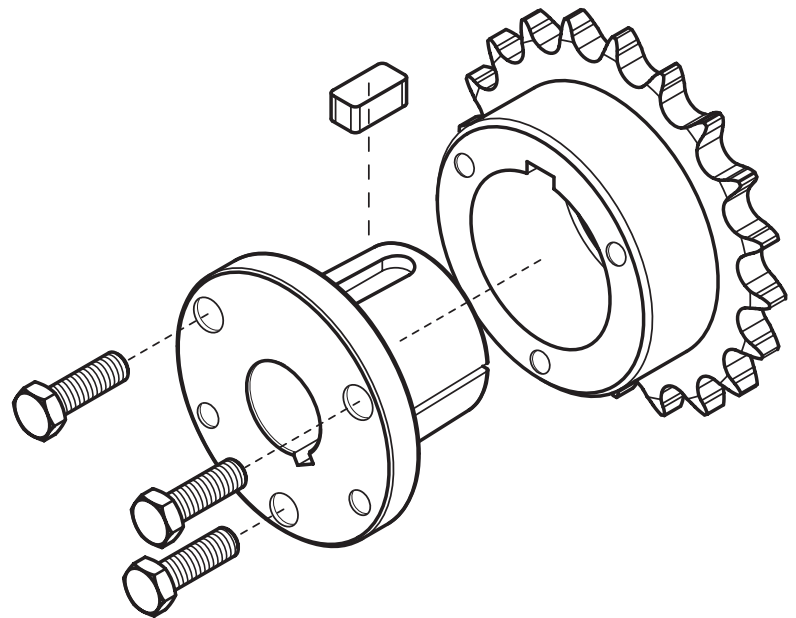


The MST® bushings are easy to install and remove. They are split through the barrel and have a taper to provide a true clamp on the shaft. They are keyed to both the soft and the hub to help during “blind” installations.

## 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 tapered removal holes.
3. Tighten inserted screws until sprocket is loose on shaft.
4. Remove sprocket from shaft.

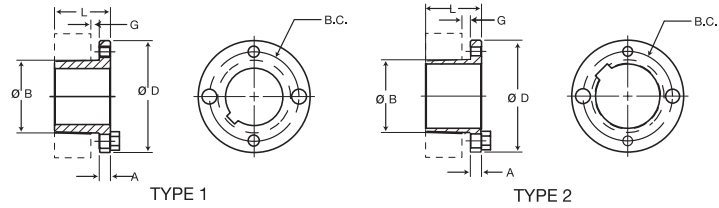
### WRENCH TORQUE VALUE FOR TIGHTENING BUSHING

MST® Bushing Size	Size of Cap Screw	Wrench Torque in/lb
G	.25 × .625	95
H	.25 × .75	95
P	.313 × 1	192
Q	.375 × 1.25	348
R	.375 × 1.75	348
S	.5 × 2.25	840
U	.625 × 2.75	1680
W	.75 × 3	3000

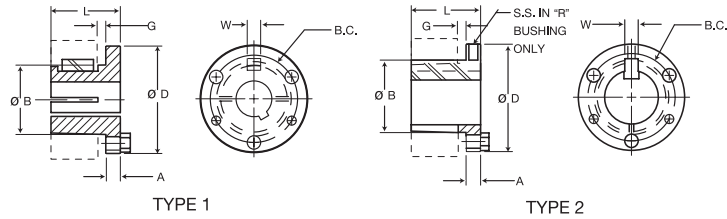
## CAUTION

**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**

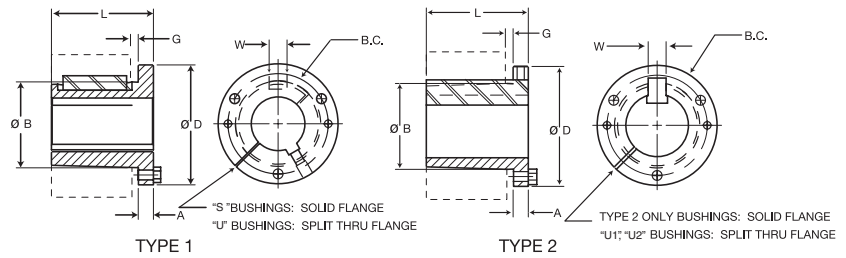
**WARNING:** Because of the possible danger to person(s) or property from accidents which may result from the improper use of products, it is important that correct procedures be followed: Products must be used in accordance with the engineering information specified in the catalog. Proper installation, 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.)



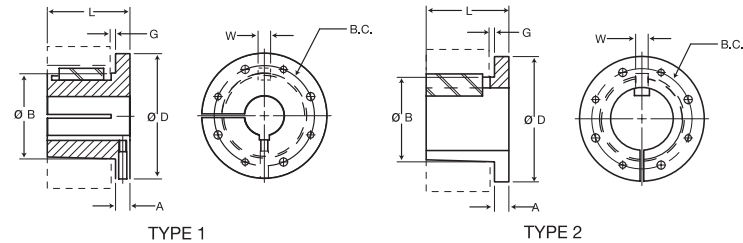
“G” & “H” BUSHINGS



“P”, “Q” & “R” BUSHINGS



“S” & “U” BUSHINGS



“W” BUSHINGS



## Bushing Specifications

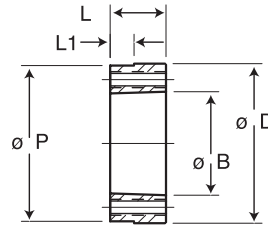
Part Number	Dimensions							Stock Bore Range		Cap Screws		Av. Wt. Lbs.	Wrench Torque In./lbs.
	D	L	A	B Large End	G	B.C.	W	Type 1	Type 2	No.	Size		
G	2	1.00	.25	1.172	.19	1.56	—	.375 – .938	1	2	.25 × .625	.5	95
H	2.5	1.25	.25	1.625	.19	2	—	.375 – 1.375	1.438 – 1.5	2	.25 × .75	.8	95
P1	3	1.94	.41	1.938	.22	2.44	.375	.5 – 1.438	1.5 – 1.75	3	.313 × 1	1.3	192
P2	3	2.94	.41	1.938	.22	2.44	.375	.75 – 1.438	1.5 – 1.75	3	.313 × 1	1.5	192
P3	3	4.44	.41	1.938	.22	2.44	.375	1.125 – 1.375	1.625	3	.313 × 1	2.0	192
Q1	4.12	2.50	.53	2.875	.22	3.38	.5	.75 – 2.063	2.125 – 2.688	3	.375 × 1.25	3.5	348
Q2	4.12	3.50	.53	2.875	.22	3.38	.5	1 – 2.063	2.125 – 2.625	3	.375 × 1.25	4.5	348
Q3	4.12	5.00	.53	2.875	.22	3.38	.5	1.375 – 2.063	2.125 – 2.5	3	.375 × 1.25	5.5	348
R1	5.38	2.88	.62	4	.25	4.62	.75	1.125 – 2.813	2.875 – 3.75	3	.375 × 1.75	7.5	348
R2	5.38	4.88	.62	4	.25	4.62	.75	1.375 – 2.813	2.875 – 3.625	3	.375 × 1.75	11.0	348
S1	6.38	4.38	.75	4.625	.31	5.38	.75	1.688 – 3.188	3.25 – 4.25	3	.5 × 2.25	13.5	840
S2	6.38	6.75	.75	4.625	.31	5.38	.75	1.875 – 3.188	3.25 – 4.188	3	.5 × 2.25	19.0	840
U0	8.38	5.25	1.06	6	.44	7	1.25	2.375 – 3.063	—	3	.625 × 2.75	30.0	1680
U0	8.38	4.94	.75	6	.44	7	1.25	3.25 – 4.25	4.375 – 5.5	3	.625 × 2.75	27.0	1680
U1	8.38	7.12	1.06	6	.44	7	1.25	2.375 – 4.25	4.375 – 5.5	3	.625 × 2.75	40.0	1680
U2	8.38	10.12	1.06	6	.44	7	1.25	2.438 – 4.25	4.375 – 5	3	.625 × 2.75	50.0	1680
W1	12.5	8.25	1.44	8.5	.44	10	1.25	3.375 – 6.188	6.25 – 7.438	4	.75 × 3	104.0	3000
W2	12.5	11.25	1.44	8.5	.44	10	1.25	3.375 – 6.188	6.25 – 7.438	4	.75 × 3	133.0	3000

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

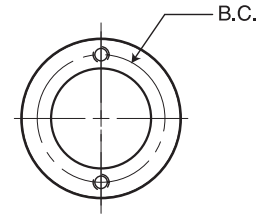
All dimensions are in inches except, as noted.

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

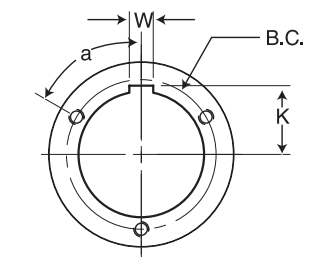
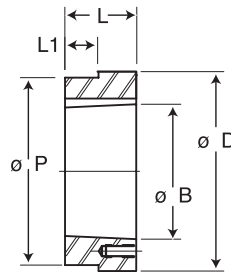
Metric bushings also available.



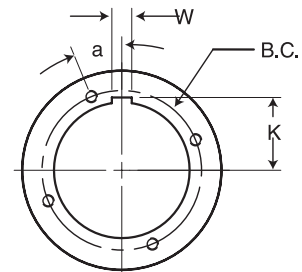
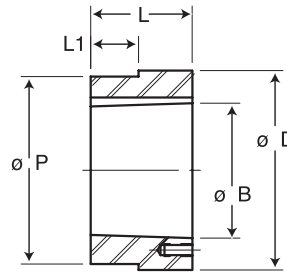
ALL TAPERS .75" PER FT.  
ON DIAMETER



"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	2.5	.88	2.375	.174	1.621	—	2	—	—	2	.25 – 20	.6
HCH1	H	2.5	.88	2.375	.625	1.621	—	2	—	—	2	.25 – 20	.7
HP1	P1	3.0	1.31	2.875	.292	1.938	1.094	2.438	.375	60	3	.313 – 18	1.4
HCP1	P1	3.0	1.31	2.875	1	1.938	1.094	2.438	.375	60	3	.313 – 18	1.1
HP2	P2	3	2.31	2.875	1.1	1.938	1.094	2.438	.375	60	3	.313 – 18	2.5
HQ1	Q1	4.5	1.75	4.375	.709	2.875	1.562	3.375	.5	60	3	.375 – 16	4.4
HCQ1	Q1	4.5	1.75	4.375	1.25	2.875	1.562	3.375	.5	60	3	.375 – 16	4.4
HQ2	Q2	4.5	2.75	4.375	1.606	2.875	1.562	3.375	.5	60	3	.375 – 16	6.9
HR1	R1	5.75	2.00	5.625	.709	4	2.188	4.625	.75	60	3	.375 – 16	7.3
HR2	R2	5.75	4.00	5.625	1.606	4	2.188	4.625	.75	60	3	.375 – 16	15.4
HS1	S1	6.75	3.31	6.5	.946	4.625	2.562	5.375	.75	60	3	.5 – 13	17.3
HS2	S2	6.75	5.69	6.5	2.963	4.625	2.562	5.375	.75	60	3	.5 – 13	30.4
HU0	U0	8.5	3.75	8.25	2	6	3.25	7	1.25	60	3	.625 – 11	32.0
HU1	U1	8.5	5.62	8.25	2.963	6	3.25	7	1.25	60	3	.625 – 11	44.6
HU2	U2	8.5	8.62	8.25	6.016	6	3.25	7	1.25	60	3	.625 – 11	69.0
HW1	W1	12.5	6.38	12.25	2.963	8.5	4.562	10	1.25	22.5	4	.75 – 10	130.0

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

All dimensions are in inches, except as noted.