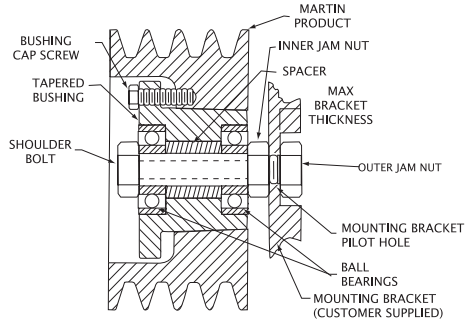
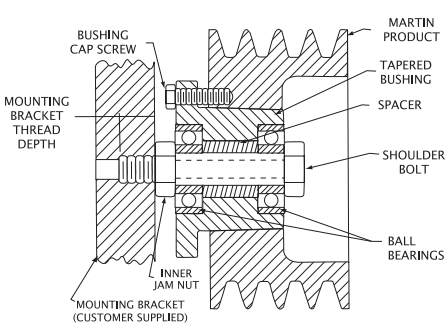


Martin MST IDLER BUSHING MOUNTING INSTRUCTIONS



INSTALLATION:

1. Make sure that the shoulder bolt will fit into the mounting bracket.
2. Remove the outer jam nut.
3. Make sure the inner jam nut is properly torqued (see Table A)



⚠ WARNING

Disconnect power before installation and maintenance. Failure to do so can result in severe injury or death.


⚠ CAUTION

Do NOT over tighten the inner jam nut.

TABLE A

Idler Bushing	SAE Grade 5 Shoulder Bolt Size	Mounting Bracket Thread Depth (min)	Tightening Torque	
			lb-in	N-m
H-BB 1/2	1/2-13NC	.77"	300	33.9
P1-BB 5/8	5/8-11NC	1.00"	350	39.5
Q1-BB 3/4	3/4-10NC	.923"	550	62.1
Q1-BB 1	1-8NC	1.08"	800	90.3

4. Prior to assembly of idler product onto bushing, make sure bushing barrel and product bore are free of contaminants (such as paints or oils) and no burrs exist.



⚠ WARNING

Lubricant on bushing barrel, hub or screws could lead to breakage.

Do NOT use lubricants or anti seize material on bushing barrel, hub or threaded surfaces.

5. Align mounting holes, insert cap screws and loosely thread them into the idler product.

Martin MST IDLER BUSHING MOUNTING INSTRUCTIONS (cont'd)

- Tighten cap screws sequentially, progressing in small stages until they are tightened to the proper torque. (see Table B).

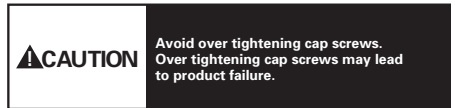


TABLE B

Idler Bushing	SAE Grade 5 Cap Screws		Tightening Torque	
	Number	Size	lb-in	N-m
H-BB 1/2	2	1/4-20NC	95	10.7
P1-BB 5/8	3	5/16-18NC	192	21.7
Q1-BB 3/4	3	3/8-16NC	348	39.3
Q1-BB 1	3	3/8-16NC	348	39.3

- Make sure there is a gap between the bushing flange and the idler product face. **If there is no gap, disassemble the parts and determine the reason for the faulty assembly.**
- Install shoulder bolt into mounting bracket. Tighten shoulder bolt into bracket (tapped style bracket), or tighten outer jam nut (plain style hole bracket) to torque limit shown in Table A.
- Make sure all drive components are aligned properly (see Fig. 3).

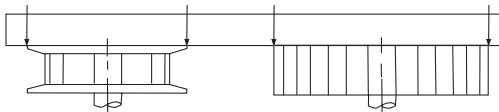


Fig. 3

REMOVAL:

- Remove cap screws.
- Place cap screws in threaded bushing flange holes.
- Tighten cap screws against the idler product face until screw force releases the idler product from the idler bushing.

