

Martin MXT BUSHING INSTALLATION AND REMOVAL INSTRUCTIONS

8. When two bushings are used, completely tighten the screws on one bushing before proceeding to tighten the other one.
9. Since tightening the cap screws may affect the axial position of the product, confirm that it is still properly aligned with its running mate. If not, determine how much the assembly must be moved to be in proper alignment.
10. If axial adjustment is required, follow REMOVAL procedure, reposition the assembly, and repeat steps 7 and 8.
11. Check installation gap. There must be a gap between the bushing flange and the hub face, if there is no gap between them, disassemble the parts, follow REMOVAL procedure, and determine the reason(s) for the faulty assembly.

REMOVAL:

1. Remove all screws sequentially as shown on Drawing 2, 3, 4 and 5 using the Roman numeral sequence.
2. Insert cap screws in all threaded bushing flange holes (C). Tighten the cap screws against hub face of the product until the screw force releases the product from the bushing. If the bushing does not release immediately, tap on the hub with a hammer.
3. When two bushings are used, completely loosen the screws on one bushing before proceeding to loosen the other one.
4. Remove the bushing(s) and product from the shaft using appropriate means.

**TABLE B
RECOMMENDED WRENCH TORQUE**

MXT SIZE	SAE Grade 8 Cap Screw		CAP SCREW TORQUE		
	NO.	SIZE	(lb-in)	(ft-lb)	(N-m)
15	4	1/4 - 20UNC	95	8	10.7
20	4	5/16 - 18UNC	192	16	21.7
25	4	3/8 - 16UNC	348	29	39.3
30	4	7/16 - 14UNC	552	46	62.4
35	4	1/2 - 13UNC	840	70	94.9
40	4	9/16 - 12UNC	1200	100	135.6
45	4	5/8 - 11UNC	1680	140	189.8
50	4	3/4 - 10UNC	3000	250	339.0
60	4	7/8 - 9UNC	4800	400	542.3
70	4	1 - 8UNC	7200	600	813.5
80	4	1 1/8 - 7UNC	9000	750	1016.9
100	6	1 1/8 - 7UNC	9000	750	1016.9
120	8	1 1/8 - 7UNC	9000	750	1016.9
140	10	1 1/8 - 7UNC	9000	750	1016.9

(N - M) = Newton Meters

**TABLE A
RECOMMENDED WRENCH TORQUE**

Shaft Size Range (in)		Lower Shaft Size Limit (in)
Above	Through	
-	1 1/2	-0.003
1 1/2	2 1/2	-0.004
2 1/2	4	-0.005
4	6	-0.006
6	8	-0.007
8	9	-0.008
9	-	-0.009

Note: Upper limit is +0.



