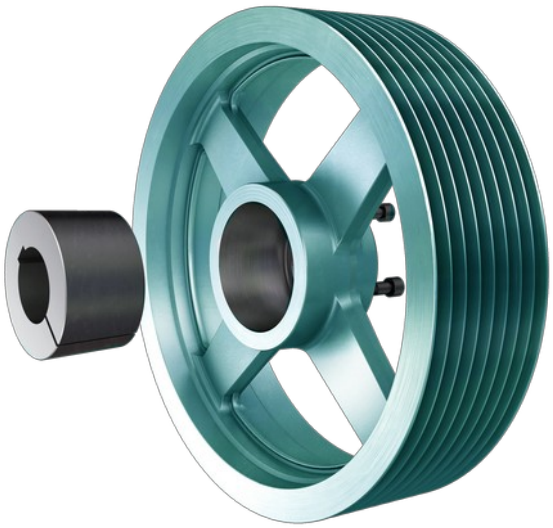
Magic-Grip-T®



1. CONTENT

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2. ASSEMBLY

- Clean the shaft, the taper bush, the screws and the inner taper bore of the pulley.
- Fit the slitted taper bush onto the shaft using a screwdriver put into the slit to open it (see Figure 1 page 2).
    - NB : It is possible, at this level, to achieve a simplified drive alignment as described in § 3.1 - Alignment of bushes page 2.
- Grease the taper bore of the pulley and fit it onto the bush (see Figure 2) in aligning the fixing holes with the tapped holes in bush.
- Grease thread and under head of the 2 screws, fit them (see Figure 3) and then tighten each screw progressively and alternately up to full tightening (Figure 4) set to values shown in Tableau 1


Figure 1: Fit the bush


Figure 2: Fit the pulley


Figure 3: Align fixing holes


Figure 4: Tighten to recommended torque

Tableau 1: Tightening torques of screws

Bush N°	Bore		Screws	Tightening torque (Nm)
	Mini	Maxi		
25	*13*	*25*	M4 x 20/20	2,5
28	*13*	*28*	M4 x 20/20	2,5
32	*12*	*32*	M5 x 25/25	5
36	*14*	*36*	M5 x 25/25	5
40	*14*	*40*	M6 x 30/30	8,4
45	*16*	*45*	M6 x 30/30	8,4
50	*19*	*50*	M8 x 35/35	20
56	*22*	*56*	M8 x 35/35	20
63	*24*	*63*	M10 x 45/45	40
80	*28*	*80*	M12 x 50/50	68
100	*40*	*100*	M16 x 60/60	165
125	*50*	*125*	M20 x 75/75	320
160	*63*	*160*	M24 x 90/90	560
200	*80*	*200*	M30 x 100/100	1050

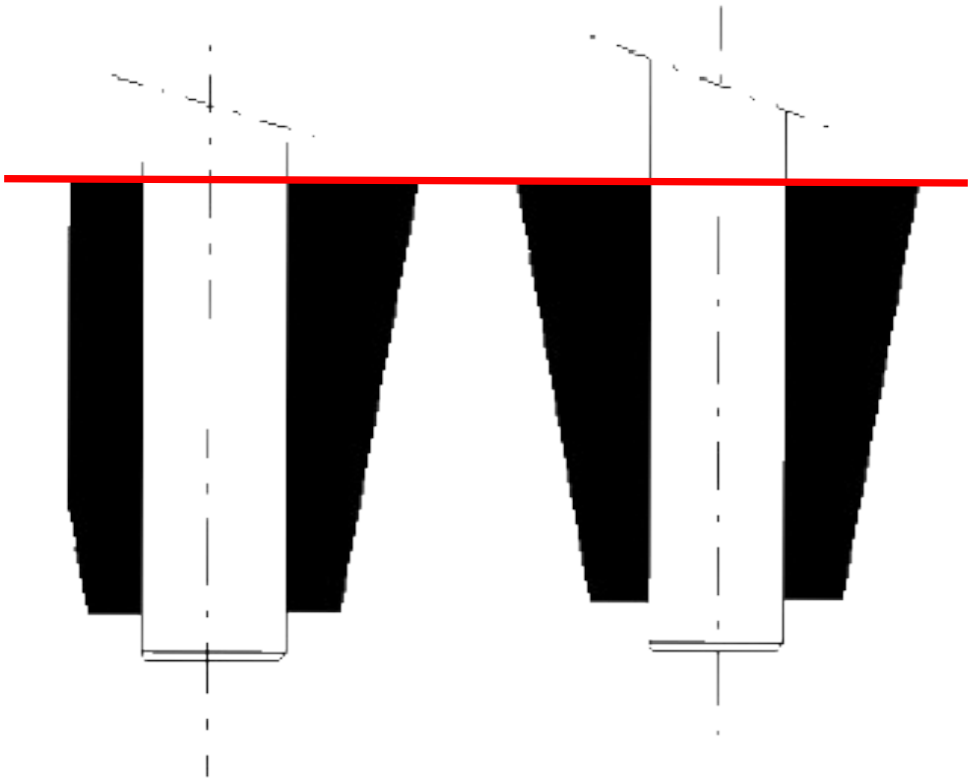
3. ALIGNMENT

Grooves of pulleys must show no evidence of shock and must be cleaned before belts are fitted.

Axis of pulleys must be parallel and pulleys rims aligned. Before tightening connected equipments fixations, check alignment and adjust if necessary according to one the procedures below :

3.1. ALIGNMENT OF BUSHES

The Magic-Grip-T® pulleys offer the unique features of a rim aligned with the face on the big diameter of the taper bush that also offers a self-clasping effect onto the shaft through its elasticity It is then possible to achieve a drive alignment in simply aligning the faces of bushes on their large diameter side, if these are on the same side of the drive, as shown below :



Dessin 1: Alignment of bushes

- Apply a ruler on the faces of the taper bushes on their big diameter side. Check that they are in contact all along the surfaces. Adjust accordingly if necessary until contact is complete.
- Fit the pulleys onto their bushes as described in § 2 - Assembly page 1. Drive will then be alignment through the unique features of the Magic-Grip-T® pulleys.

3.2. ALIGNMENT OF RIMS

Pull tight a rope or use a ruler and place it on the faces of pulleys rims to be aligned. Check that contact is thorough onto the rim faces as shown below :

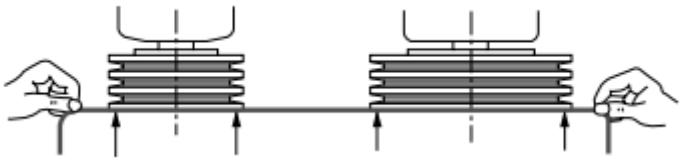


Figure 5: Alignment of rims

Adjust if necessary till contact between rope/ruler and pulleys rims is complete.

4. EARTHING

The pulleys or their supporting shafts must be grounded.

5. DISASSEMBLY OF PULLEYS

Untighten and remove the fixing screws. Fit them in the removal tapped holes and tighten alternately until the pulley is released.

- **The Magic-Grip-T® bushes have a self-clasping effect onto the shaft they are fitted on. Therefore, if shafts are not moved, it is possible to re-assemble pulleys without checking drive assembly.**

6. MATERIALS USED

- Material for pulleys : Grey Lamellar Cast-Iron EN-GJL-200 as per EN 1561.
- Material for bushes : Grey Lamellar Cast-Iron EN-GJL-250 as per EN 1561.

ATTENTION ! : PTP INDUSTRY cannot assume liability or provide guarantee coverage in the event of spare part used are not original PTP INDUSTRY parts.