

GIB KEY REMOVAL AND INSTALLATION

FIG. 50: Gib keys (1) are tapered keys with a tang on the thick end. A gib key is both a locking component and hub retainer. The hub must have a tapered key way that fits the gib key. The gib key will lock the hub in position. No other locking component such as a set screw is needed.

Remove paint from the shaft on both sides of the hub.

Use a pry bar (2) to apply pressure between the gib key and the hub. While holding pressure on the gib key, drive the hub away from the gib key by hitting the hub with a hammer.

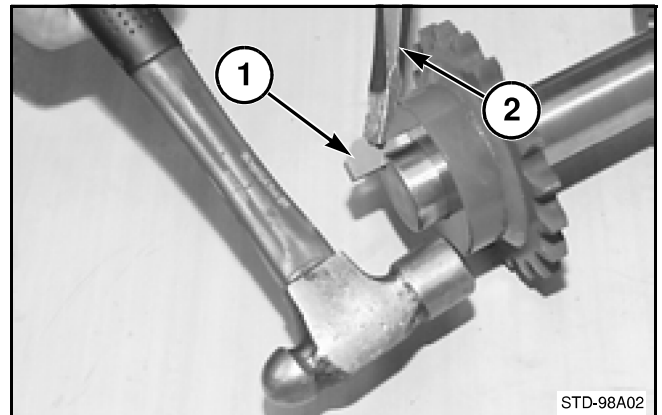


FIG. 50

FIG. 51: Make a special tool to remove gib keys from locations with little access. Use a 25 mm (1 inch) wide chisel and grind the width of the chisel to 16 mm (5/8 inch) (1). Grind a slot (2) in each side of the head of the chisel. The slot is used to keep the chisel from slipping.

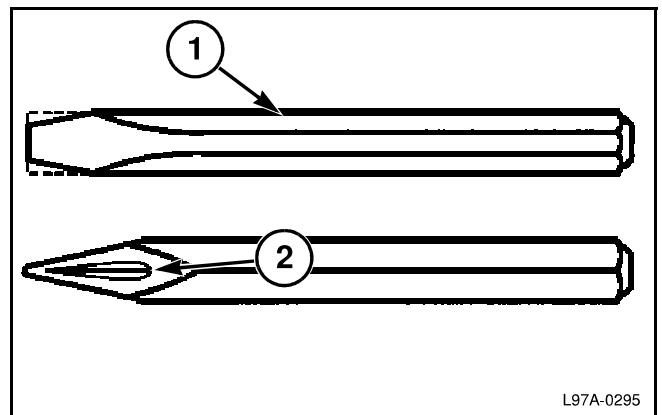


FIG. 51

FIG. 52: Insert the chisel between the gib key head and the hub. Drive against the chisel with a hammer. Use the narrow side of the chisel for smaller gib keys and the wide side of the chisel for large gib keys.

After the hub and gib key loosens, remove the gib key with the pry bar.

Remove the hub.

Put a thin layer of anti-seize compound or grease on the shaft to prevent sticking or the formation of rust between the hub and shaft.

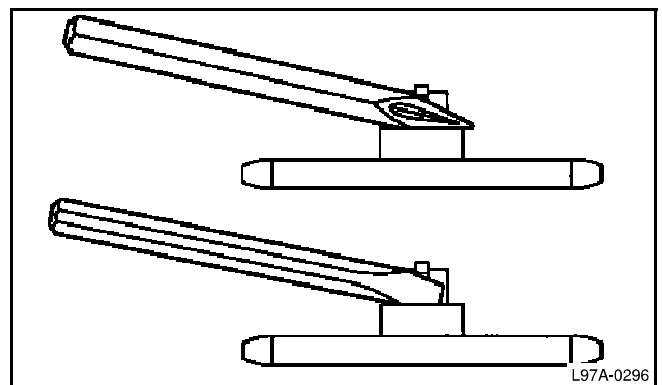


FIG. 52

FIG. 53: Install the hub. Make sure the taper in the hub is in the same direction as the gib key taper. Align the key way in the hub with the key way on the shaft. Install the gib key.

Hold the sheave or sprocket in position on the shaft. Hit the gib key with a hammer until the gib key is seated.

NOTE: The gib key does not have to be driven extremely hard into the hub to seat.



FIG. 53

General Information


TORQUE CHARTS

Standard Torque Specifications


Foot Pounds (lbf ft) Newton Meters (Nm)

Use this chart as a guide when tightening bolts and nuts that do not have special torque specifications.


SIZE	SUGGESTED ASSEMBLY TORQUE VALUES (STANDARD HARDWARE)											
	SAE GRADE 2 ASSEMBLY TORQUE				SAE GRADE 5 ASSEMBLY TORQUE				SAE GRADE 8 ASSEMBLY TORQUE			
	DRY		LUBE		DRY		LUBE		DRY		LUBE	
	Ft.-Lb.	N.m	Ft.-Lb.	N.m	Ft.-Lb.	N.m	Ft.-Lb.	N.m	Ft.-Lb.	N.m	Ft.-Lb.	N.m
5/16"-18	11	15	8	11	17	23	13	18	25	34	18	24
5/16"-24	12	16	9	12	19	26	14	19	25	34	20	27
3/8"-16	20	27	15	20	30	41	23	31	45	61	35	47
3/8"-24	23	31	17	23	35	47	25	34	50	68	35	47
7/16"-14	30	41	24	33	50	68	35	47	70	95	55	75
7/16"-20	35	47	25	34	55	75	40	54	80	108	60	81
1/2"-13	50	68	35	47	75	102	55	75	110	140	80	108
1/2"-20	55	75	40	54	90	122	65	88	120	163	90	122
9/16"-12	65	88	50	68	110	149	80	108	150	203	110	149
9/16"-18	75	102	55	75	120	163	90	122	170	230	130	176
5/8"-11	90	122	70	95	150	203	110	149	220	298	170	230
5/8"-18	100	136	80	108	180	244	130	176	240	325	180	244
3/4"-10	160	217	120	163	260	353	200	271	380	515	280	380
3/4"-16	180	244	140	190	300	407	220	298	420	569	320	434
7/8"-9	140	190	110	149	400	542	300	407	600	813	460	624
7/8"-14	155	210	120	163	440	597	320	434	660	895	500	678
1"-8	220	298	160	217	580	786	440	597	900	1220	680	922
1"-12	240	325	170	230	640	868	480	651	1000	1356	740	1003
1-1/8"-7	300	407	220	298	800	1085	600	813	1280	1735	960	1302
1-1/8"-12	340	461	260	353	880	1193	660	895	1440	1952	1080	1464
1-1/4"-7	420	569	320	434	1120	1519	840	1139	1820	2468	1360	1844
1-1/4"-12	460	624	360	488	1240	1681	920	1247	2000	2712	1500	2034
1-3/8"-6	560	759	420	569	1460	1979	1100	1491	2380	3227	1780	2413
1-3/8"-12	640	868	460	624	1680	2278	1260	1708	2720	3688	2040	2766
1-1/2"-6	740	1003	560	759	1940	2630	1460	1979	3160	4284	2360	3200
1-1/2"-12	840	1139	620	841	2200	2988	1640	2224	3560	4827	2660	3606



GRADE 2
NO MARKS



GRADE 5
3 MARKS



GRADES 8
6 MARKS

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FIG. 54

FIG. 54: Standard Torque Chart.

NOTE: Mild steel torque values (SAE Grade 2) are also to be used when weld nuts, or other low strength nuts are used.