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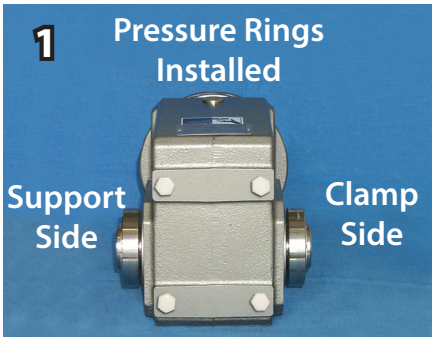
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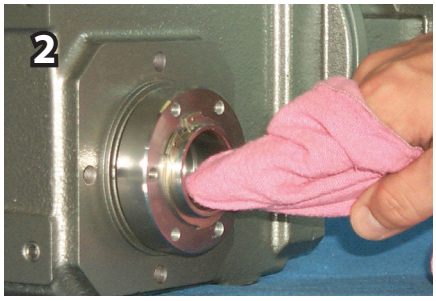
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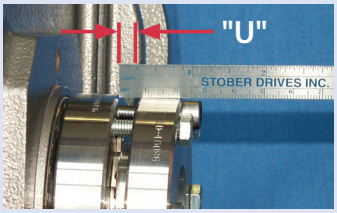
MGS®/ServoFit® Double Bushing Output Installation (F, K, KL, KSS)





Be sure the inside of the bore is free of grease and oil before installing the tapered cones.

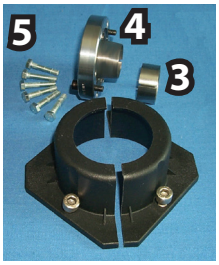
Important:



The "U" distance (between the rings) determined by the spacer bolts (see Table 1) must be maintained throughout assembly of the bushing and mounting onto the shaft. Therefore DO NOT tighten the capscrews or remove the spacer bolts until the unit is mounted on the shaft.

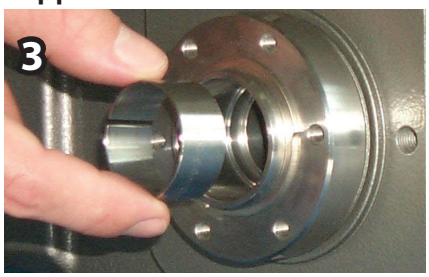


Support Side Bushing Components

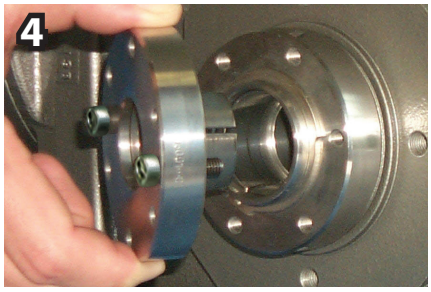


Support side is the bushing with the dark coating on the cone. Do NOT use cleaner on the coated cone.

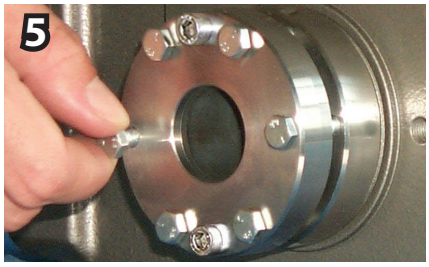
Support Side Installation



Insert tapered cone, which may have single split or double slot. If you have the split cone insert so the thinnest portion is facing outward. If you have the double slot, insert so slots are facing outward. Insure the cone is seated against the internal quill shoulder. (Note: K1/KSS1 do not have a tapered cone.)



If you have single split taper and flange cone assembly, align slots so they are 180° opposite each other. If you have double slot taper and flange cone or mixture of single and double slots, align the parts so the slots/slits are offset 90°

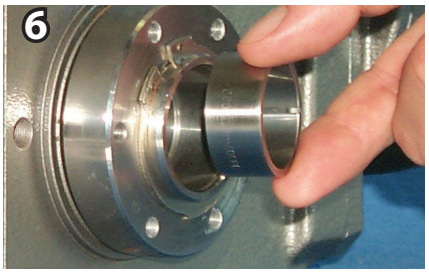


Hand tighten capscrews

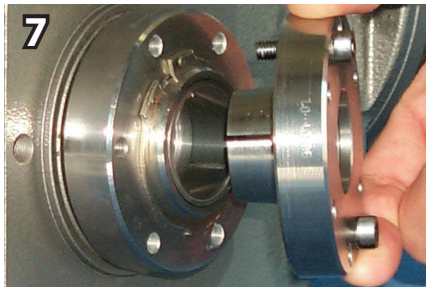
Clamp Side Bushing Components



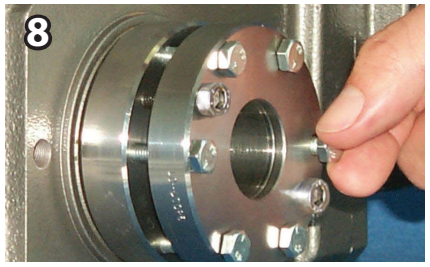
Clamp Side Installation



Insert tapered cone, which may have single split or double slot. If you have the split cone insert so the thinnest portion is facing outward. If you have the double slot, insert so slots are facing outward. Insure the cone is seated against the internal quill shoulder. (Note: K1/KSS1 do not have a tapered cone.)



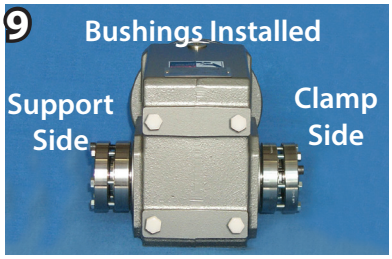
If you have single split taper and flange cone assembly, align slots so they are 180° opposite each other. If you have double slot taper and flange cone or mixture of single and double slots, align the parts so the slots/slits are offset 90°



Hand tighten capscrews

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Mounting onto Shaft

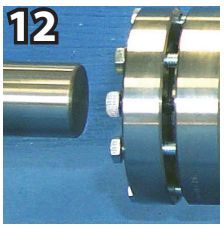




1/32 x 45° chamfer on shaft end



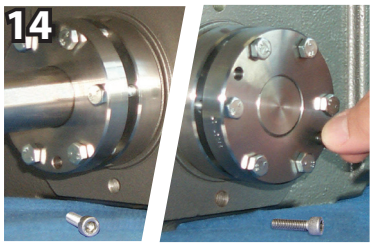
Clean the shaft



Guide support side bushing onto the shaft



Shaft does not protrude on clamp side



Remove the spacer bolts



Tighten clamp side first – use more than one rotating sequence – hand tighten one to two revolutions before using wrench



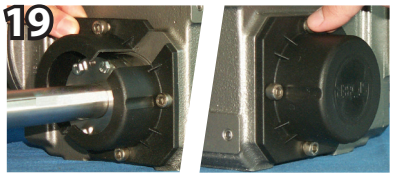
Use a torque wrench (See Table 1) for recommended torque



Tighten support side capscrews – use more than one rotating sequence



Use a torque wrench (See Table 1) for recommended torque



Install split and closed covers

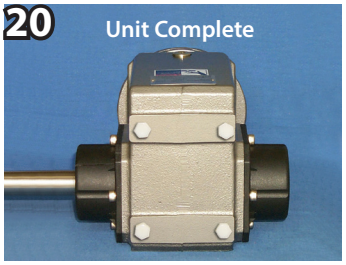


Table 1 Recommended Tightening Torque

Base Module	Capscrews Qty – Size x L (mm)	Tightening Torque Nm	Tightening Torque in. lbs	U mm	U in	Spacer Bolts (mm)
F1	6 – M6×1×25	10	89	5	0.20	M6×1×20
F2	8 – M6×1×30	10	89	5	0.20	M6×1×20
F3	8 – M6×1×30	10	89	6	0.24	M6×1×20
F4	8 – M8×1.25×30	25	221	6	0.24	M8×1.25×20
F6	8 – M10×1.5×35	49	434	6	0.24	M10×1.5×25
KL2	6 – M5×0.8×25	6	53	4	0.15	M5×0.8×20
K1	6 – M6×1×25	10	89	5	0.20	M6×1×20
K2	6 – M6×1×30	10	89	5	0.20	M6×1×20
K3	8 – M6×1×30	10	89	5	0.20	M6×1×20
K4	8 – M8×1.25×30	25	221	6	0.24	M8×1.25×20
K5	8 – M8×1.25×30	25	221	7	0.28	M8×1.25×25
K6	8 – M10×1.5×35	49	434	8.5	0.33	M10×1.5×25
K7	8 – M10×1.5×40	49	434	5.5	0.22	M10×1.5×25
K8	8 – M12×1.75×40	85	752	7	0.28	M12×1.75×45
KSS1	6 – M6×1×25	10	89	5	0.20	M6×1×20
KSS2	8 – M6×1×25	10	89	5	0.20	M6×1×20
KSS3	8 – M6×1×25	10	89	5	0.20	M6×1×20
KSS4	8 – M8×1.25×30	25	221	6	0.24	M8×1.25×20

Using a torque wrench, tighten all capscrews to the torque shown in Table 1. The tightening should be done gradually in a rotating sequence and will require more than one rotation.

After two hours (minimum) running time, check capscrews and retighten, if necessary.

Table 2 Recommended Shaft Length (Inches)

Base Module	Double Bushing Without Cover	Double Bushing With Cover
F1	7.04	–
F2	8.18	–
F3	8.89	–
F4	10.03	–
F6	11.30	–
K1	7.73	7.97
K2	8.99	9.23
K3	9.50	9.76
K4	11.11	11.42
K5	11.61	11.89
K6	12.75	12.99
K7	14.33	14.83
K8	17.29	17.60
KL2	6.81	7.03
KSS1	7.85	7.49
KSS2	9.28	9.00
KSS3	9.75	9.47
KSS4	11.38	11.04

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