

# TRU TUF SLB BUSHINGS

## INSTALLATION INSTRUCTIONS PRESS-FIT AND NUT & BOLT

**TRU TUF SLB BUSHINGS** are normally designed to be held in a housing with a press (interference) fit. This press-fit alone is usually sufficient to hold the bushing during use. The **TRU TUF SLB** materials have a coefficient of thermal expansion about half that of carbon steel and the bushing must be designed with enough press fit to maintain an interference fit at the operating temperature.

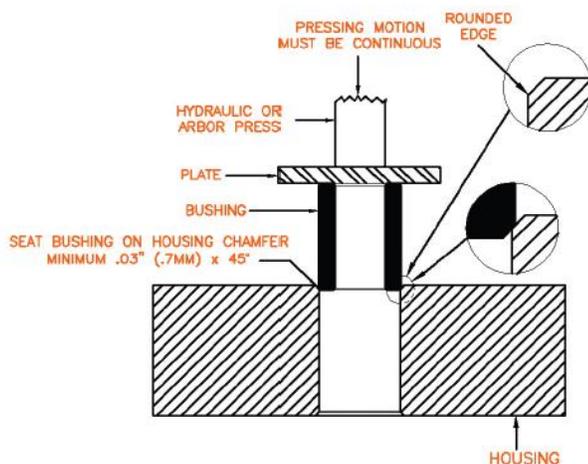
Interference fit depends on:

- Maximum operating temperature expected
- Materials of the shaft and housing and
- Size of the Bushing

Fits up to 0.5% of the OD size (.010 to .025") are not unusual and can be installed without difficulty.

### PRESS INSTALL

- Press by means of Arbor or Hydraulic press
- Housing ID chamfer of .03-.06" x 45 Deg to match chamfer of the bushing
- A flat plate may be used as shown with the plate completely covering surface of bushing
- Pressing motion must be uninterrupted until bushing is completely in place, stopping may crack the bushing, see Diagram Below:



### NUT & BOLT INSTALL

- Where Press is not available
- Plate or Heavy Washer on either side
- Nut must be continuously tightened
- Preferable to use a pneumatic wrench
- Method not recommended for bushings above 3" OD
- See Diagram Below:

