

1-1/2 & 2 HP Bushing Repair Kit Instructions With Gage Pins

Watch on YouTube: <https://youtu.be/2qyzkYunVCg>



- 1) Run the speed dial to the lowest speed range and shut off the motor. This puts the vari-speed belt in the best position for disassembly
- 2) Disconnect the power and remove the switch from the side of the belt housing
- 3) Remove the motor pulley cover
- 4) Use two of the cover screws to fasten the spring collar to the lower motor vari-drive pulley. This will reduce the hazard of personal injury is always present when a heavy spring is under compression
- 5) When the pulley and spring collar are securely fastened and a single unit, crank the speed dial to the high speed position
- 6) Remove the screws that fasten the motor to the belt housing
- 7) The motor should be lifted slightly and pulled firmly away from the spindle and toward the rear of the belt housing. This will put the vari-drive belt deeply into the spindle pulley, providing the slack needed to slip the belt over the motor pulley
- 8) Lift the motor high enough to rest the motor base gently on the adjusting screw seat directly in front of the motor flange. The belt can now be slipped over the lower pulley and the motor removed from the housing
- 9) Remove the snap ring from the bottom of the motor shaft & slide the vari-disc assembly off the shaft. NOTE: If the motor vari-disc bushings are blue or teal in color, you will have to replace the entire motor vari-disc assembly.
- 10) Remove the top spindle cap by removing the three socket head cap screws and installing them in the three threaded holes, using them as jack screws
- 11) Looking down inside of the unit you will see two socket head cap screws and two pivot sleeves. Remove the screws and the sleeves
- 12) Remove the snap ring from the shaft
- 13) Remove the two lower socket head cap screws in the speed changer bracket
- 14) Remove the five socket head cap screws (4 on top and 1 on the bottom in back) holding the belt housing to its sub-housing
- 15) The belt housing is now being held in place by two dowel pins. You may be required to pry the housing apart to completely remove the belt housing
- 16) Slide the front pulley off the shaft
- 17) Using an arbor press, compress the spring on the motor vari-disc assembly and remove the two screws. Slowly release the pressure on the spring
- 18) Remove the old bushings and keys from the vari-discs
- 19) The old epoxy must be removed from the walls and grooves of the vari-discs
- 20) Use the sandpaper to scuff up the bore and OD of the bushings
- 21) Before installing the epoxy, install the bushings and test on the arbors for proper fit
- 22) Mix the epoxy and apply to the ID of the pulleys
- 23) Install the bushings (make sure the keyways are left clear)
- 24) Coat the gage pins and clean out any excess epoxy
- 25) Install the gage pins into the ID of the vari-discs with the bushings installed and allow to set overnight
- 26) Remove the gage pins and clean out any excess epoxy
- 27) Install the keys into the vari-discs
- 28) Reassemble the head by following the instructions in reverse
- 29) If you need additional assistance please contact us a 800-285-5271

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