



Installation Instructions for Dailey Engineering Taper Grip Pulleys

NOTE: There are multiple sizes of taper grip hubs. Some use 10-24 socket head cap screws and others use 1/4-20 socket head cap screws. For the purpose of this document we use the 10-24 as the example. The torque values should be adjusted for the 1/4-20 screws as follows:

10-24 55 in.-lbs.

1/4-20 90 in.-lbs.

- 1) Remove the three (3) 10-24 socket head cap screws and clean thoroughly.**
- 2) Remove taper hub and clean the taper in both the pulley and the hub, apply anti seize (copper-slip or similar) to taper.**
- 3) Clean the ID bore of the taper hub.**
- 4) Apply blue Loctite (#243), or similar to the three (3) 10-24 socket head cap Screws.**
- 5) Re-assemble pulley loosely.**
- 6) Install pulley on oil pump shaft (shaft should be free of any burrs, scratches, oil or grease) and position.**
- 7) Tighten the (3) 10-24 socket head cap screws in a circular pattern to a torque of 55 in.-lbs. Repeat the torquing procedure until screws do not move at 55 in.-lbs. (usually 3 times around).**
- 8) Do Not tighten the pulley with a belt attached or the pulley may not run true! Hold the pulley by hand while tightening to ensure things tighten correctly.**

Removal Instructions for Dailey Engineering Taper Grip Pulleys

- 1) Loosen the three (3) socket head cap screws.
- 2) Tap with a soft mallet, if pulley and hub do not separate, use one (1) 10-24 socket head cap screw and thread into one of the threaded holes in the taper hub. Tighten screw until it separates the hub from the pulley.
- 3) Pull the pulley assembly off of the shaft (with your hands, not a puller). Pulling on the pulley to remove it from the shaft can tighten the taper, making it difficult to remove the assembly from the shaft. With the pulley and hub separated, you can insert a small screwdriver into the slot on the hub, which will keep the hub from closing up during the pulling process, facilitating pulling the assembly off of the shaft.

