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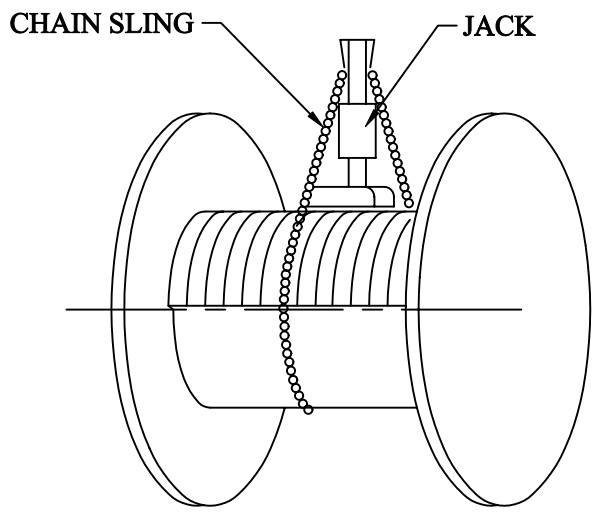
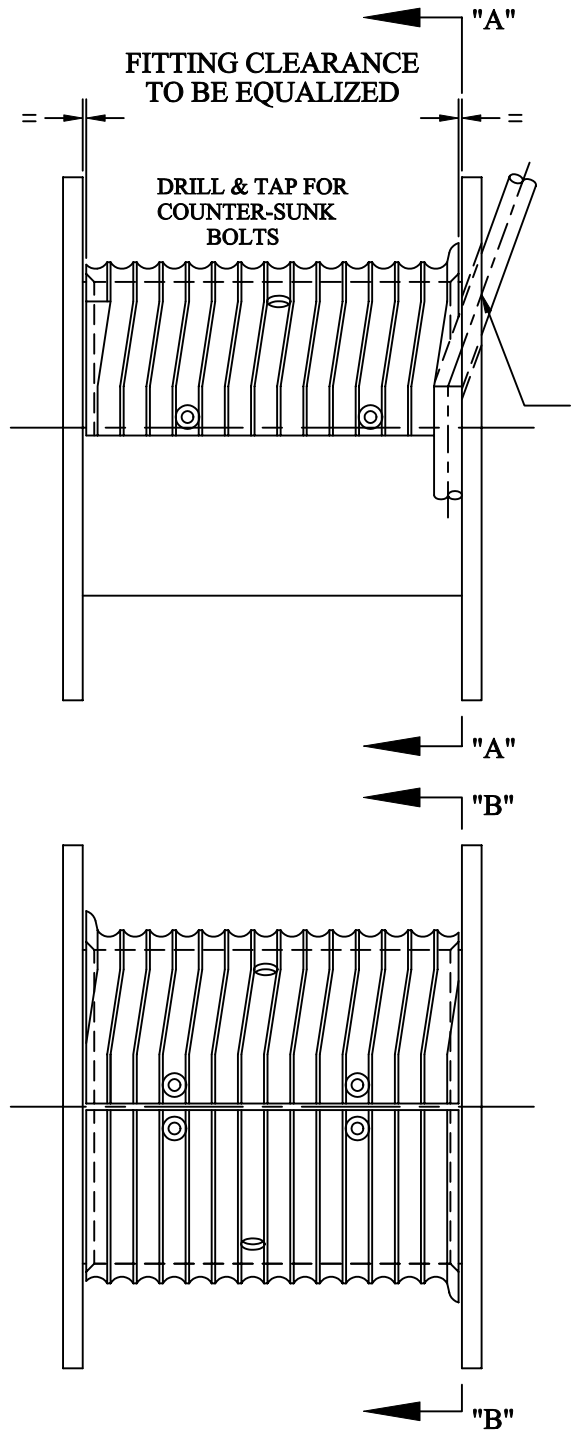
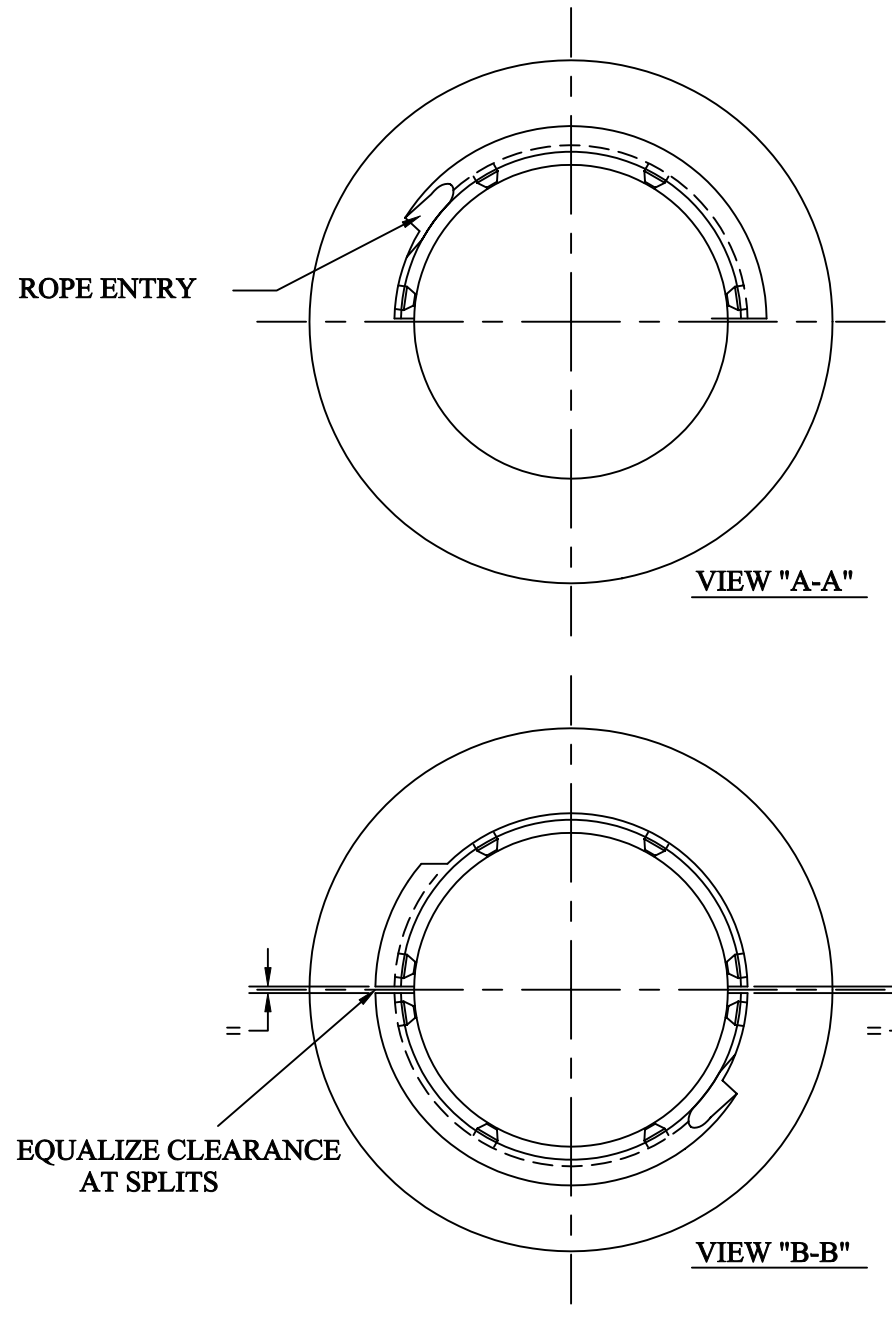
REVISIONS			
LTR	DESCRIPTION	BY	DATE



A METHOD OF JACKING SLEEVE DOWN ONTO DRUM





Installation Instructions

1. Measure the drum diameter and width carefully.
2. Measure the sleeve width. It should be approximately 1/32" to 1/16" smaller than the drum width for clearance reasons.
3. Using a flexible tape, measure the ID circumference of the sleeve halves. The two sleeve half ID circumference measurements plus 1/4" to 3/8" should be approximately equal to the drum circumference.
4. Using the provided tapped lifting holes, place the "entry" half of the sleeve in place. The rope entries on the sleeve and the drum must match correctly. A small sample of rope can be used to aid in this alignment.
5. Position the sleeve half around the drum to suit. Keep the clearance gaps at the drum flanges and split lines equal. This assures the sleeve is square to the drum.
6. Using chain(s) and jack(s) force the sleeve down tight against the drum barrel in the area to be bolted. (If sleeve is lockwashered, weld a dog to the sleeve. Then using a wedge, line-up the ends square with the drums flange.) Begin drilling & tapping the drum using the sleeve half as a template starting at the center and working towards the split in either direction moving the jack as you go. The tapped holes in the sleeve are for lifting eyes. Note, they are not to be used to lift the drum.
7. Position the second half such that the groove lands line up with each other. Once again, equalize the clearance gap at the drums ends. Also equalize the split line gap between the sleeve halves.
8. If the sleeve split lines bump up to each other before it is tight against the drum then contact LeBus International for additional information. Do not trim the sleeve in any way before talking with LeBus.
9. Repeat steps 6 & 7 for the second half.

For any questions, please call LeBus at 903-758-5521

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES. TOLERANCES		CONTR	LEBUS INTERNATIONAL, INC. LONGVIEW, TEXAS
CASTINGS	±1/8"	DATE March 14, 2001	Installation Instructions for a Bolt-On Split Sleeve without Wear Plates
FABRICATING	±1/8"	DRAWN DAG	
MACHINING		APPROVAL	
FRACTIONS		N.A.	SIZE B / CODE IDENT 17798 / DWG NO. P3287-402B
.XX	±.008"		SCALE None / WEIGHT / SHEET
.XXX	±.004"		