

Work Instruction	HUDSON PRODUCTS CORPORATION <i>Fan Engineering Standards</i> Title: Shear Pin Installation For 5000 Series Hub Plates	Work Instruction
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SCOPE: Four shear pins will be installed on all 5000 series hubs to increase the torsional strength of the connection between the plate and hub spool. Two pins will be installed at 180° to each other on top and bottom plates. The four 0.5 D. x 1.5 LG. “DRIV-LOK” grooved pins will be installed **after** hub is assembled.

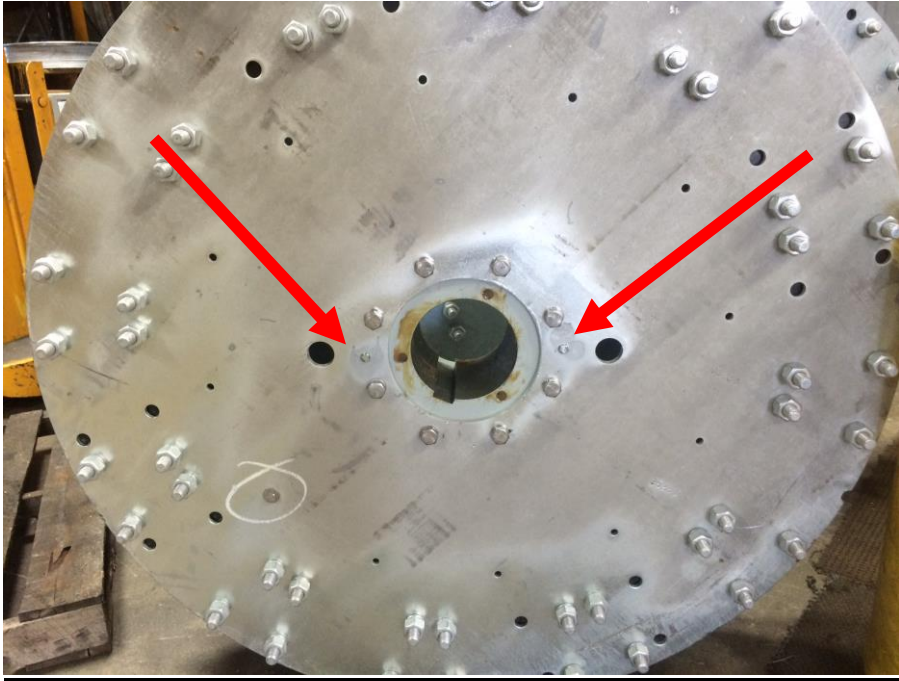
- 1. Material: 0.5 dia. x 1.5” long, AISI 8650, steel pin
Description: type A grooved pin, alloy material, zinc plated.
- 2. Installation:

- 2.1 Prior to disassembly, **mark the position of the spool keyway on the top and bottom hub plate.** This will allow for reassembly in the same relative position keeping the integrity of the hub balance.
- 2.2 Remove all blade clamp sets and hardware. Save for reinstallation.
- 2.3 Remove 8 each 5/8” stainless steel bolts from both top and bottom (total of 16) side of the center spool. Save for reinstallation.
- 2.4 Remove center spool and machine bore as required. Do not disturb balance weights on hub plate.
- 2.5 **After machining, reinstall center spool lining up keyway with marks on top and bottom plate.** Torque spool mounting hardware to 60-65 ft.lbs (lubricated)
- 2.6 Drill two holes, 0.50 D. drill on each side of hub **after** assembly. (thru plate into spool, 1 ½” deep hole) See picture for location. Locate pin holes on same 7.75” bolt circle as spool mounting holes at 180° apart. Maintain consistent alignment of pin position from top plate to bottom plate.
- 2.7 Install four pins, leaving approximately 1/8” of pin exposed above plate. Widest point of tapered groove will be at top of pin.
- 2.8 Reinstall blade clamp sets.

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DATE	25AUG15						
INITIALS	NJR						

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2.9 Coat top of pin and surrounding area with cold galvanize corrosion resistant material, example below:



Install 2 pins on top and 2 pins on bottom of hub as shown in above example

REV.	DESCRIPTION	DATE	APPROVED
0	Initial release	25AUG15	N. Rizzo

REVISION	0						
DATE	25AUG15						
INITIALS	NJR						