

Z8 FITTING AND REMOVAL OF Z-LOCK LOCKING ASSEMBLIES

Fitting:

1. Fit at least 3 screws, evenly spaced around the circumference, into the threaded jacking holes, until resting against the face of the outer hub. This separates the hub and flange, and also stops tilting during assembly.
2. Tighten locking screws carefully until the locking assembly is located in the correct place without any looseness. Remove the lifting screws and tighten with the remaining screws.
3. Tighten all screws evenly to the given torque M_a , crosswise covering the circumference several times. (Tighten the screws on both sides of the slot one after the other). When no screw can be tightened any further with the torque wrench set to the tightening torque M_a , the fitting process is complete.

Removal:

1. Loosen all locking screws several turns and insert one screw into each of the flange's threaded jacking holes. Tighten the screws crosswise to loosen the connection. Tighten the screws both sides of the slot one after the other.

Tightening Torques for screws Gr. 12.9 DIN 912

Screw	M6	M8	M10	M12	M14	M16	M18	M20	M22
Torque Ma (Nm)	17	41	83	145	230	355	485	690	930