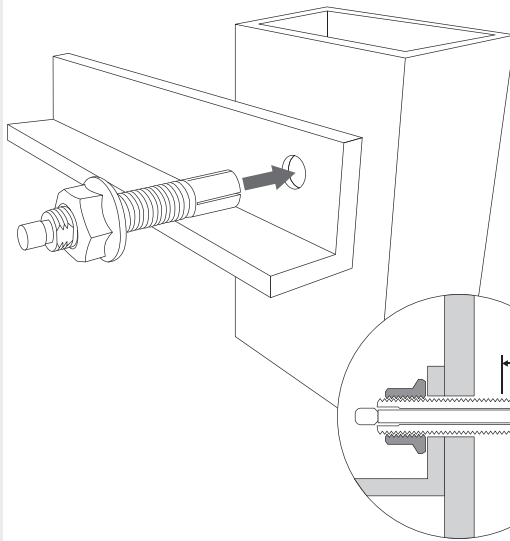


Installation Instructions

Step 1

Using the table opposite drill an appropriate fixing hole in both components to be connected, also note clamping range and depth clearance required.



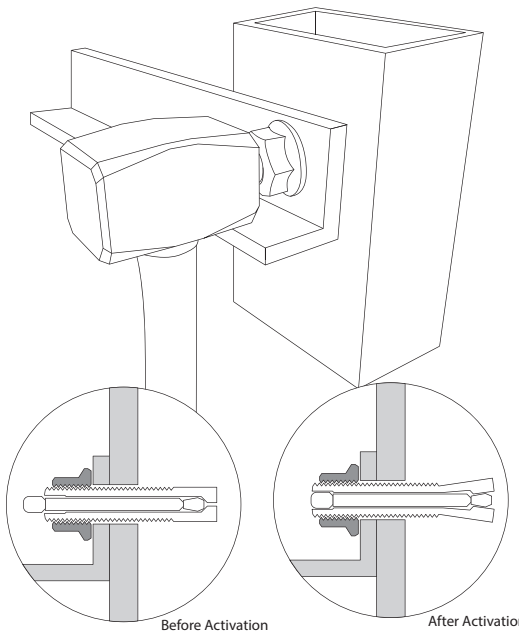
Product Code	Bolt Size	Hole Diameter	Clamping Range		Depth Clearance
			Min	Max	
HD0845ZF	M8 x 45	8	7	25	10
HD1045ZF	M10 x 45	10	7	25	12
HD1060ZF	M10 x 60	10	7	40	12
HD1245ZF	M12 x 45	12	8	22	15
HD1260ZF	M12 x 60	12	8	34	15
HD1275ZF	M12 x 75	12	8	48	15
HD1660ZF	M16 x 60	16	12	30	25
HD1675ZF	M16 x 75	16	12	45	25
HD2070ZF	M20 x 70	20	15	32	30
HD2085ZF	M20 x 85	20	15	47	30

(All values in mm unless stated otherwise)

NOTE: Ensure to insert the HD Bolt into the fixing hole to a sufficient depth to allow the bolt legs to activate fully.

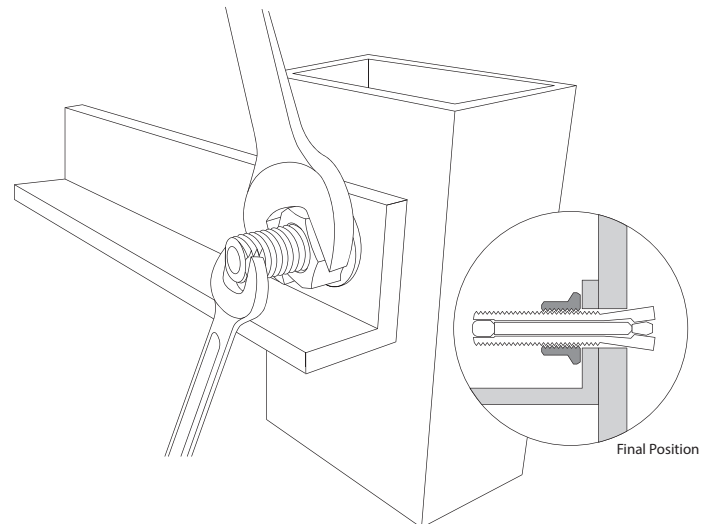
Step 2

Using a suitably weighted hammer strike the activation pin at the head of the bolt until flush with the bolt head. This will force apart the anchoring legs at the base of the bolt into their locked position.



Step 3

Finally, brace the HD Bolt using a suitable spanner attached to the machined flats at the head of the bolt and tighten the supplied nut to the recommended pre-load torque found below. Full technical information for the HD bolt can be found on our website.



Bolt Size	Recommended Pre-load Tightening Torque (Nm)	
	Zinc Flake 1000hr SSP	A4-70 Stainless Steel
M8	20	18
M10	35	24
M12	45	30
M16	95	45
M20	120	80