

DOUBLE SPLIT CLAMPCOLLAR ASSEMBLY INSTRUCTIONS

The protruding hub of the DOUBLE SPLIT CLAMPCOLLAR is the side with the best bore to face squareness and is designed to be placed against the retained component. The use of an anaerobic compound on the socket head cap screws is dependent on the customer's requirements and is applied just before assembly. Remove the (2) cap screws to separate the CLAMPCOLLAR halves and re-assemble the halves (with the hubs are on the same side) over the shaft. Position the CLAMPCOLLAR against the components or in the required alignment keeping the hubs in line with each other, and then lightly tighten the cap screws to bring the halves together, keeping the gaps between the two slits uniform to each other. The cap screws can then be alternately tightened to the recommended torque while maintaining the slit gap uniformity. Do not over-torque the cap screws as the CLAMPCOLLAR may close up completely with a possible loss of holding power.

Whittet-Higgins Company Recommended Cap Screw Torques

Metric Screw Size	Style	Torque (Inch-Pounds)	Torque (Newton-metre)
M3	Low Head	17	1.9
M4	Low Head	24	2.7
M5	Low Head	50	5.6
M6	Low Head	90	10.1
M8	Full Head	260	29.4
M10	Full Head	500	56.5

Unified National Screw Size	Torque (Inch-Pounds)
4-40	14
6-32	25
10-32	60
1/4-28	150
5/16-24	260
3/8-24	500

Reduce Stainless Steel Cap Screw torque by 30%