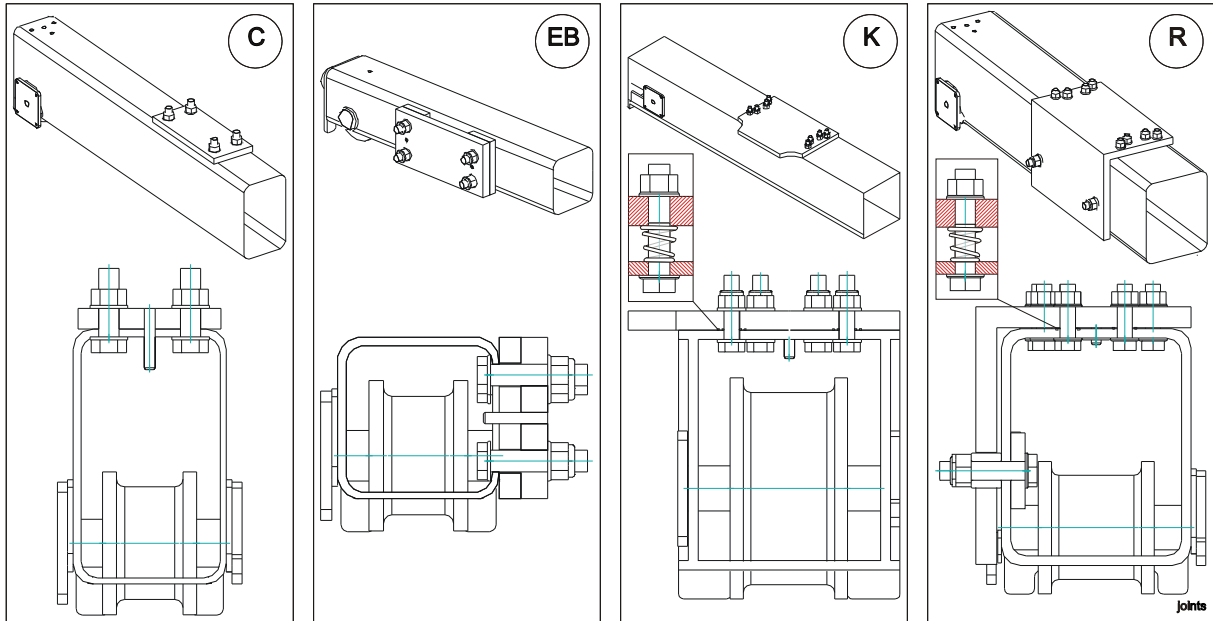


## 10 Joint plate assembly

### 10.1 Joint plate assembly, top running end carriages



Pos.	Connection	Friction rings
EB	Side connection	No
C, C-Gantry	Top connection	No
P, L, K	Top connection	Yes
R, S	Top connection / Side connection	Top yes, side no

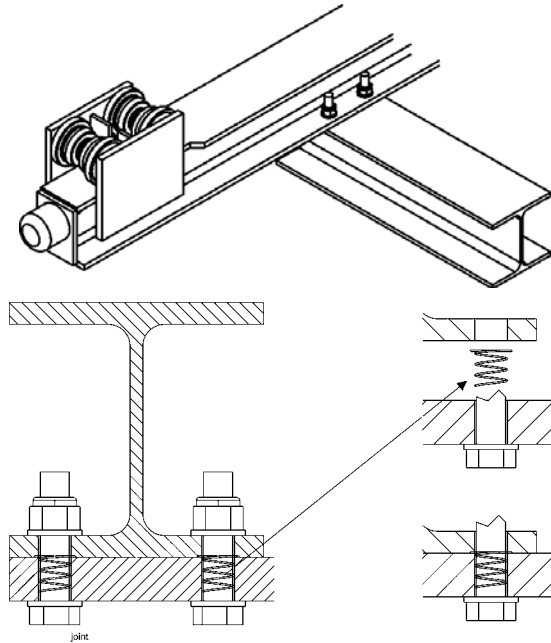
Tightening torque	
Screw size	Tightening torque
M16-10.9	280 Nm
M20-8.8	385 Nm
M20-10.9	550 Nm

- Check that joint surfaces are free from dirt, dust and loose particles. Only shop primer paint is allowed.
- Place friction rings around screw holes at top of end carriage.
- Reset spring pins into the holes at joint plates so that pin head penetrates the plate about 10-20 mm below bottom surface.
- Place joint plate above the end carriage. Make sure, that spring pins contact with corresponding holes at the end carriage top plate. Drive pins trough both plates with a hammer and proper tool. Make sure, that friction rings are kept in position during assembly.
- Assemble screws and nuts.
- Assemble joint plate into final position and tighten screws with correct torque.
- Retighten screws after test runs at assembly site.



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## 10.2 Joint plate assembly, underrunning end carriages



Pos.	Connection	Friction rings
BA, BB, SA, SB	Bottom connection	Yes

Tightening torque	
Screw size	Tightening torque
M16-10.9	280 Nm
M20-10.9	550 Nm

- Check that joint surfaces are free from dirt, dust and loose particles.
- Place friction rings around screw holes at bottom of end carriage.
- Place joint plate bottom of the end carriage. Make sure, that friction rings are kept in position during assembly.
- Assemble screws and nuts.
- Assemble joint plate into final position and tighten screws with correct torque.
- Retighten screws after test runs at assembly site.