



F-Type Nuts

Operating Instructions

F-Type Nuts are pressurized through a high-pressure F-Nipple located on the end face (axial surface) or on the OD (radial surface) of the nut by either a hand or motorized pump.

A. To Install Nuts and Apply Pressure

- Clean the threads and contact faces of the F-Type Nuts, arbors and mating tooling, and also ensure all tooling is packed solidly together on the arbor.
- Assemble the F-Type Nuts on the arbors and snug them by hand against mating tooling, then back off 10 to 20 degrees to ensure only the thrust ring will clamp the tooling and provide easy release later.
- The thrust ring must be flush with the face of the Amtec Nut; if not see Section B.
- Close the release screw using the provided 6 mm hex wrench (hand tight only - no power tools).
- Wipe the face of the Amtec F-Nipple with a clean thumb to ensure contamination is not pumped into the nut.
- Apply Amtec handpump's F-Coupler firmly over the F-Nipple, close the black thumb screw (pressure release valve) on the Handpump and then pump the handle until the desired pressure is obtained on the pressure gauge. (See operating instructions for Amtec handpumps on page 66.)
- Open the black thumb screw on the handpump 1/4 turn; the reading on the pressure gauge will be reduced to zero instantly. Then with a slight rotating motion of the handpump, remove the F-Coupler from the F-Nipple.
- Observe the F-Nipple for a few seconds to ensure no leakage occurs (tighten or replace F-Nipple as required).
- The Amtec F-Type Nut is now fully pressurized with the thrust ring giving uniform axial pressure to the mating tooling.

B. To Release Pressure and Remove Nuts

- Open the release screw 1/4 turn with the provided 6 mm hex wrench.
- NOTE: Cover the bleed hole with a rag or paper towel to ensure all expelled grease is contained, then discard immediately to prevent contamination of equipment.
- Insert an Amtec Hand Assist Bar (see page 76) in the peripheral holes of the nut to first tighten the F-Type Nut against the adjacent tooling to compress the thrust ring flush with the face of the nut and ready for subsequent use. This procedure will also protect the thrust ring from damage.
- Remove the Amtec Nuts from the arbors and place on a wooden-topped bench to prevent damage to the nut faces.
- Tooling may now be removed.

C. Remarks

- DO NOT apply pressure to the F-Type Nuts when nuts are "off-line." The thrust ring has no retainer and can be forced out of the pressure chamber, causing distortion of the thrust ring and possible rupture of the seal.
- Use only genuine Amtec F-Nipples, Release Screws, Seals, Thrust Rings and Handpumps to guarantee clamping reliability.
- Use only Amtec approved grease (see page 77). DO NOT use hand filled grease tube systems. Air bubbles may be introduced into the nut, risking variable clamping forces, and also creating hazards when releasing pressure.
- Always change cartridges on a clean bench with clean hands. Dirt in the valves will cause malfunction of the handpump.
- For videos on F-nut installation and removal, please visit our website.

D. Service

- For service and spare parts contact your local agent or call our office directly.