



K-Type Nuts

Operating Instructions

K-Type Nuts are pressurized by tightening one or more actuator screws located on the end face or on the radial surface of the nut, by a hand held hex wrench.

A. To Install Nuts and Apply Pressure

1. Clean the threads and contact faces of the K-Type Nuts, arbors and mating tooling.
2. Pack all tooling solidly together on the arbour before installing the K-Type Nuts.
3. With K-Series Nuts, the actuator screws must be unscrewed until flush with the limit screws, which prevents retraction past flush.
4. With older K-Series Nuts, the actuator screws must be unscrewed until they are flush with the axial face (K-7 Series) or contact the roll pin (K-6 Series).
5. If the thrust ring sits proud, tighten the K-Type Nut with an Amtec Assist Bar to retract by hand until the thrust ring contacts the mating tooling. Continue to tighten the K-Type Nut to retract the thrust ring until it is flush with the nut face.
6. Loosen the K-Type Nut 10 or 20 degrees to provide a slight clearance between the thrust ring and the contact face on the tooling. This step is extremely important to prevent the nut from binding upon removal.
7. Insert the hex wrench, as supplied with the nut, into the actuator screw and tighten by hand. Although "hand tight" is generally sufficient, refer to the "Clamping Force vs Actuator Torque" column in the K-6 or K-7 product page for torque specifications, if required.

B. To Release Pressure and Remove Nuts

1. Insert the hex wrench, as supplied with the nut, into the actuator screw and turn to the left until the actuator screws are flush with the limit screw, or as per A4 above, for older nuts.
2. Insert the assist bar (page 76) in the radial holes of the nut to tighten the K-Type Nut against the mating tooling to compress the thrust ring into the nut body. This protects the thrust ring from damage and prepares the nut for subsequent use.
3. Remove the K-Type Nut from the arbor and place on a wooden bench to prevent damage to the nut face.
4. Tooling may now be removed.

C. Remarks

1. DO NOT tighten the actuator screws when the 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 sealing system.
2. Use only genuine Amtec Hydraclamp repair parts to guarantee clamping reliability.
3. DO NOT remove the limit screws and unscrew the actuator screws beyond their reference faces, as described in Section A, above. Doing so may damage the seals of the actuator assembly.
4. Respect the designed thrust ring maximum stroke (S max) for the particular K-Type Nut being used. Excess travel can cause the seals to rupture, which may cause physical damage.

D. Service

1. For service and spare parts contact your local distributor or call Amtec Hydraclamp directly.