



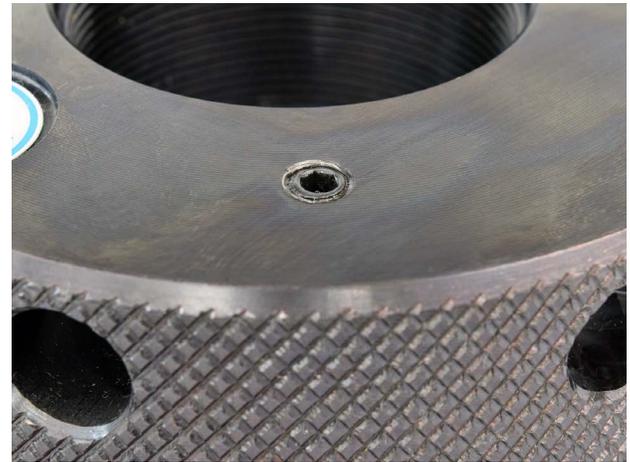
K-Type Nuts

Refill Instructions

The self-contained grease volume within the pressure chamber may gradually leak out and need to be replenished.

** Use only EP1 or EP2 (Calcium Sulphonate) Grease (see page 75 for more information on grease)*

1. Concentrated grease leakage around the thrust ring or the actuator screws would indicate seal failure. The respective sealing system should be replaced before refilling the pressure chamber with grease. See page 39 for spare part information.
2. Remove only one of the two M6 filling screws and the 4 mm ball under the screw (part no. 719.001.006.001), using a 3 mm hex wrench.
3. Support the thrust ring flush with the nut face using a steel plate with a diameter larger than the diameter of the K-Type Nut and clamp in a press. C-clamps or a central bolt and nut arrangement will also work.
4. Insert the hex wrench, as supplied with the nut, into the actuator screw and tighten until the piston bottoms out. This action will expel some grease and possibly air bubbles from the pressure chamber.
5. All actuator screws should be discharged in the same manner as described in number 4 above.
6. Screw a filler nipple with M6 thread (part no. 710.101.006.010) into the open filling screw hole and hand tighten with a wrench.
7. Remove the second M6 filling screw and the 4mm ball underneath.



8. Apply a handpump to the nipple and then pump grease through the nut until the grease exiting the open filling screw hole is clean and free from air bubbles. Remove the handpump.
9. Replace the 4 mm ball and the M6 filling screw into the open filling screw hole and tighten the screw with the 3 mm hex wrench.
10. Apply a handpump to the filler nipple again and pump grease into the nut to just indicate a slight pressure. While maintaining slight pressure, gradually return one actuator screw to a flush position against the limit screw on the counter-bore for K-6 Type Nuts or with the end face of the nut on K-7 Type Nuts.
11. Additional actuator screws should be returned to the flush position, under slight pressure, as described above.
12. Remove the handpump from the filler nipple, unscrew the filler nipple and replace the 4 mm ball and M6 filling screw. Hand tighten with the 3 mm hex wrench.
13. Refill is complete. Test the Amtec K-Type Nut under working conditions.
14. Contact your local Amtec Distributor, or Amtec Hydraclamp directly, for repair service or genuine Amtec Hydraclamp repair parts.