

CLAMPNUT ASSEMBLY INSTRUCTIONS FOR PRECISE INSTALLATIONS

The protruding hub of the CLAMPNUT is the side with the best thread to face squareness and is designed to be placed against the bearing or other component. The use of an anaerobic compound on the socket head cap screw is dependent on the customer's requirements and is applied just before assembly. With the cap screw loose, assemble the CLAMPNUT onto the shaft threads until the CLAMPNUT threads are fully engaged. Then hand tighten the cap screw while rotating the CLAMPNUT back and forth until a light drag is felt. This is essential to eliminate the pitch diameter differential between the threads. Failure to snug the cap screw could result in the opening of the CLAMPNUT threads during preloading and subsequent loss of holding power. It also pulls the CLAMPNUT central on the threads.

Warning

Never use an impact wrench or other automated device to initially start the CLAMPNUT onto the shaft threads as it may cause cross-threading due to the inherent flexibility of the split design.

The lightly snugged CLAMPNUT is now ready to be rotated into position against the bearing/components, preload applied, and cap screw tightened to the recommended torque. Do not over-torque the cap screws as the CLAMPNUT may close up completely with a possible loss of holding power.

CLAMPNUT Screw Recommended Torques

<u>Low Head Metric Screw Size</u>	<u>Torque (Inch-Pounds)</u>	<u>Torque (Newton-metre)</u>
M4	24	2.7
M6	70	7.9
M8	150	17.0
M10	300	34.0
M12	510	57.0

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

Reduce Stainless Steel Cap Screw torque by 30%