DOUBLE SPLIT CLAMPNUT
ASSEMBLY INSTRUCTIONS

The protruding hub of the DOUBLE SPLIT 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 screws is dependent on the customer's requirements and is applied just before assembly. Remove the (2) cap screws to separate the clampnut halves and re-assemble the halves (with the hubs are on the same side) over the shaft thread. Then lightly tighten the cap screws to bring the halves together, keeping the gaps between the two slits uniform to each other, until a light drag is felt when rotating the CLAMPNUT back and forth. 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.

The lightly snugged DOUBLE SPLIT CLAMPNUT is now ready to be rotated into position against the bearing/components, preload applied, and cap screws alternately tightened to the recommended torque while maintaining the slit gap uniformity. 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

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

Unified National Screw Size	Torque (Inch-Pounds)
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%