

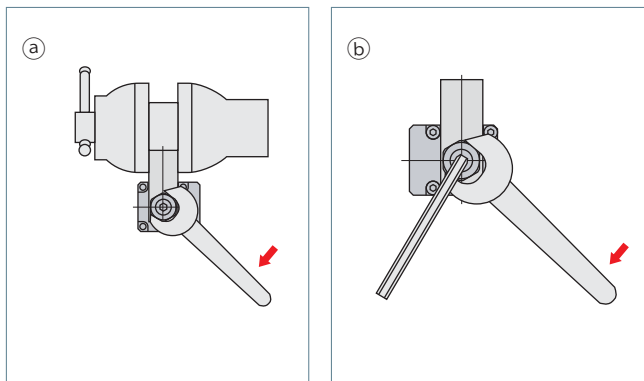
Mounting & dismounting of clamp arm

- Swing clamp may be damaged if excessive torque is applied to piston rod, since structure is intended for swinging using cam mechanism with lead grooves. Follow instructions shown below to prevent excessive torque from being applied on piston rod when mounting or dismounting clamp arm.
- Be sure to tighten the locknut with recommended tightening torque. If the tightening torque is insufficient, clamp arm may slip during operation.

Model		CTK02	CTK04	CTK06	CTK10	CTK16
Recommended tightening torque of locknut	N·m	11	26	51	75	130

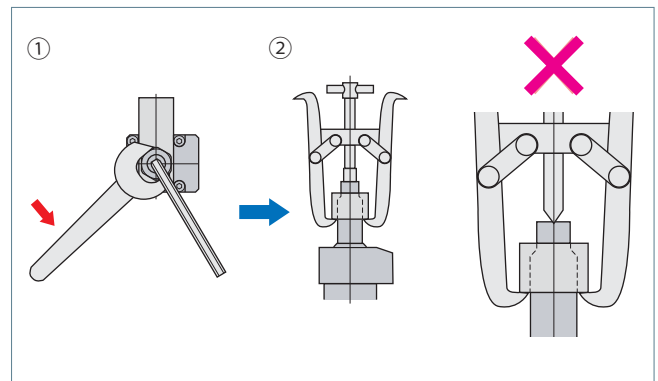
Mounting of clamp arm

- Fix the clamp arm in a vise, then set the clamp body and clamp arm at the desired orientation, and tighten locknut with a wrench.
- For clamps that are mounted on jig, set clamp arm at desired orientation as shown in diagram below. Insert a hex wrench to hex socket at tip section of piston rod to hold it and tighten locknut with a wrench.



Dismounting of clamp arm

- Insert hex wrench to hex socket at tip section of piston rod to ensure that piston rod is held in place, then loosen locknut with wrench.
- After dismounting the locknut, pull out clamp arm using gear puller. A flat saddle type of gear puller should be used when removing an arm not to enlarge the hole on the tip of the piston rod. In addition, be careful not to rotate the rod when removing the arm.



Dismounting of model CTK□N (Cartridge)

1. Check that the hydraulic pressure is set at zero (0).
2. Remove mounting screws.
3. For protection of the mounting surfaces, install the hex socket head set screw or straight pin.
4. Using removal tap hole in the clamp, lift the clamp up with two screws for proper dismounting. In this step, use care not to allow the clamp to become inclined.

