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 locknut with recommended tightening torque. If the tightening torque is insufficient, clamp arm may slip during operation.

Model		CTM03	CTM04	CTM05	CTM06	CTM10	CTM16
Recommended tightening torque of locknut	N·m	22	35	60	100	155	260

Model		CTN02	CTN04	CTN05	CTN06	CTN10	CTN16
Recommended tightening torque of locknut	N·m	7.5	14	40	50	74	116

Model		CTU01 CTT01	CTU02 CTT02	CTU04 CTT04	CTU06 CTT06	CTU10 CTT10	CTU16 CTT16	CTU25 CTT25
Recommended tightening torque of locknut	N·m	12	26	51	60	86	120	180

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

① 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.

② 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.