

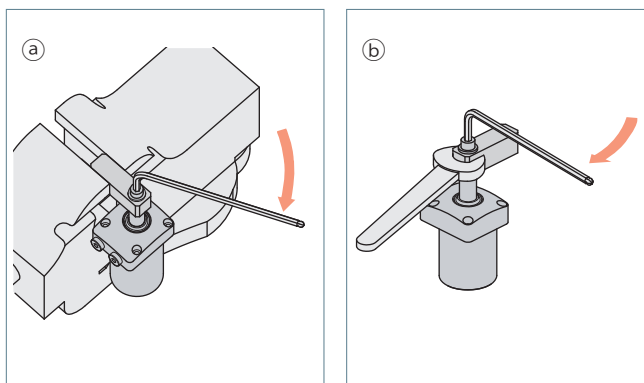
Mounting & dismounting of clamp arm

- Swing clamp may be damaged if excessive torque is applied, 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 hex socket head cap screw with recommended tightening torque. If the tightening torque is insufficient, clamp arm may slip during operation.

Model		CTY25	CTX32 CTY32	CTX40 CTY40	CTX50 CTY50	CTX63 CTY63
Recommended tightening torque of cap screw	N·m	11	25	25	50	53

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 the hex socket head cap screw with a hex wrench.
- For clamps that are mounted on jig, set clamp arm at desired orientation, and hold it with a wrench not to rotate piston rod, and then tighten screw on the piston rod with a hex wrench.



Dismounting of clamp arm

- Hold the clamp arm with a wrench not to rotate piston rod, and then loosen screw on the piston rod with a hex wrench.
- After dismounting hex socket head cap screw, 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.

