

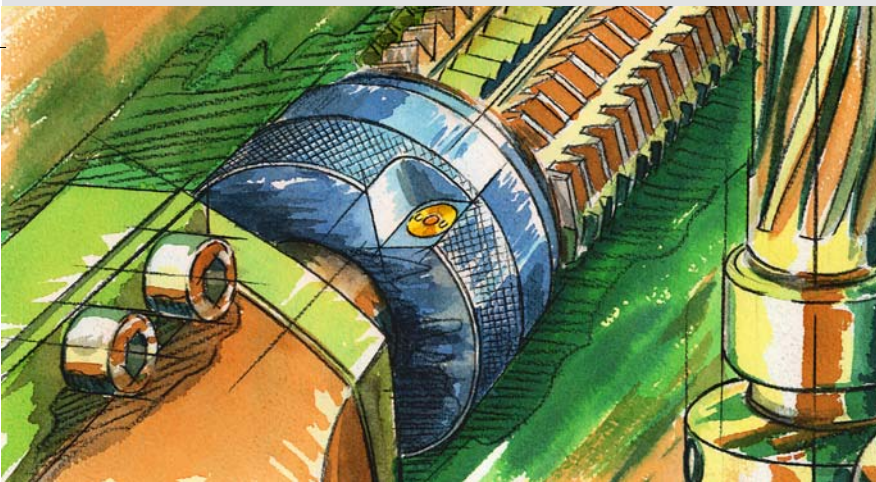
**SCHREM**

## Hydraulic lock nut DK92-Z

With clamping pressure indicator,  
hydraulic retract

## POLYMA-SICCA

SICCA



POLYMA

As a result of the tendency to dry cutting, demands made on lock nuts are changing. Further development resulted from our experiences with the hydraulic lock nut POLYMA-MINORA D92.

The insertion of a flange has 2 functions:

- To prevent the radial movement of the hob even by micrometers.
- To reset the hydraulic to the zero/home position, when the internal pressure is reduced.



During dry hobbing, temperatures of 100°C may occur in the area of the lock nut. This requires the use of a special hydraulic medium and appropriate seals.

As usual, the lock nut is screwed onto the cutter arbor by hand. By screwing-in the pressure screws, the clamping force is increased corresponding to the data of the hydraulic lock nut and the requirements. Both pressure screws have to be tightened. The value of the effective pure axial clamping force can be read from the pressure indicator. By inserting the flange a concentricity of 10 µm is achievable, in most cases, without special alignment.

When the hob is changed, the keyed flange takes over the hydraulics retract function – after the pressure screws have been unscrewed – so that it is easier to unscrew the lock nut from the arbor.