TECHNICAL SAFETY BULLETIN

TSB No. 2103	**STATUS:** REVISION 1
SUBJECT: SUPERNUT JACKBOLTS - TORQUE	
PRIORITY: 3-GENERAL	**RELEASE DATE:** 02/01/24

KEYSTONE TECHNICAL BULLETIN INFORMATION

The bulletin was established to provide updated information regarding installation of the supernut for cluster drill assembly.

BULLETIN DETAILS

The supernut is used to secure hammers within the modules of a cluster drill. These supernuts use a pattern of jackbolts to apply an evenly applied torque across the mating surface. Following field data and experimenting with variations of torque applied to the jackbolts, the specifications below will be used when installing the supernut:

- Follow the tightening procedures outlined in the superbolt instructions (attached).
- The recommended torque for superbolt model CY-250-8 (for Keystone applications) will be 250ftlb torque per jackbolt.

The increased torque that is applied to the jackbolts is intended to closer match the superbolt recommended torque per the model, and also relieve stress that is transferred to the dust cap bolt.

RELATED EQUIPMENT

Keystone Cluster Drills, Keystone Hole Openers, Keystone Core Barrels