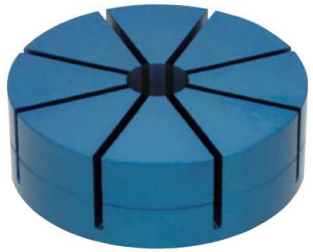
JAWS FOR EXTERNAL FORM HOLDING [CP126] INSTRUCTIONS



For Safe operation of the CP126, please read this instructions carefully before using.
Please keep this instruction manual handy for future reference.

※Please read the CP125 instruction together

Part Number	Proper FORM HOLDING CLAMPS	Allowable Screw Torque (N·m)	Clamping Force(kN)	Allowable Compression Dia.	Proper Oring (NOK)
CP126-06501	CP125-06501	15	4.5	Φ0.6	CO 7772A
CP126-09001	CP125-09001	25	7		CO 0549A
CP126-12001	CP125-12001	40	10		CO 0555A
CP126-16001	CP125-16001		12		CO 0565A

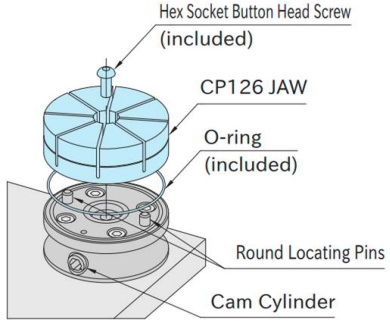
Precautions

Do not actuate clamping the jaw without a workpiece to avoid damage and deformation.
Tightening with torque greater than the allowable screw torque will lower the durability of the jaw.

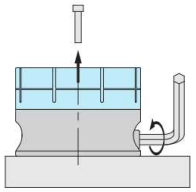
■How To Use

1.Jaw Mounting

・Loosen the cam cylinder by turning it counterclockwise until it stops.
・Insert an O-ring to the groove on top surface of the Form Holding Clamp.
・Set a Jaw putting its locating holes onto the round locating pins and fix it with a hex socket button head screw.

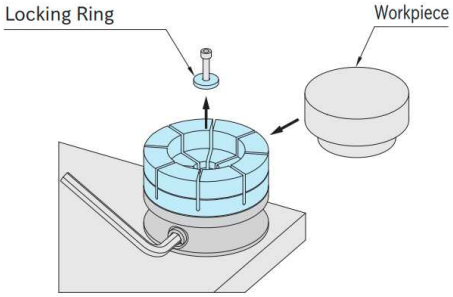


2-2. ・Tighten the cam cylinder to clamp the locking ring. (Recommended Tightening Torque:15N·m)
・After clamping the screw should be removed from the locking ring.



3.Workpiece Loading

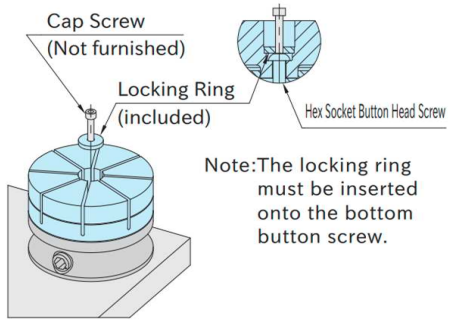
・Loosen the cam cylinder to remove the locking ring.
・Load the workpiece and tighten the cam cylinder for clamping.



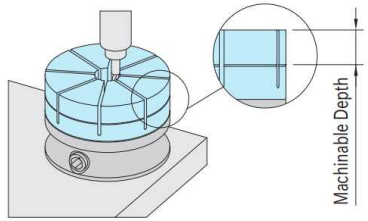
*) Following the above steps for jaw machining, the clearance between the jaw and the workpiece will be 0.3 mm in diameter.

2.Jaw Machining

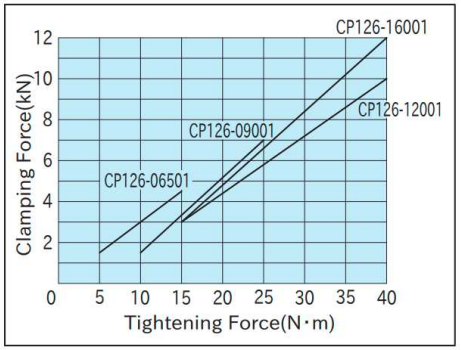
2-1. Set the locking ring in the jaw. (Using a screw facilitates setting.)



2-3. Machine the jaw to the contours of workpiece. (Do not machine the jaws beyond the machinable depth.)



Performance Curve



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