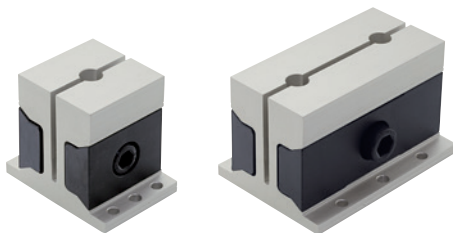


# CP124

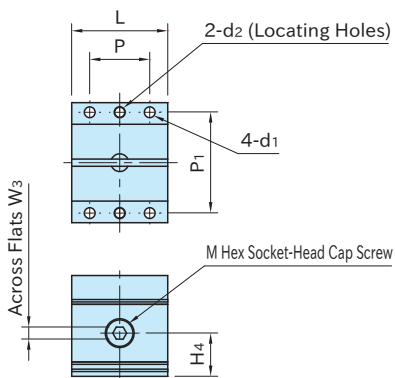
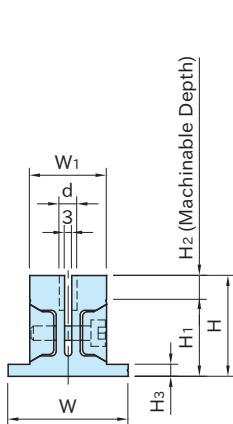
## OD HOLDING CLAMPS (Wedge Style/Square)



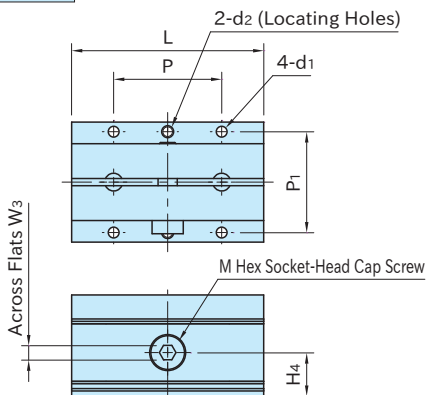
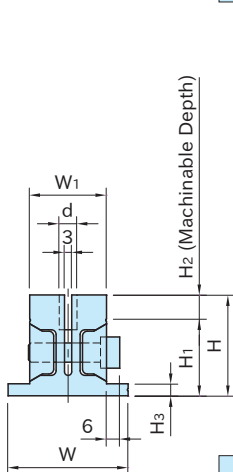
CP124-\*\*\*01

CP124-\*\*\*02

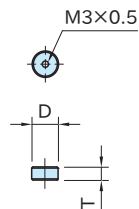
Body	Wedge
A6N01 aluminum Anodized Silver	SCM440 steel Black oxide finished Quenched & tempered



CP124-\*\*\*01



CP124-\*\*\*02



Locking Button

Part Number	W <sub>1</sub>	d	L	H	H <sub>2</sub>	W	H <sub>3</sub>	H <sub>1</sub>	d <sub>2</sub> (H7)	d <sub>1</sub>	P	P <sub>1</sub>	M
CP124-03201	32	7.4	40	42	10	50	5	32	5	4.5	25	42	M 6×1 -25L
CP124-03202			80										M 8×1.25-30L
CP124-05001	50	11.4	50	63	15	72	7	48	6	5.5	30	62	M10×1.5 -40L
CP124-05002			100										M12×1.75-45L

Part Number	W <sub>3</sub>	H <sub>4</sub>	D	T	Clamping Force (kN)	Allowable Screw torque (N·m)	Weight (kg)
CP124-03201	5	18	7	3.5	2.5	7.5	0.22
CP124-03202	6					14	0.42
CP124-05001	8	27	11	5.5	5.5	26	0.62
CP124-05002	10					46	1.29

### Technical Information

Locating Repeatability :  $\pm 0.08$

### Supplied With

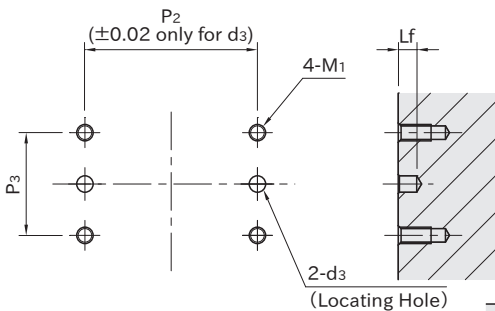
- 1 of locking button for CP124-\*\*\*01
- 2 of locking button for CP124-\*\*\*02
- 2 of parallel pin(m6 tolerance)
- $\phi 5 \times 10L$  for CP124-\*\*\*01
- $\phi 6 \times 15L$  for CP124-\*\*\*02

### Feature

- When the clamp screw is tightened, both jaws tilt toward the center to clamp the circumference of the workpiece.
- The clamping stroke is 0.5mm.
- Cutting the machinable jaw to the contour of workpiece allows holding different shapes.
- Simple and compact design permits multiple-parts holding arrangement.

### How To Use

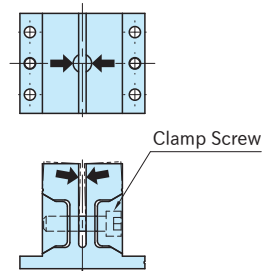
#### ■ Mounting-Hole Dimension



Use the included parallel pin for locating.

### Note

- Do not tighten the clamp screw without the workpiece set to prevent damage and deformation.
- Do not machine the jaws beyond the machinable depth



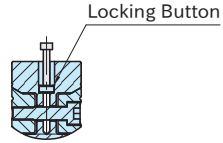
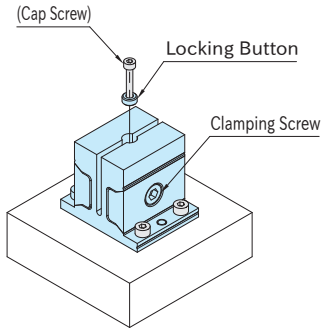
Part Number	d <sub>3</sub> (H7)	Lf	M <sub>1</sub>	P <sub>2</sub>	P <sub>3</sub>
CP124-03201	5	5	M4×0.7	42	25
CP124-03202					45
CP124-05001	6	8	M5×0.8	62	30
CP124-05002					58

Continuing to next page

## ■ How to Machine Jaw

### 1. Setting the locking button

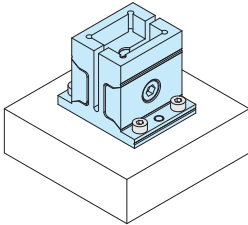
Insert the locking button into the jaw, and then tighten the clamp screw to fasten the locking button.  
(Using a cap screw facilitates setting)



Note: The locking button must be inserted onto the bottom.

### 2. Machining the jaw

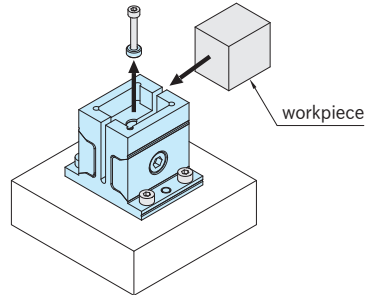
Cut the jaw to the contours of the workpiece.



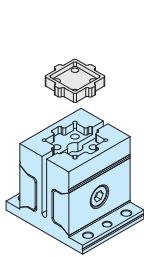
Note: Do not cut beyond the machinable depth.

### 3. Workpiece Loading

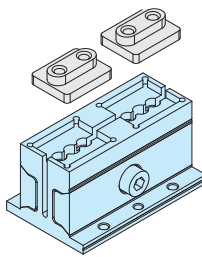
Loosen the clamp screw to remove the locking button. Load the workpiece and tighten the clamp screw for clamping.



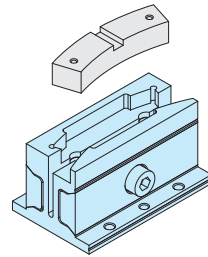
## ■ Application Example



Single-station mode  
on the short-type clamp



Dual-station mode  
on the long-type clamp



Single-station mode  
on the long-type clamp