

# How To Use FLEX LOCATORS (Blind)

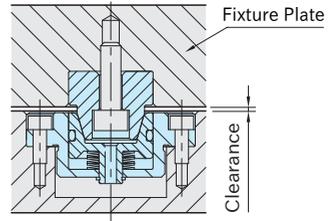
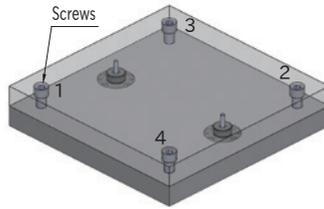
## Tightening Order

1. Ensure that each plate is in close contact.\*)
2. Tighten the screws temporarily in order of 1→2→3→4.  
For temporary tightening, the tightening torque should be approximately 50% of the final tightening.
3. Tighten the screws finally in order of 1→2→3→4.

\*) The fixture plate may be pushed up by the lifting force of **CP725** Flex Locator Bushings.

In such cases, tighten the screws loosely in order of 1→2→3→4, and make the each plate be in close contact with each other. Then tighten the screws temporarily.

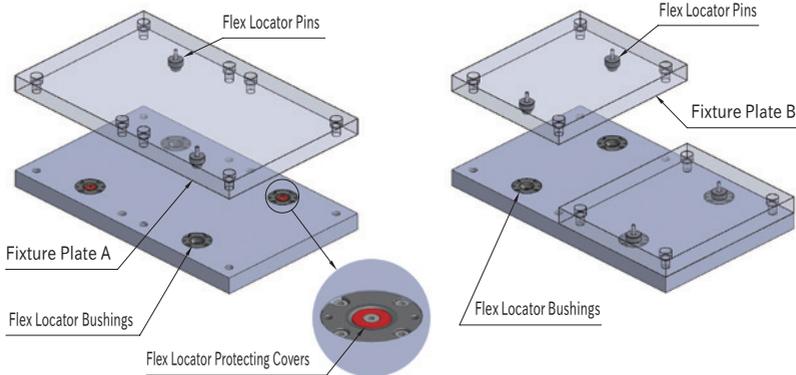
For the lifting force, see the measurement table of **CP725** Flex Locator Bushings.



If the screws are not tightened in the correct order, the locating repeatability may exceed 10 μm.

## How To Use

### Horizontal Assembly of Base Plate and Fixture Plate



### Vertical Assembly of Tooling Block and Fixture Plate

If the total load exceeds the maximum loading capacity, the locating repeatability may exceed 10 μm.

Size	Max. Loading Capacity(kN)
	0.8
<b>CP720</b>	1.2
<b>CP725</b>	2
	2.2

Note: The maximum load is the entire sum of the load of fixture plates, fixtures and workpieces.

Note: The maximum loading capacity shown is the value when two sets of **CP720** Flex Locator Pins and **CP725** Flex Locator Bushings are used.

