How To Use FLEX LOCATORS (Blind)

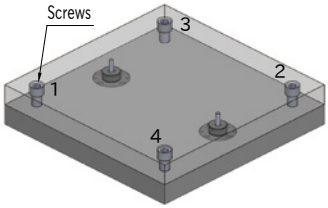
Tightening Order

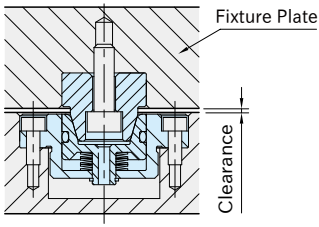
1.Ensure that each plate is in close contact.*)

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 Locating Receivers.
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 Locating Receivers.

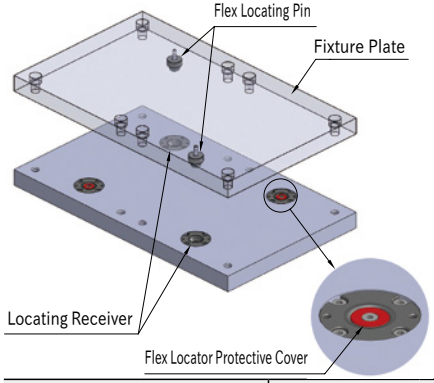




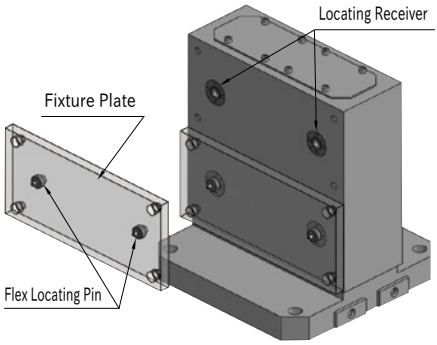
If the screws are not tightened in the correct order, the locating repeatability may exceed 10 μm.

How To Use

■Horizontal Assembly of Base Plate and Fixture Plate



■Vertical Assembly of Tooling Block and Fixture Plate



Size		Horizontal Assembly		Vertical Assembly	
		Max. Loading Weight (kg)	Locating Repeatability	Max. Loading Weight (kg)	Locating Repeatability
CP720-16032 CP720-10032N	CP725-16032	45	10μm	80	10μm
CP720-25050 CP720-15050N	CP725-25050	70		120	
CP720-38070 CP720-20070N	CP725-38070	160		200	
CP720-56095 CP720-30095N	CP725-56095	280		220	

Note: These values shown above are when 2 pairs of tapered Locating Pins and tapered Locating Receivers are used. When 4 pairs of tapered Locating Pins and tapered Locating Receivers are used, the maximum loading weight is double the above values.

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

Note: When used in excess of the maximum loading weight, the locating repeatability may exceed the above values.