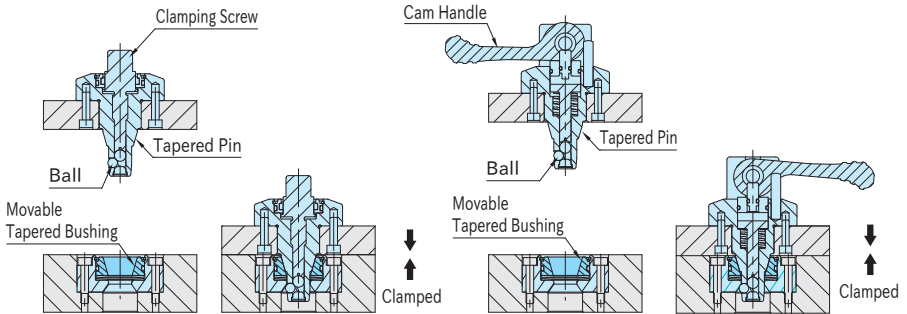


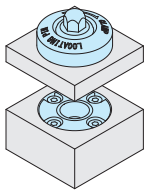
How To Use ONE-TOUCH FLEX LOCATORS (Hexagon Head / Cam Handle)

Feature

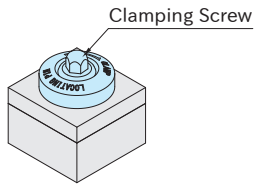


- The plate is located by fitting of the tapered parts.
 - When the clamping screw or the cam handle is tightened, the balls goes out and the movable tapered bushing goes down. The fixture plate contacts with the base plate.
 - For clamping screw, 2 turns tightening is enough.
- Note: No locating function on the combination of straight pin and straight bushing.

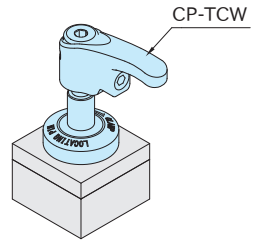
How To Operate



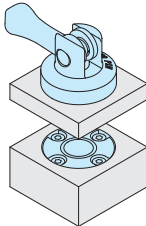
1. Ensure the balls are retracted.



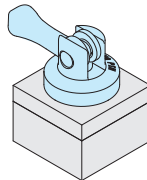
2. Insert the clamping screw to the bushing.



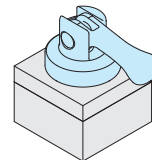
3. Tighten the clamping screw within the allowable torque.
Note: For unclamping, follow back these steps.



1. Ensure that the cam handle is loosened.

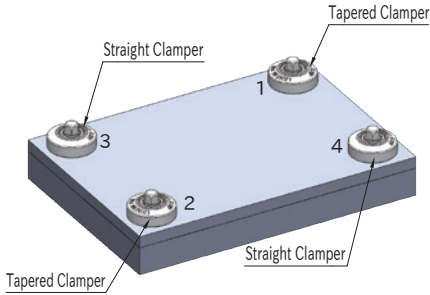


2. Insert the clamping screw to the bushing.



3. Tighten the cam handle.
Note: For unclamping, follow back these steps.

Tightening Order



CP730

- 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 the tapered bushing. 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 [CP735](#) ONE-TOUCH FLEX LOCATOR BUSHINGS.

CP731

- Tighten the cam handles in order of 1→2→3→4.

If the screws are not tightened in the correct order, the locating repeatability may exceed $8 \mu\text{m}$.

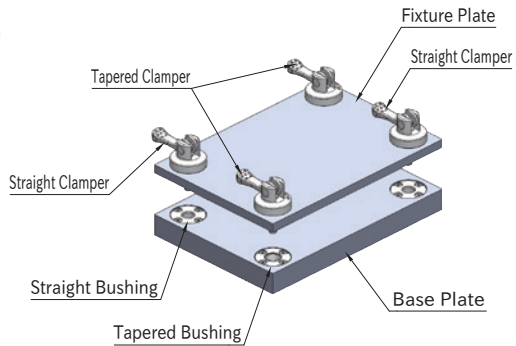
How To Use

Horizontal Assembly

Two sets of tapered pin and straight pin

Use tapered or straight pin and bush as a set.

Note:Ensure not to lift the fixture plate up and down with gripping the cam handle of the clampers.

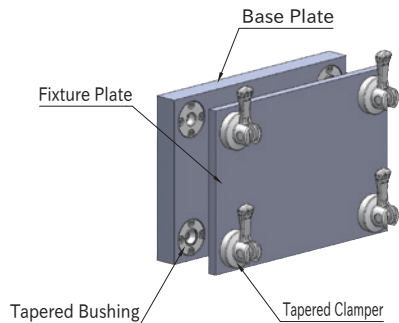


Vertical Assembly

In vertical assembly, the locating repeatability is $10 \mu\text{m}$.

Size		Max. Loading Capacity(N)
CP730	0939	400
	1246	600
CP735	1656	1000

Size		Max. Loading Capacity(N)
CP731	0939	250
	1246	400
CP735	1656	600



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 tapered clamper and tapered bushing are used.