

OD HOLDING CLAMPS

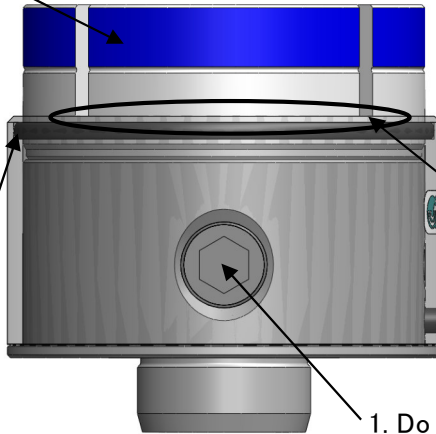
INSTRUCTIONS

CP120-06501
CP120-09001

Precautions

1. Do not actuate clamping without a workpiece inserted, to avoid damage and deformation.
2. Do not machine the jaw beyond the machinable area.
3. Check if the O-ring is fitted properly before installing the jaw.
4. Insert the jaw completely from right above.
The O-ring can make it hard to insert the jaw.

2. Machinable Area



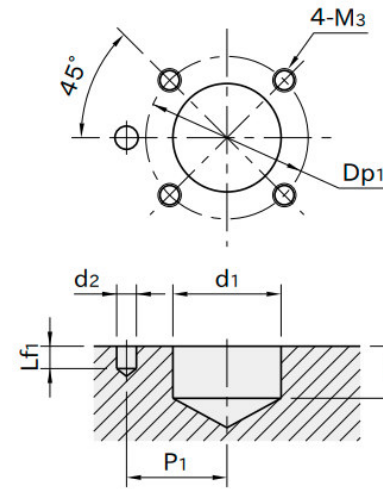
4. Install Jaw Perpendicularly.

3. O-Ring to keep out metal chips

1. Do Not Tighten Locking Screw Without Workpiece Inserted Into Jaw.

Part Number	O-Rings for Jaws
CP120-06501	CO 0544(S65) NOK
CP120-09001	CO 0551(S90) NOK

Hole Preparation



Part Number	d ₁ (H7)	L _f	d ₂ (G7)	L _{f1}	P ₁ (±0.02)	M ₃	D _{p1}
CP120-06501	28	13	6	6	26	M6X1	42
CP120-09001	42	15	8	8	36	M8X1.25	60

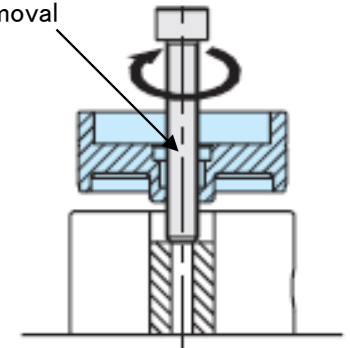
Jaw Removal

1. Remove the jaw-fastening screw.
2. Insert a screw with one-size larger threads (jaw-removing screw) into the jaw's tapped hole and thrust it against the body.

1. Jaw-Fastening Screw



2. Cap Screw for Jaw Removal

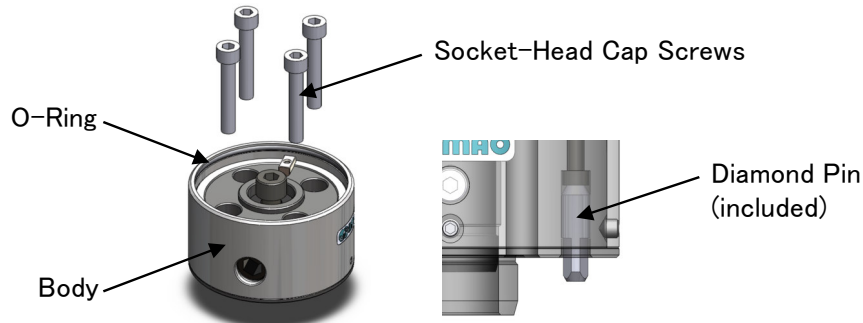


Part Number	Cap Screw for Jaw Removal
CP120-06501	M10
CP120-09001	M12

Setting Information

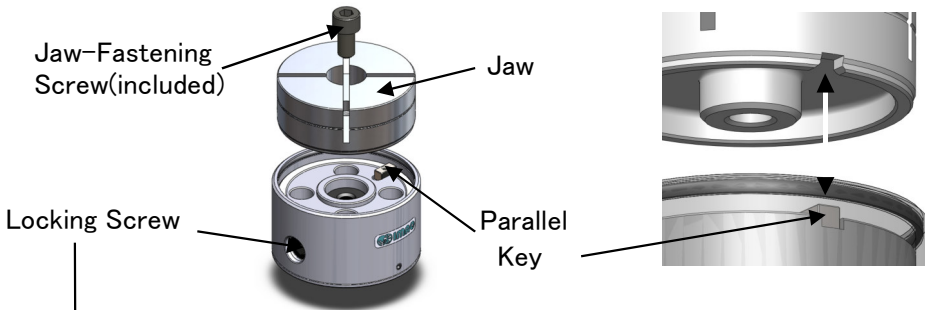
1. Body Installation

Insert the diamond pin into the body and then fasten the body to the fixture plate using four socket-head cap screws.



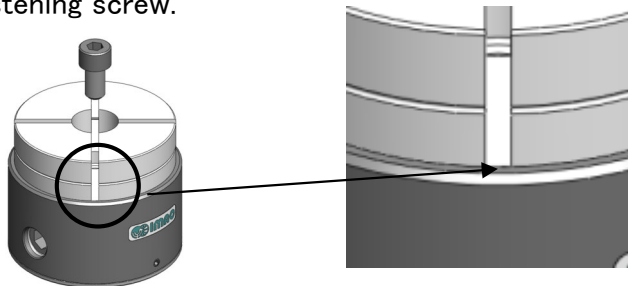
2. Jaw Installation

1) Fit the keyway on the jaw bottom onto the parallel key on the body top and then press down the jaw from right above.



Note : At jaw installation, ensure the locking screw is fully loosened by turning counterclockwise until it stops.

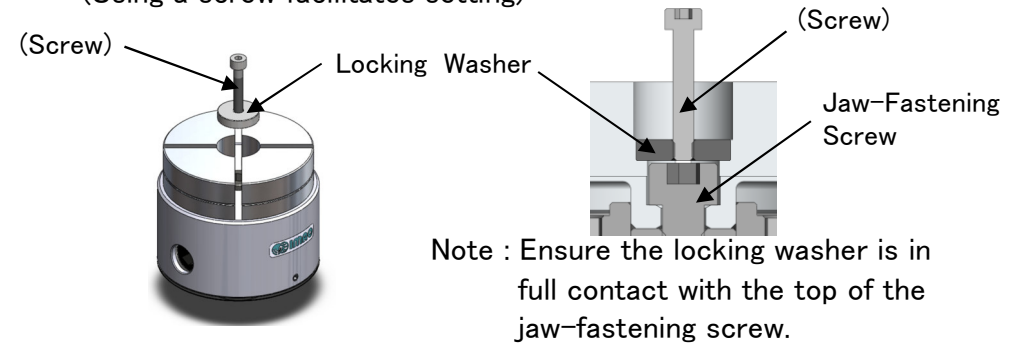
2) Check to see if the jaw is properly positioned, and then lock it using the jaw-fastening screw.



Note : Ensure the slit bottom is flush with the top of the body cover at all four places, as shown above.

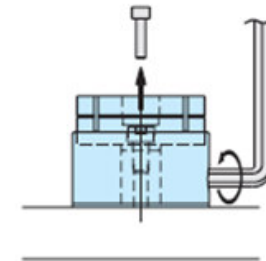
3. Jaw Machining

1) Set the locking washer into the jaw.
(Using a screw facilitates setting)

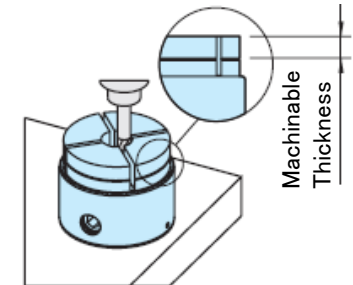


2) Tighten the locking screw to clamp the locking ring.
(Tighten with half of the allowable screw torque or more.)

After clamping the screw, remove the screw from the locking ring.

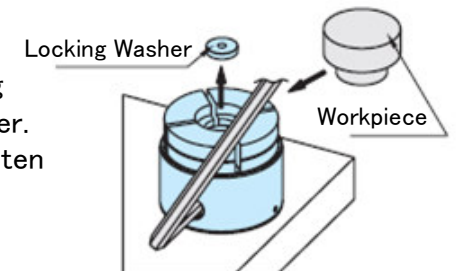


3) Machine the jaw to the contours of a workpiece.



4. Workpiece Loading

1) After machining, loosen the locking screw to remove the locking washer.
2) Insert the workpiece and then tighten the locking screw for clamping.



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