

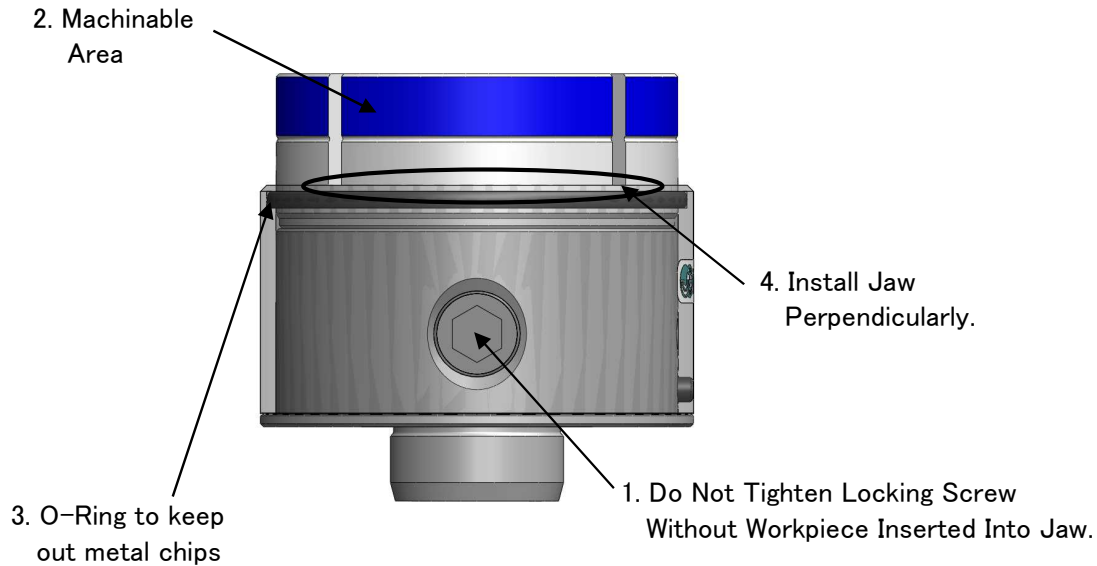
# OD HOLDING CLAMPS

## INSTRUCTIONS

CP120-06501  
CP120-09001

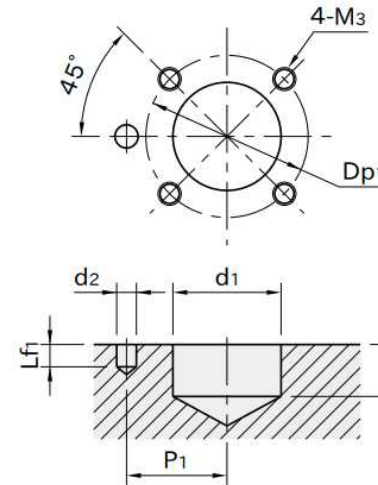
### Precautions

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.



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

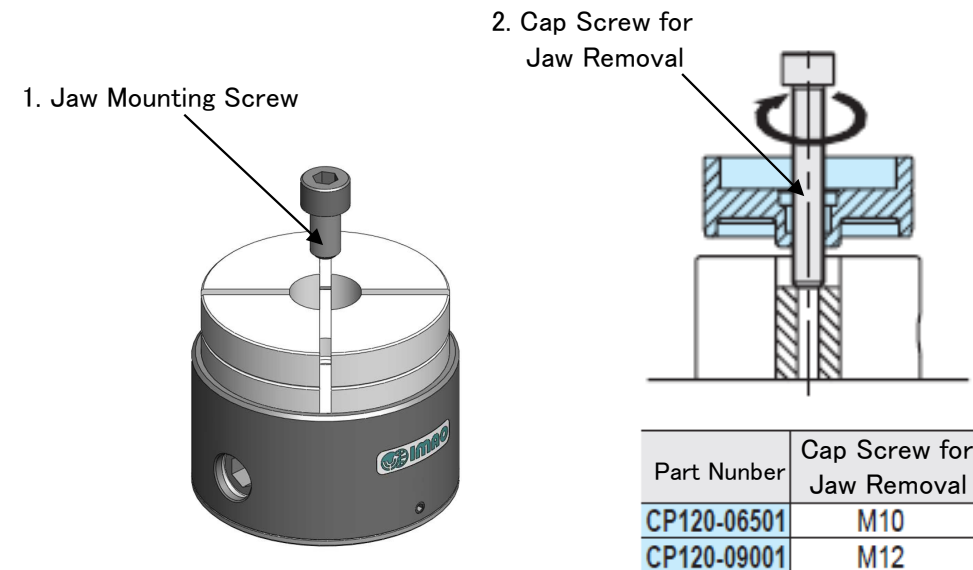
### Hole Preparation



| Part Number | d <sub>1</sub><br>(H7) | L <sub>f</sub> | d <sub>2</sub><br>(G7) | L <sub>f1</sub> | P <sub>1</sub><br>(±0.02) | M <sub>3</sub> | D <sub>p1</sub> |
|-------------|------------------------|----------------|------------------------|-----------------|---------------------------|----------------|-----------------|
| CP120-06501 | 28                     | 13             | 6                      | 6               | 26                        | M6×1           | 42              |
| CP120-09001 | 42                     | 15             | 8                      | 8               | 36                        | M8×1.25        | 60              |

### Jaw Removal

1. Remove the jaw mounting 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.

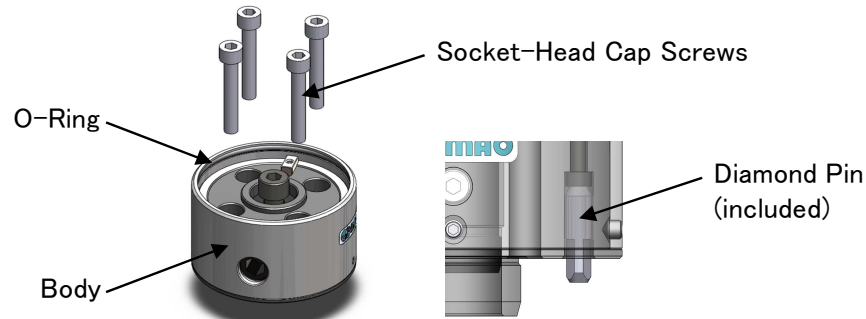


| Part Number | Cap Screw for Jaw Removal |
|-------------|---------------------------|
| CP120-06501 | M10                       |
| CP120-09001 | M12                       |

## Setting Information

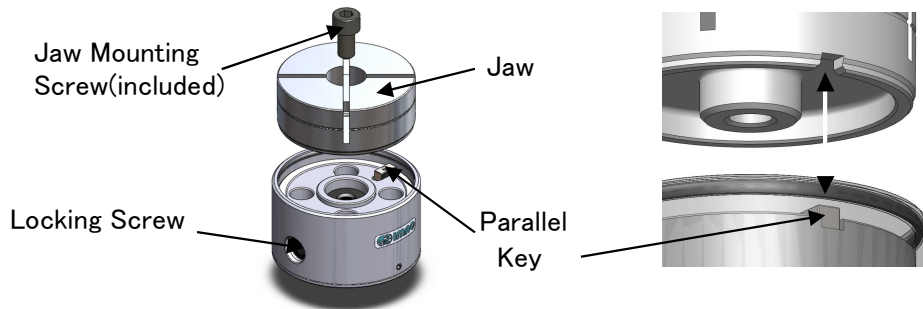
### 1. Body Installation

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

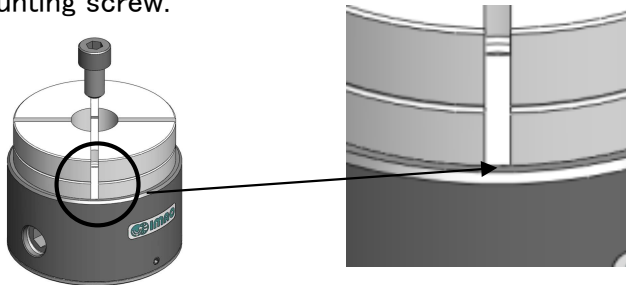


### 2. Jaw Installation

1) Loosen the locking screw by turning it counterclockwise until it stops. Then fit the keyway on the jaw bottom onto the parallel key on the body top and press down the jaw from right above.



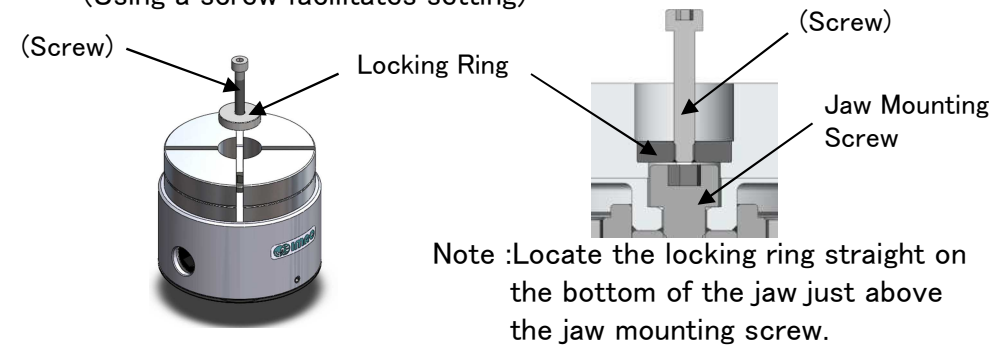
2) Check to see if the jaw is properly positioned, and then lock it using the jaw mounting screw.



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

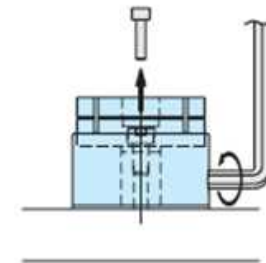
### 3. Jaw Machining

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

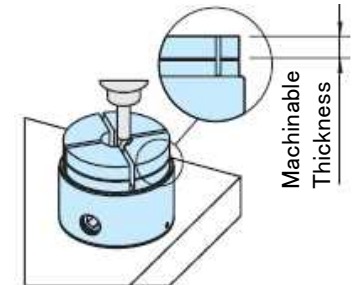


2) Tighten the locking screw to clamp the locking ring.  
(Tighten with half of the allowable screw torque or more.)

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

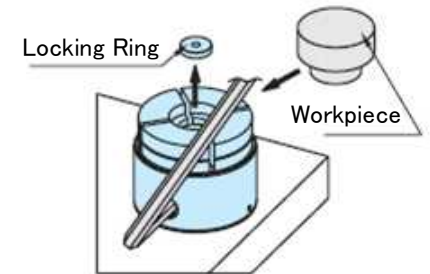


3) Machine the jaw to the contours of a workpiece.



### 4. Workpiece Loading

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



\*)Following the above steps for jaw machining, the clearance between the jaw and the workpiece will be 0.3 mm in diameter.

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