

# JAWS FOR OD HOLDING CLAMPS

## INSTRUCTIONS

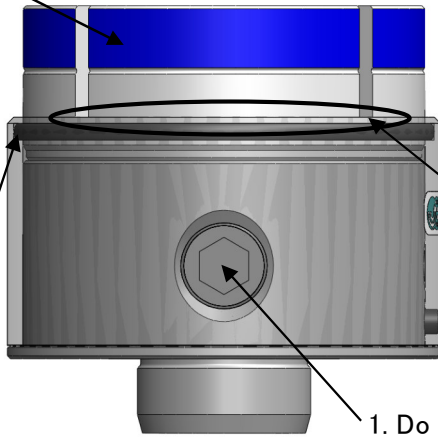
CP121-06501  
CP121-09001

\*The image below shows the body of CP120 clamps.

### Precautions

1. Do not actuate clamping\*1) 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
3. O-Ring To Keep Out Metal Chips



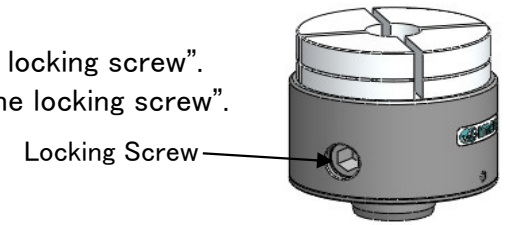
4. Install Jaw Perpendicularly.

1. Do Not Actuate Clamping\*1) Without Workpiece Inserted Into Jaw.

### Definition of “clamp(ing)” and “unclamp(ing)” used in the instructions

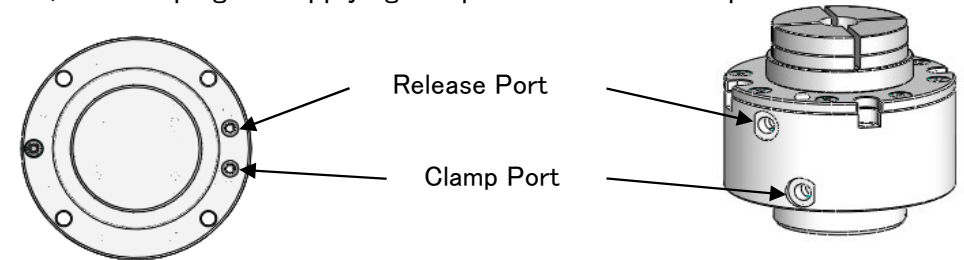
•For CP120 Clamps,

- \*1) “clamping” = “tightening the locking screw”.
- \*2) “unclamping” = “loosening the locking screw”.



•For AMCH Clamps,

- \*1) “clamping” = “applying air pressure to clamp port”.
- \*2) “unclamping” = “applying air pressure to release port”.

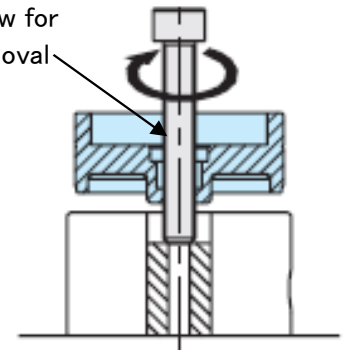
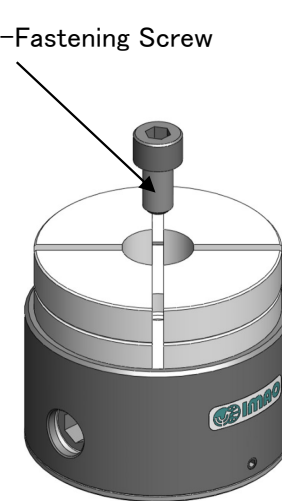


### Jaw Removal

1. Set the jaw in the unclamping \*2) mode.
2. Remove the jaw-fastening screw.
3. Insert a screw of thread size specified below into the jaw's tapped hole and thrust it against the body.

2. Jaw-Fastening Screw

3. Cap Screw for Jaw Removal

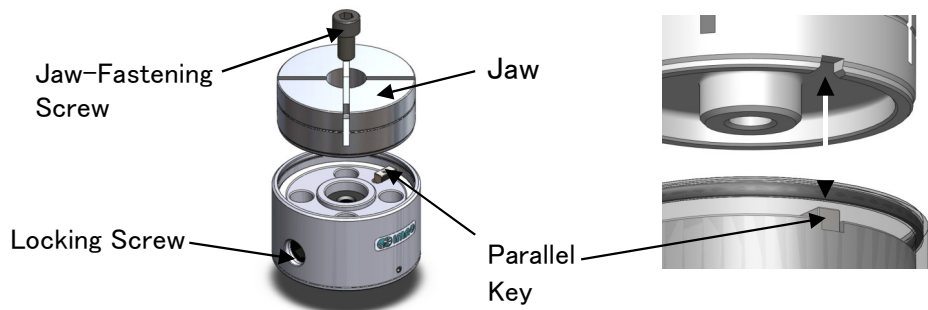


Part Number	Cap Screw for Jaw Removal
CP121-06501	M10
CP121-09001	M12

Jaws	O-Rings	OD Holding Clamps	Air-Assist OD Holding Clamps
CP121-06501	CO 0544(S65) NOK	CP120-06501	AMCH080-5W
CP121-09001	CO 0551(S90) NOK	CP120-09001	AMCH100-5W

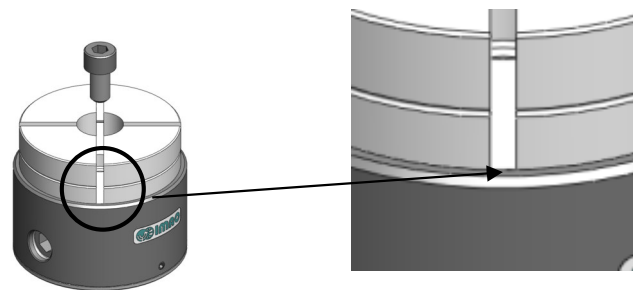
## Jaw Installation

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 **CP120** : At jaw installation, ensure the locking screw is fully loosened by turning counterclockwise until it stops.  
**AMCH** : Jaw setting must be done with the unclamping port pressurized.

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

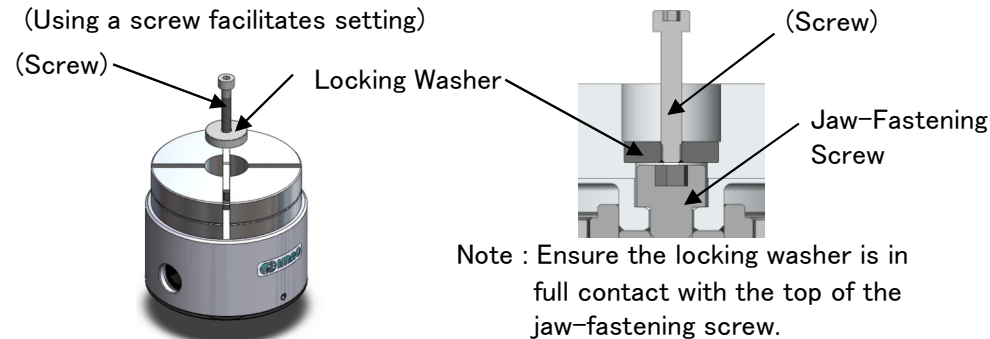


Jaw	Jaw-Fastening Screw
CP121-06501	M8x15L
CP121-09001	M10x20L

Note : Ensure the slit bottom is flush with the top of the body cover at all four places, as shown above.  
 Installation must be run in the unclamping\*2) mode.

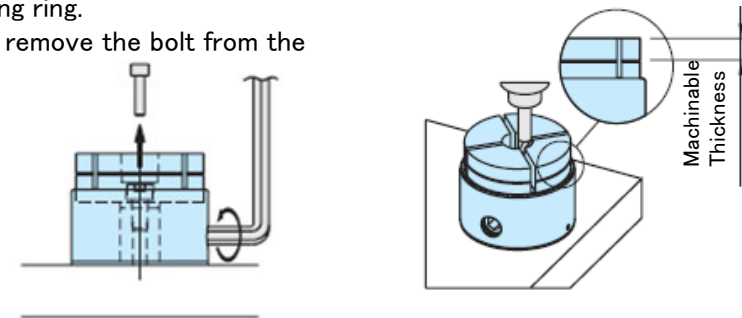
## Jaw Machining

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



2. **CP120** : Tighten the locking screw to clamp the locking ring.  
 (Tighten with half of the allowable screw torque or more.)

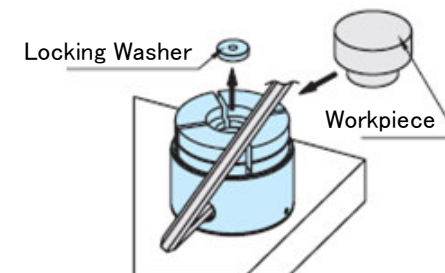
**AMCH** : Apply air to the clamping port to clamp the locking ring.  
 After clamping, remove the bolt from the locking washer.



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

## Workpiece Loading

1. After machining, unclamp\*2) the workpiece and remove the locking washer.
2. Insert the workpiece and clamp\*1) it.



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