

# JAWS FOR INTERNAL FORM HOLDING [CP127] INSTRUCTIONS



For Safe operation of the CP127, please read this instructions carefully before using.  
Please keep this instruction manual handy for future reference.

※Please read the CP125 instruction together

Part Number	Proper FORM HOLDING CLAMPS	Allowable Screw Torque (N·m)	Clamping Force(kN)	Allowable Expansion Dia.	Proper Tapered Screws	Proper Oring (NOK)	
						Large	Small
CP127-06501	CP125-06501	15	4.5	Φ0.6	CP127-06501B	CO 3107A	CO 0602A
CP127-09001	CP125-09001	25	7		CP127-09001B	CO 0211A	CO 0606A
CP127-12001	CP125-12001	40	10		CP127-12001B	CO 0217A	
CP127-16001	CP125-16001				CP127-16001B	CO 1786A	CO 0609A

## Precautions

Do not actuate clamping the jaw without a workpiece to avoid damage and deformation.

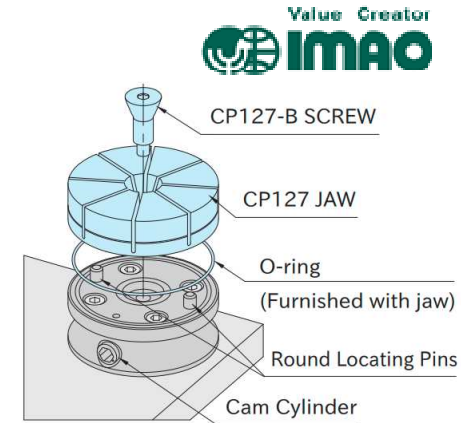
Tightening with torque greater than the allowable screw torque will lower the durability of the jaw.

## ■ How To Use

### 1. Jaw Mounting

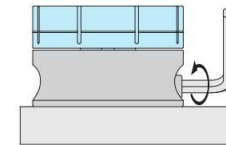
- Loosen the cam cylinder by turning it counterclockwise until it stops.
- Insert an O-ring to the groove on top surface of the Form Holding Clamp.
- Set a Jaw putting its locating holes onto the round locating pins and fix it with a tapered screw.

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

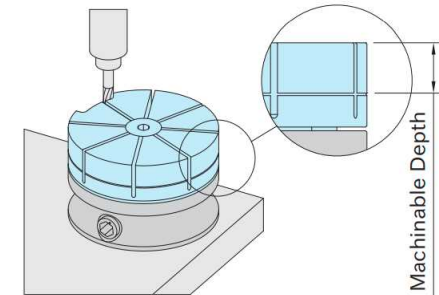


### 2. Jaw Machining

- 2-1. Loosen the cam cylinder fully and measure the dimension of the jaw for machining. Then tighten the cam cylinder until each jaw section expands 0.15mm.

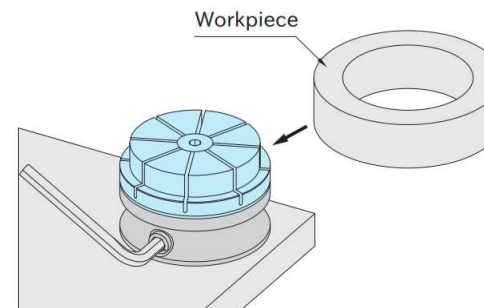


- 2-2. Machine the jaw to the contours of workpiece. (Do not machine the jaws beyond the machinable depth.)

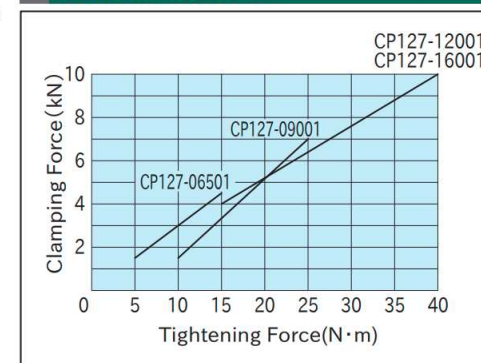


### 3. Workpiece Loading

After machining loosen the cam cylinder to set workpiece and tighten the cam cylinder again for clamping.



### Performance Curve



\*) 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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