

INSTRUCTIONS

Please read this instruction manual for your safety use.

Note

CP730

- Do not tighten the clamping screw without the bushing CP735 to prevent break.
- If you apply greater torque for unclamping, the clamping screw could be fixed. Do not loosen more after it stops.
- Apply allowable torque for clamping after ensuring the clamping screw rotates smoothly.

Tightening Order

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

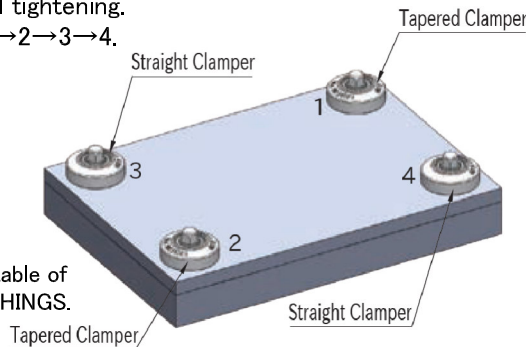
CP730

- Ensure that each plates is in close contact with each other. *)
- 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.
- 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.



CP735 Lifting force/pc.

Part Number	Lifting Force (N)**)
CP735-0939L	300
CP735-1246L	450
CP735-1656L	680

**) The lifting force is the power of the inner spring of the body to push up the movable tapered bushing.

CP730 Allowable Screw Torque

Part Number	Allowable Screw Torque(N·m ***)
CP730-0939	2
CP730-1246	4
CP730-1656	7

***) Do not apply greater torque than allowable screw torque. Do not use a power tool (impact wrench etc.) to turn the hex head, for damage prevention.

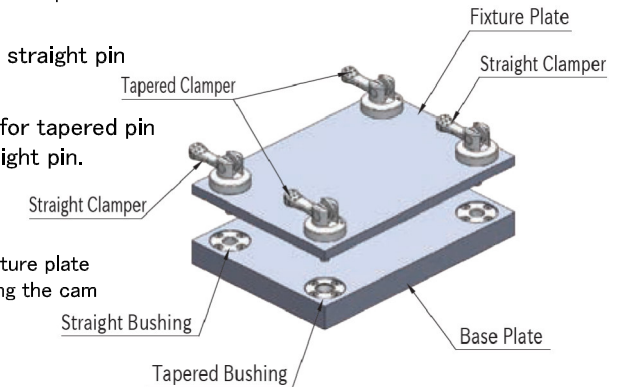
CP731 Operating Load

Part Number	Operating Load(N)
CP731-0939	60
CP731-1246	130
CP731-1656	160

Horizontal Assembly

Two sets of tapered pin and straight pin

Please use tapered bushing for tapered pin and straight bushing for straight pin.



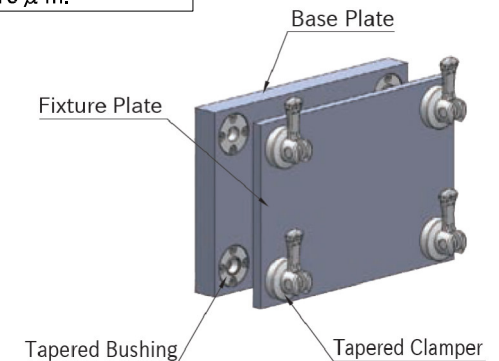
Note: Ensure not to lift the fixture plate up and down with gripping the cam handle of the clampers.

Vertical Assembly

If the total weight exceeds the maximum loading weight, the locating repeatability may exceed $10\mu\text{m}$.

Size		Max. Loading Weight(kg)
CP730	0939	40
	1246	60
CP735	1656	100

Size		Max. Loading Weight(kg)
CP731	0939	25
	1246	40
CP735	1656	60



Note: The maximum loading weight is the entire sum of the weight of fixture plates, fixtures and workpieces.

Note: The maximum loading weight shown is the value when two sets of tapered clamper and tapered bushing are used.

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