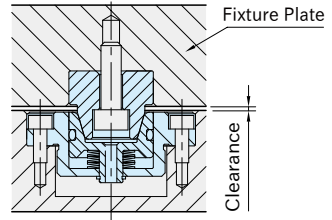
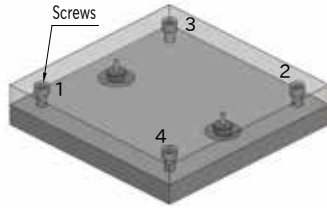


How To Use FLEX LOCATORS (Blind)

Tightening Order

1. Ensure that each plate is in close contact.*)
2. 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.
3. Tighten the screws finally in order of 1→2→3→4.

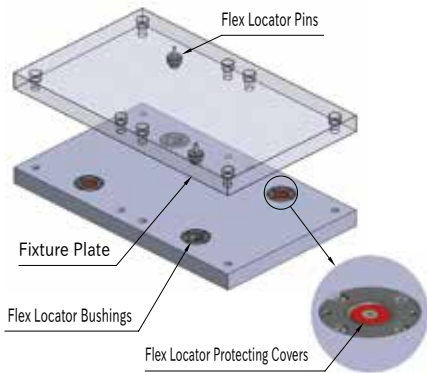
*) The fixture plate may be pushed up by the lifting force of **CP725** Flex Locator Bushings.
In such cases, tighten the screws loosely in order of 1→2→3→4, and make the each plate be in close contact with each other.
Then tighten the screws temporarily.
For the lifting force, see the measurement table of **CP725** Flex Locator Bushings.



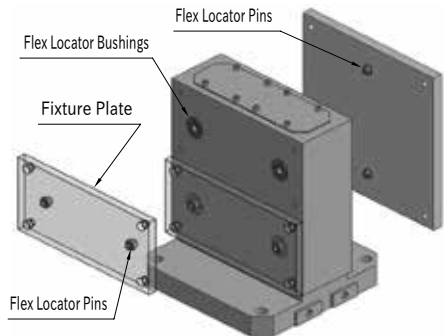
If the screws are not tightened in the correct order, the locating repeatability may exceed 10 μ m.

How To Use

Horizontal Assembly of Base Plate and Fixture Plate



Vertical Assembly of Tooling Block and Fixture Plate



Size		Horizontal Assembly		Vertical Assembly	
		Max. Loading Weight (kg)	Locating Repeatability	Max. Loading Weight (kg)	Locating Repeatability
CP720 CP725	16032	45	10 μ m	80	10 μ m
	25050	70		120	
	38070	160		200	
	56095	280		220	

Note: These values shown above are when 2 pairs of tapered clampers and tapered bushings are used.
When 4 pairs of tapered clampers and tapered bushings are used, the maximum loading weight is double the above values.

Note: The maximum loading weight is the entire sum of the weight of fixture plates, fixtures and workpieces.
Note: When used in excess of the maximum loading weight, the locating repeatability may exceed the above values.