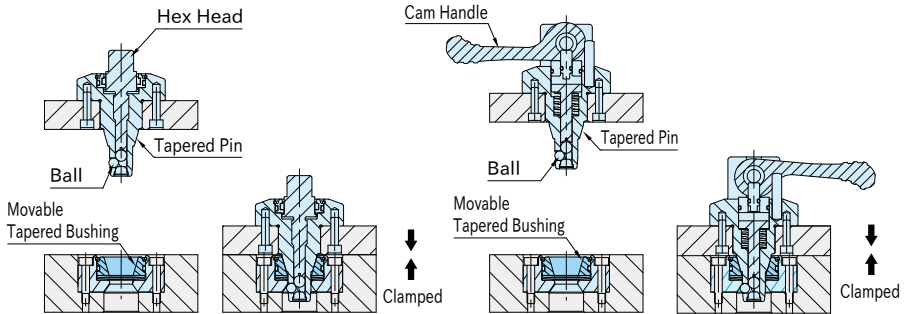


# How To Use ONE-TOUCH FLEX LOCATORS (Hexagon Head / Cam Handle)

## Feature

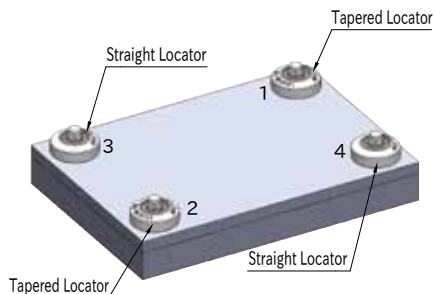


- Fitting of the tapered surfaces ensures precise positioning.
  - Turning the hex head/cam handle pushes the balls outward, engaging the tapered pin with the locating receiver. This compresses the spring-loaded floating bushing, ensuring a secure contact between the plate surfaces.
  - Hex head type requires 2 turns to complete clamping.
- Straight pin locator and straight bushing receiver have no locating function and are for clamping only.

## How To Operate

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- The operating steps are illustrated with isometric diagrams:
1. Ensure the balls are retracted.
  2. Insert the Locator to the Locating Receiver.
  3. Tighten the hex head within the allowable torque.  
Note: For unclamping, follow back these steps.
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1. Ensure that the cam handle is loosened.
  2. Insert the Locator to the Receiver.
  3. Tighten the cam handle.  
Note: For unclamping, follow back these steps.

## Tightening Order



### CP730

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

\*) The fixture plate may be pushed up by the lifting force of the tapered Receiver. In such cases, tighten the Locator loosely in order of 1→2→3→4, and make the each plate be in close contact with each other. Then tighten the Locator temporarily. For the lifting force, see the measurement table of [CP735](#) LOCATING RECEIVERS.

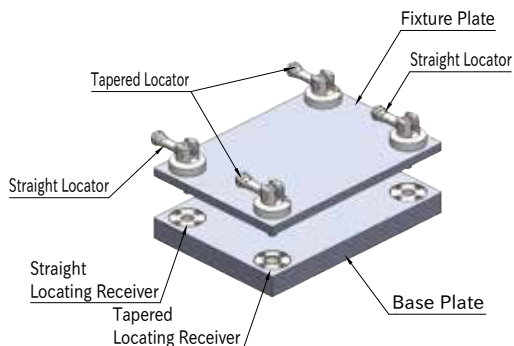
### CP731

- Tighten the cam handles in order of 1→2→3→4.

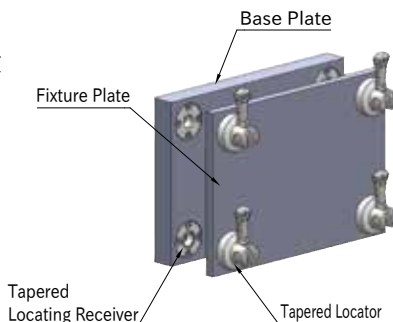
If the Locator are not tightened in the correct order, the locating repeatability may exceed  $8\mu\text{m}$ .

## How To Use

### ■ Horizontal Assembly



### ■ Vertical Assembly



Use tapered or straight Locator and Locating Receiver as a set.

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

| Size           |      | Horizontal Assembly      |                        | Vertical Assembly        |                        |
|----------------|------|--------------------------|------------------------|--------------------------|------------------------|
|                |      | Max. Loading Weight (kg) | Locating Repeatability | Max. Loading Weight (kg) | Locating Repeatability |
| CP730<br>CP735 | 0939 | 120                      | 8 $\mu\text{m}$        | 40                       | 10 $\mu\text{m}$       |
|                | 1246 | 180                      |                        | 60                       |                        |
|                | 1656 | 280                      |                        | 100                      |                        |
| CP731<br>CP735 | 0939 | 120                      |                        | 25                       |                        |
|                | 1246 | 180                      |                        | 40                       |                        |
|                | 1656 | 280                      |                        | 60                       |                        |

Note: These values shown above are when 2 pairs of tapered Locators and tapered Locating Receivers are used. When 4 pairs of tapered Locators and tapered Locating Receivers 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.