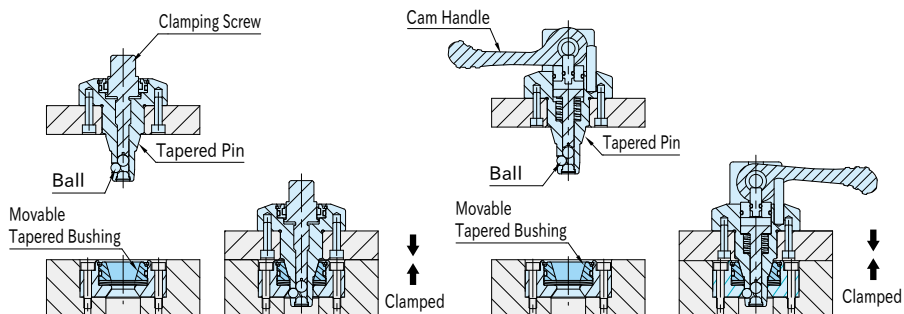


How To Use ONE-TOUCH FLEX LOCATORS (Hexagon Head / Cam Handle)

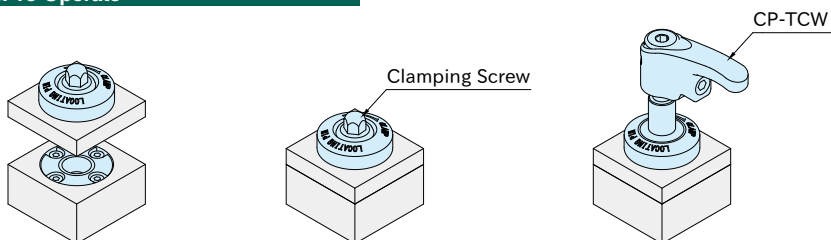
Feature



- The plate is located by fitting of the tapered parts.
- When the clamping screw or the cam handle is tightened, the balls goes out and the movable tapered bushing goes down. The fixture plate contacts with the base plate.
- For clamping screw, 2 turns tightening is enough.

Note: No locating function on the combination of straight pin and straight bushing.

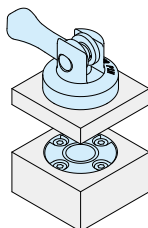
How To Operate



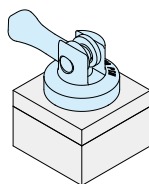
1. Ensure the balls are retracted.

2. Insert the clammer to the bushing.

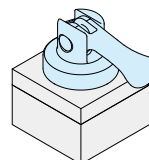
3. Tighten the clamping screw within the allowable torque.
Note: For unclamping, follow back these steps.



1. Ensure that the cam handle is loosened.

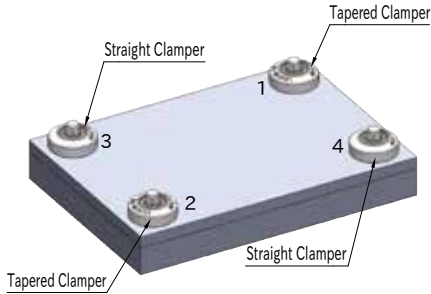


2. Insert the clammer to the bushing.



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 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 the tapered bushing. In such cases, tighten the screws loosely in order of 1→2→3→4, and make 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.

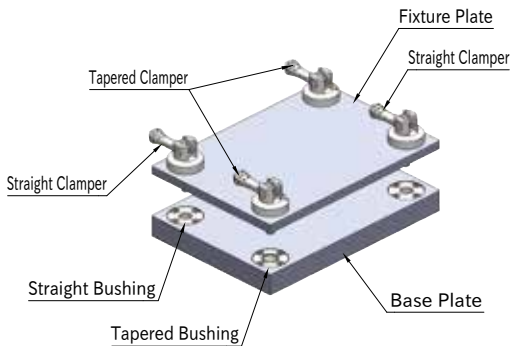
CP731

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

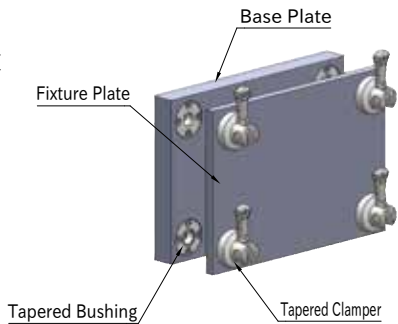
If the screws are not tightened in the correct order, the locating repeatability may exceed $8\ \mu\text{m}$.

How To Use

■ Horizontal Assembly



■ Vertical Assembly



Use tapered or straight pin and bush as a set.

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

Size		Horizontal Assembly		Vertical Assembly	
		Max. Loading Weight (kg)	Locating Repeatability	Max. Loading Weight (kg)	Locating Repeatability
CP730 CP735	0939	120	8 μm	40	10 μm
	1246	180		60	
	1656	280		100	
CP731 CP735	0939	120		25	
	1246	180		40	
	1656	280		60	

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.