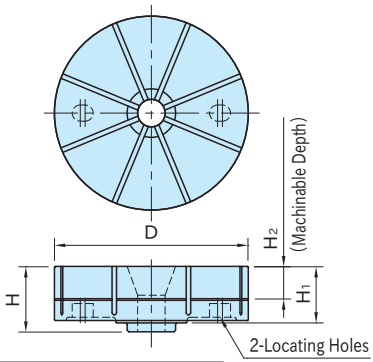
CP127 JAWS FOR INTERNAL FORM HOLDING



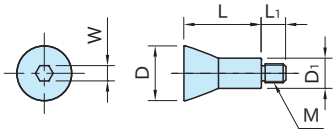
Jaw
A7075 Aluminum Silver

Part Number	D	H1	H2	H	Weight (kg)	Proper CP125 Clamps	Proper CP127-B Screws
CP127-06501	65	25	10	28.5	0.2	CP125-06501	CP127-06501B
CP127-09001	90	30	15	34.5	0.4	CP125-09001	CP127-09001B
CP127-12001	120	35	20	40.5	0.9	CP125-12001	CP127-12001B
CP127-16001	160	40	25	46.5	1.9	CP125-16001	CP127-16001B

Furnished Part

1 pc. of O-ring

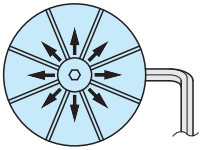
CP127-B TAPERED SCREWS FOR INTERNAL FORM HOLDING



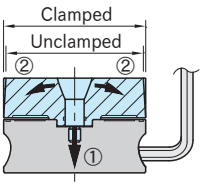
Body
SCM435 Steel Quenched and tempered Electroless nickel plated

Part Number	D	L	M	L1	D1	W	Weight (g)	Proper CP127 Jaws
CP127-06501B	22.5	29	M 8×1.25	10	13.2	6	50	CP127-06501
CP127-09001B	27	35	M10×1.5	11	16	8	80	CP127-09001
CP127-12001B	29	41		13			100	CP127-12001
CP127-16001B	33	47	M12×1.75	14	18	10	150	CP127-16001

Features

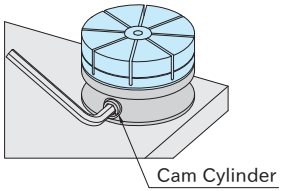


- The tapered screw expands the jaws towards eight directions to hold different irregularly-shaped parts securely.
- 0.15mm clamping stroke of each jaw section is perfect for clamping of lost-wax parts, die-cast parts, extruded parts, solid-drawn parts, prefinished parts, etc.



①When the cam cylinder is tightened, the tapered screw is pulled down.

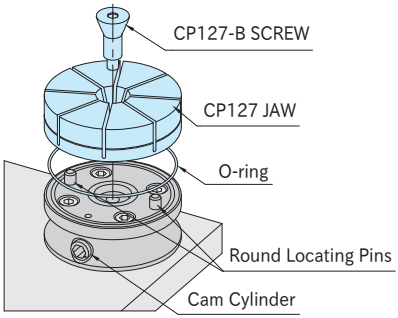
②At the same time the 8 jaw sections expand to clamp the internal form of a part.



How To Use

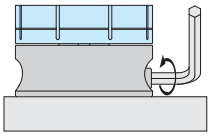
①Jaw Mounting

・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.

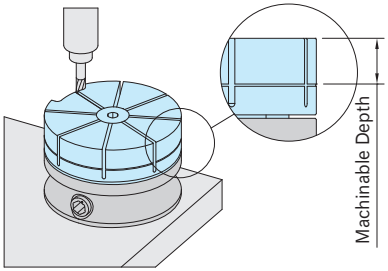


②Jaw Machining

(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.

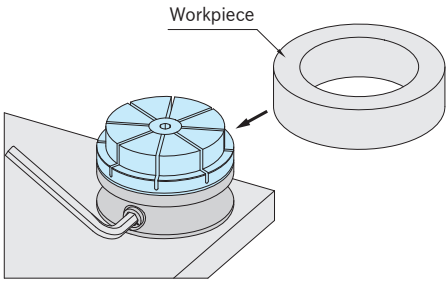


(2-2) Machine the jaw to the contours of a part.
Note: Do not machine the jaw deeper than allowed.

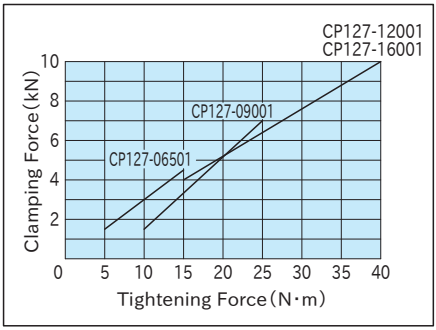


③Workpiece Setting

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



Performance Curve



Notes

Do not actuate clamping without a workpiece to avoid damage and deformation. Tightening with torque greater than the allowable screw torque will lower the durability of the jaw.