

CP124

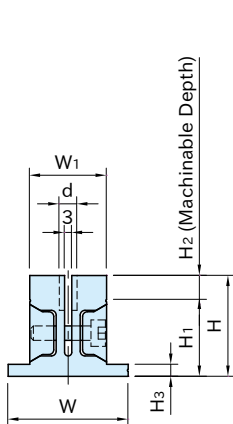
OD HOLDING CLAMPS (Wedge Style/Square)



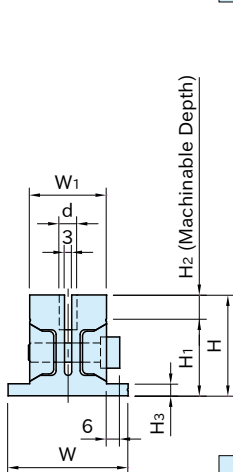
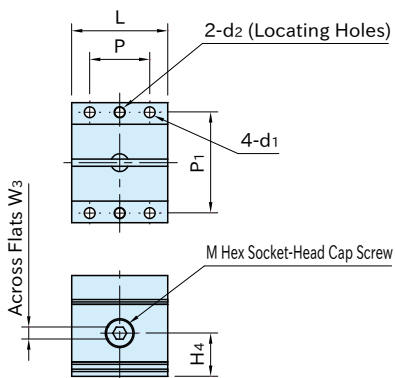
CP124-***01

CP124-***02

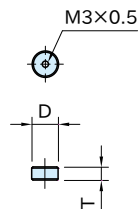
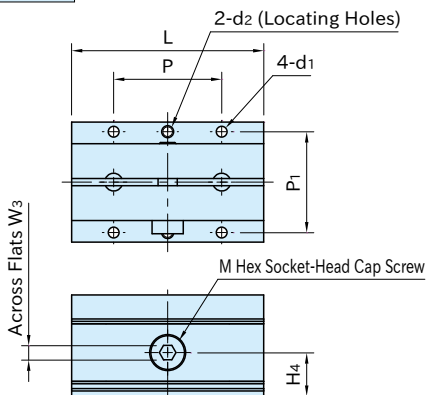
Body	Wedge
A6N01 aluminum Anodized	SCM440 steel Black oxide finished Quenched & tempered



CP124-***01



CP124-***02



Locking Button

Part Number	W ₁	d	L	H	H ₂	W	H ₃	H ₁	d ₂ (H7)	d ₁	P	P ₁	M
CP124-03201	32	7.4	40	42	10	50	5	32	5	4.5	25	42	M 6×1 -25L
CP124-03202			80										M 8×1.25-30L
CP124-05001	50	11.4	50	63	15	72	7	48	6	5.5	30	62	M10×1.5 -40L
CP124-05002			100										M12×1.75-45L

Part Number	W ₃	H ₄	D	T	Clamping Force (kN)	Allowable Screw torque (N·m)	Weight (kg)
CP124-03201	5	18	7	3.5	2.5	7.5	0.22
CP124-03202	6					14	0.42
CP124-05001	8	27	11	5.5	5.5	26	0.62
CP124-05002	10					46	1.29

Technical Information

Locating Repeatability : ±0.08

Supplied With

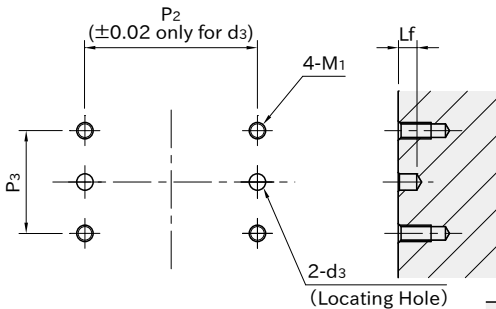
- 1 of locking button for CP124-***01
- 2 of locking button for CP124-***02
- 2 of parallel pin(m6 tolerance)
- φ5×10L for CP124-***01
- φ6×15L for CP124-***02

Feature

- When the clamp screw is tightened, both jaws tilt toward the center to clamp the circumference of the workpiece.
- The clamping stroke is 1 mm.
- Cutting the machinable jaw to the contour of workpiece allows holding different shapes.
- Simple and compact design permits multiple-parts holding arrangement.

How To Use

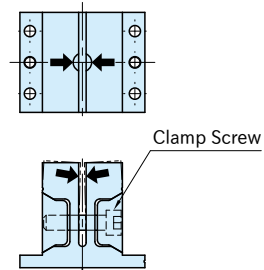
■ Mounting-Hole Dimension



Use the included parallel pin for locating.

Note

- Do not tighten the clamp screw without the workpiece set to prevent damage and deformation.
- Do not machine the jaws beyond the machinable depth



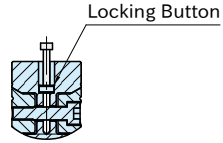
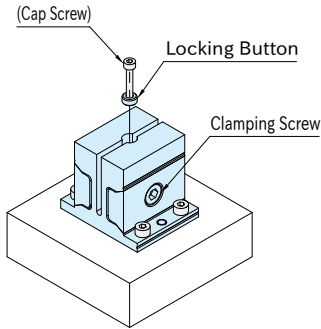
Part Number	d ₃ (H7)	L _f	M ₁	P ₂	P ₃
CP124-03201	5	5	M4×0.7	42	25
CP124-03202					45
CP124-05001	6	8	M5×0.8	62	30
CP124-05002					58

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■ How to Machine Jaw

1. Setting the locking button

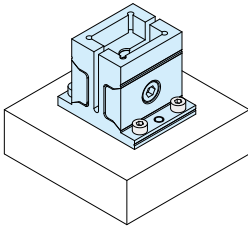
Insert the locking button into the jaw, and then tighten the clamp screw to fasten the locking button.
(Using a cap screw facilitates setting)



Note: The locking button must be inserted onto the bottom.

2. Machining the jaw

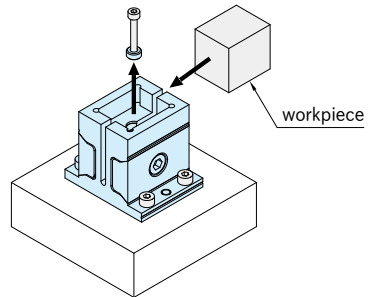
Cut the jaw to the contours of the workpiece.



Note: Do not cut beyond the machinable depth.

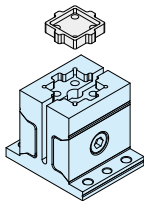
3. Workpiece Loading

Loosen the clamp screw to remove the locking button. Load the workpiece and tighten the clamp screw for clamping.

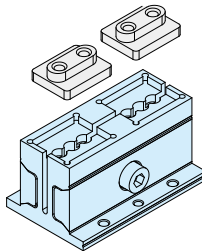


*) Following the above steps for jaw machining, the clearance between the jaw and the workpiece will be 0.5 mm.

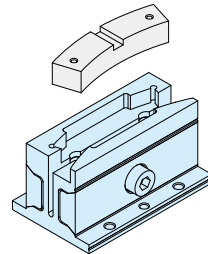
■ Application Example



Single-station mode
on the short-type clamp



Dual-station mode
on the long-type clamp



Single-station mode
on the long-type clamp