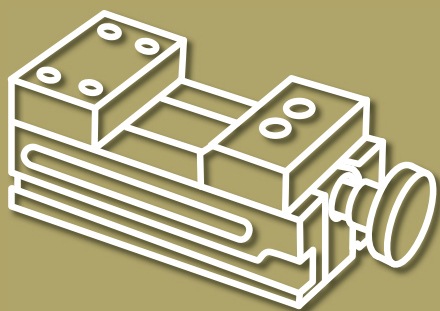
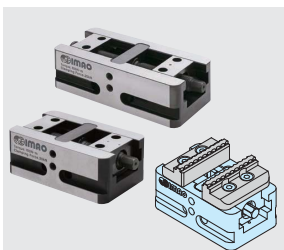
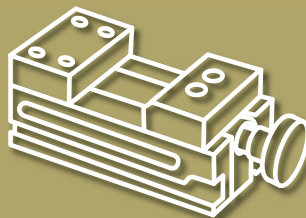


VICES

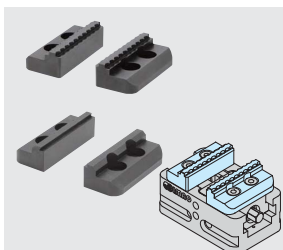


VICES



CENTERING CLAMPS

Part No. CP170-N



JAWS

Part No. CP175

CENTERING CLAMP

Perfect Workholding for
5-axis Machining!

NEW
Short size of
130mm
is newly
available!



IMAO
Torque.100N·m
Clamping Force.20kN

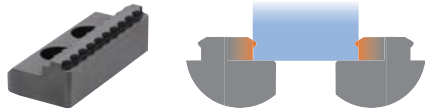
NEW
**Reversible
jaws**
enable clamping
various workpiece
sizes!

Clamping unit for machining full sides of the workpiece
Ideal for 5-axis machining center or rotary table!

CENTERING CLAMP



Serrated Jaw



The jaw has serrated edges on both sides.



Dovetail Jaw



CP170-N

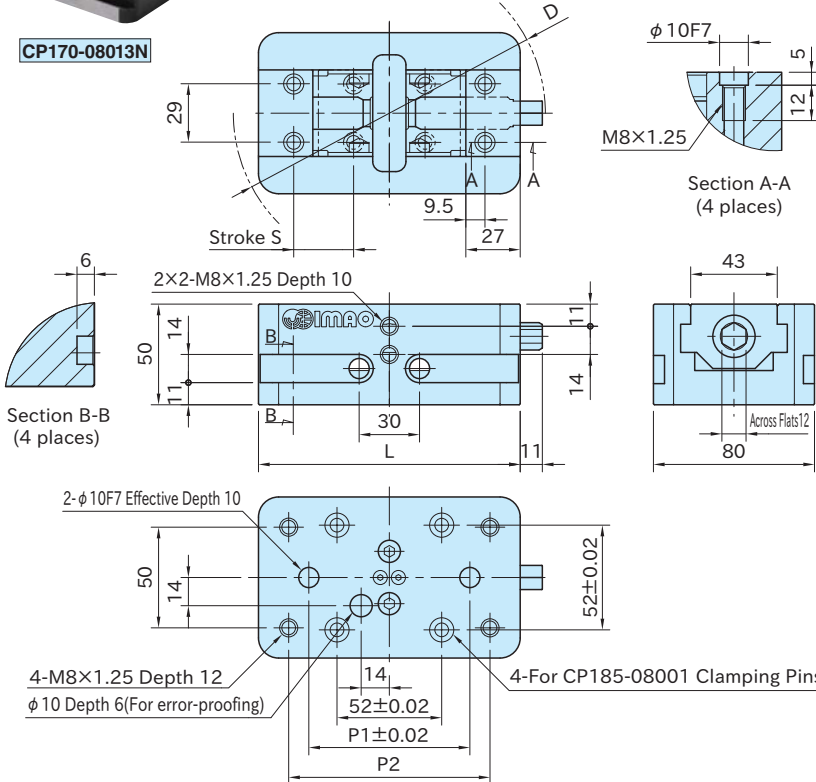
CENTERING CLAMPS



Body	Jaws Bases
SCM440 steel Induction hardened Black oxide finished Precision ground	SCM440 steel Black oxide finished

CP170-08013N

CP170-08017N



Part Number	D	L	P ₁	P ₂	S	Allowable Tightening Torque (Nm)	Weight (kg)
CP170-08013N	160	130	80	100	29.7	100	3.1
CP170-08017N	195	170	120	120	49.7		3.9

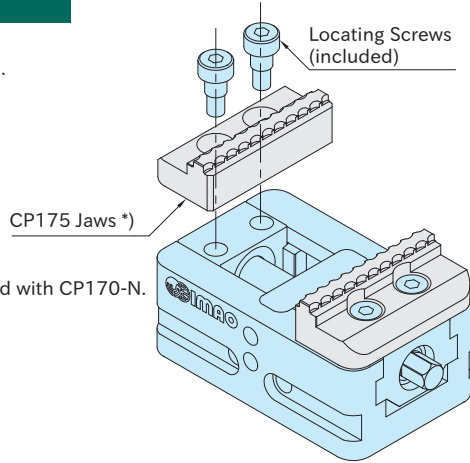
Part Number	Proper Jaws			
	Serrated Jaws		Dovetail Jaws	
	Part Number	Clamping Force (kN)	Part Number	Clamping Force (kN)
CP170-08013N	CP175-08001RS	20	CP175-08001D	20
CP170-08017N				

Feature

Manual compact self-centering vise.
Recommended machining allowance is 0.4mm or more per side of the workpiece.

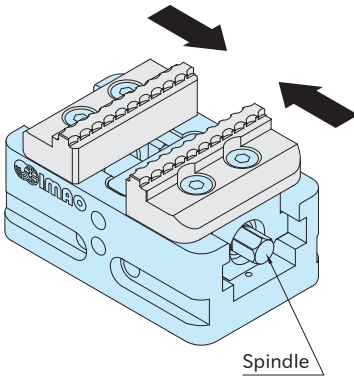
How To Use

- How to Mount Jaws
 - Mount Jaws to the jaw bases of CP170-N.
 - Use included locating screws to fix Jaws.



*) Jaws are not supplied with CP170-N.

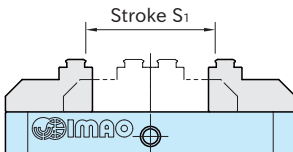
How to Operate



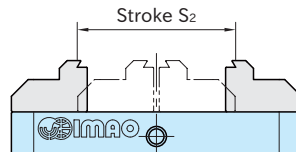
- Both jaws move inward to the center by turning the spindle clockwise.
- Both jaws move outward from the center by turning the spindle counterclockwise.

Stroke

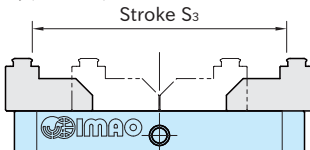
With CP175-08001RS Serrated Jaws



With CP175-08001D Dovetail Jaws



With Reversely (Inside-out) Mounted CP175-08001RS Serrated Jaws



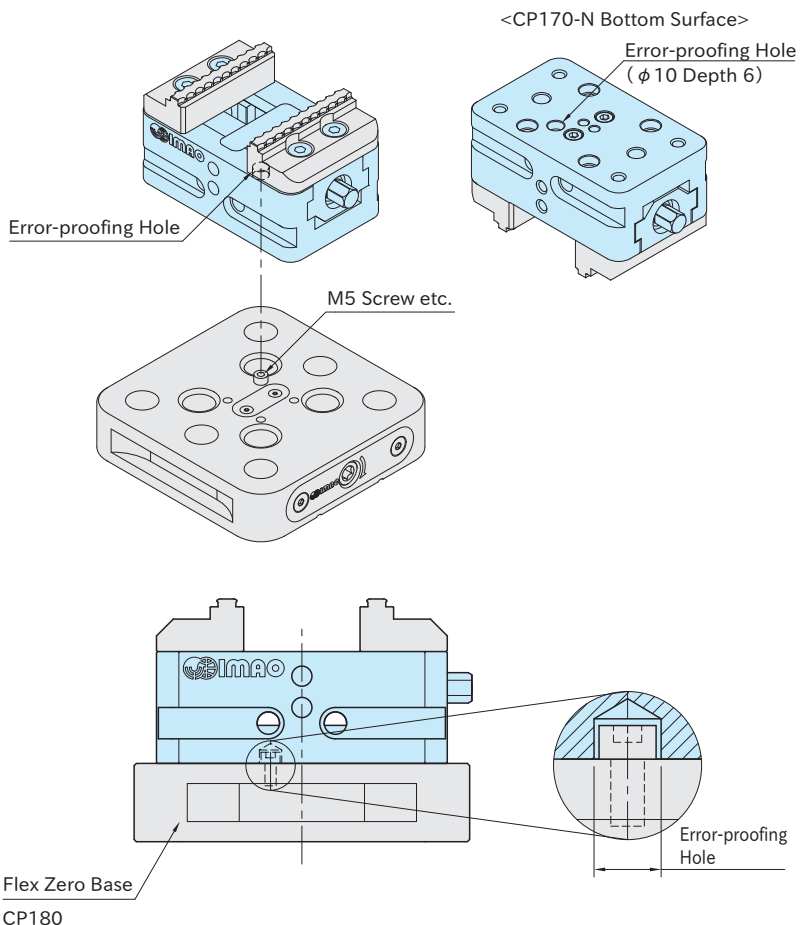
Part Number	S ₁	S ₂	S ₃
CP170-08013N	6 - 58	11.5 - 71	54.5 - 114
CP170-08017N	6 - 98	11.5 - 111	54.5 - 154

*) The maximum rotation diameter is the dimension D in the chart on previous page.

Continuing on Next Page

■ Usage Example of Error-proofing Hole

Prepare a screw etc. on M5x0.8 Depth 12 hole on **CP180** Flex Zero Base to prevent mounting **CP170-N** Centering Clamp in wrong direction.



Supplied With

4 of Locating Screw for jaw mounting.

Related Product

- **CP175** JAWS
- **CP180** FLEX ZERO BASES
- **CP185** CLAMPING PINS

CP175

JAWS

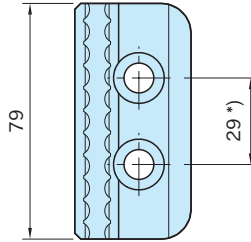


CP175-08001RS (Serrated)

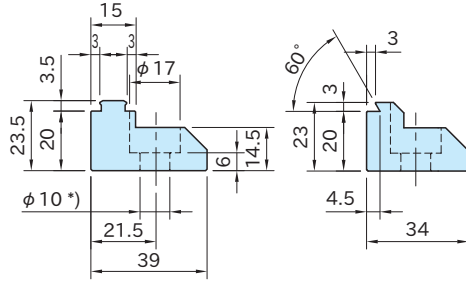


CP175-08001D (Dovetail)

Part Number	Type	Weight (g)
CP175-08001RS	Serrated	710
CP175-08001D	Dovetail	600



Body
SCM440 steel
Quenched & tempered
Black oxide finished



CP175-08001RS

(Serrated)(2 pcs. as a set)

CP175-08001D

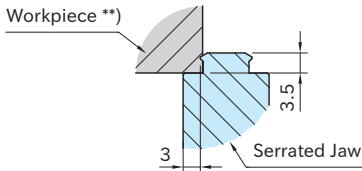
(Dovetail)(2 pcs. as a set)

How To Use

Use as jaws of CP170-N Centering Clamps.

Serrated Jaw

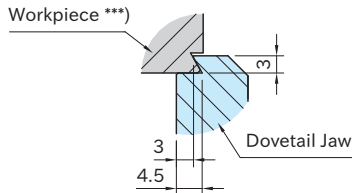
The serrated tips bite into workpiece and clamp powerfully.



** Workpiece hardness should be HRC38 or less for use of serrated jaw.

Dovetail Jaw

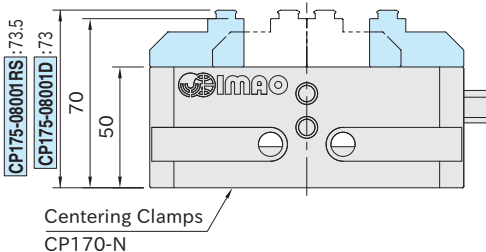
Dovetail jaw holds workpiece at two surfaces and provides positive clamping.



*** Preparation of dovetail groove on workpieces is required.

Technical Information

Dimensions of Centering Clamps with Jaws



Dovetail groove preparation

Machine dovetail grooves on workpiece to the specifications below.

