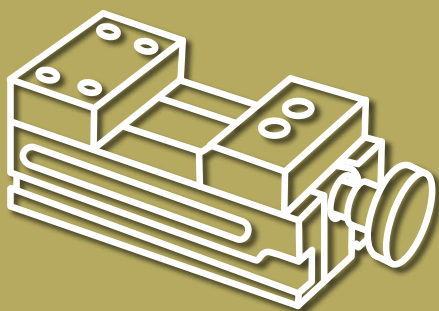
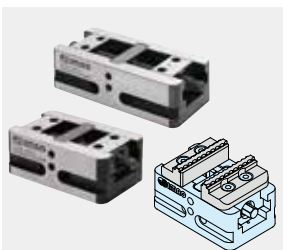
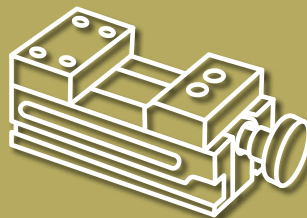


# VICES

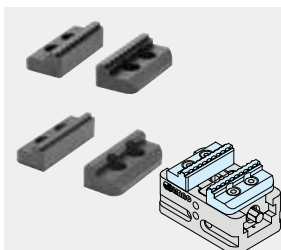


# VICES



CENTERING CLAMPS

Part No. CP170-N



JAWS

Part No. CP175

CENTERING CLAMP

Perfect Workholding for 5-axis Machining!

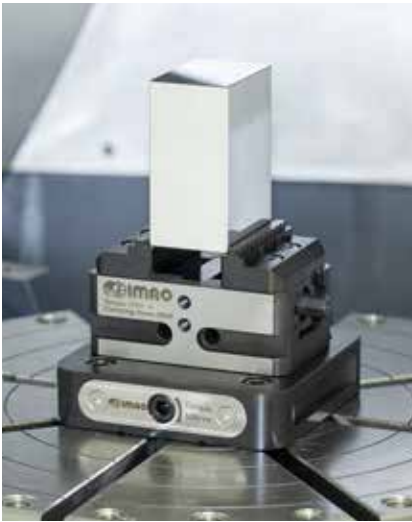
**NEW**  
Short size of **130mm** is newly available!



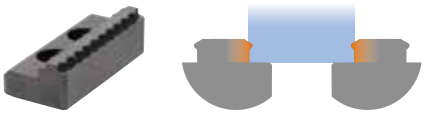
**NEW**  
**Reversible jaws**  
enable clamping various workpiece sizes!

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

CENTERING CLAMP



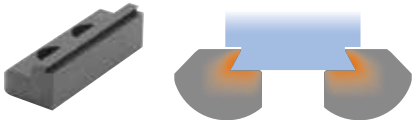
Serrated Jaw



The jaw has serrated edges on both sides.



Dovetail Jaw



# CP170-N

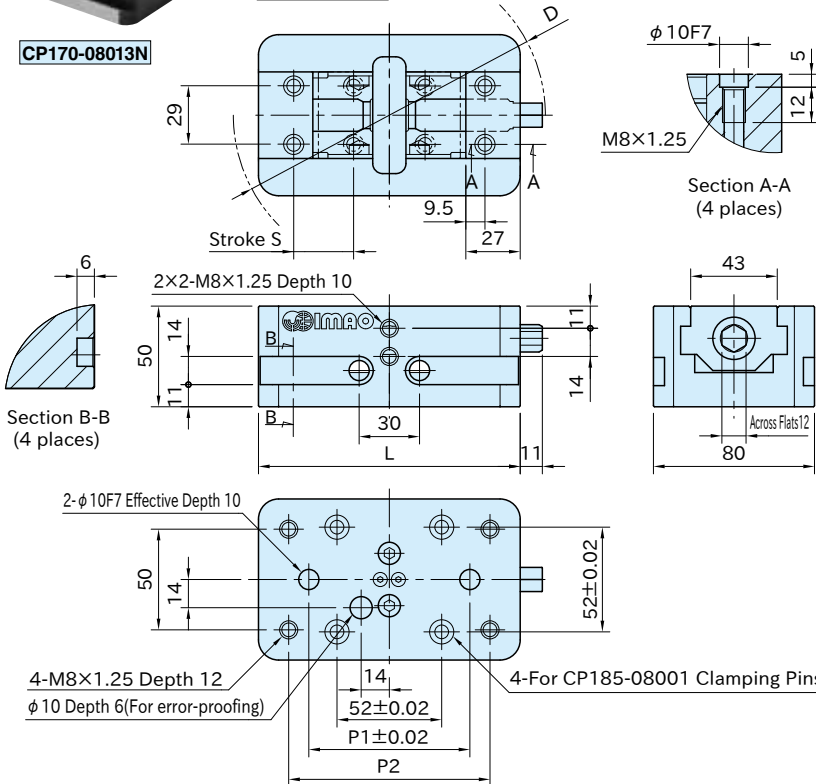
# CENTERING CLAMPS



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 <sub>1</sub>	P <sub>2</sub>	S	Allowable Tightening Torque (Nm)	Weight (kg)
<b>CP170-08013N</b>	160	130	80	100	29.7	100	3.1
<b>CP170-08017N</b>	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)
<b>CP170-08013N</b>	<b>CP175-08001RS</b>	20	<b>CP175-08001D</b>	20
<b>CP170-08017N</b>				

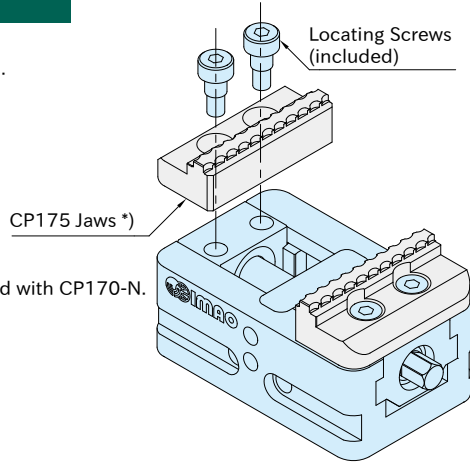
## Feature

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

## How To Use

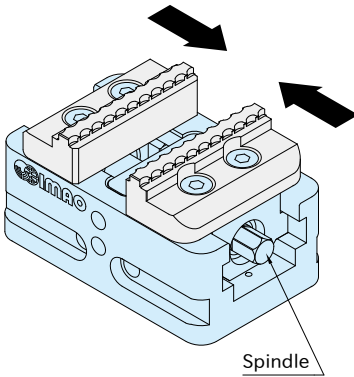
### How to Mount Jaws

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



\*) Jaws are not supplied with CP170-N.

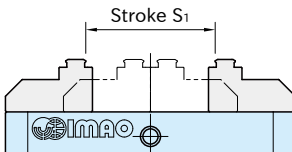
### How to Operate



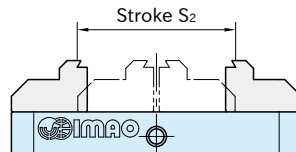
- Both jaws move inward to the center by turning the spindle clockwise.
- Both jaws move outward from the center by turning the spindle counterclockwise.

### Stroke

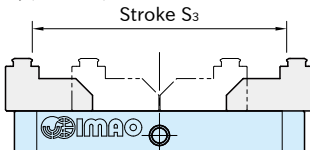
With CP175-08001RS Serrated Jaws



With CP175-08001D Dovetail Jaws



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



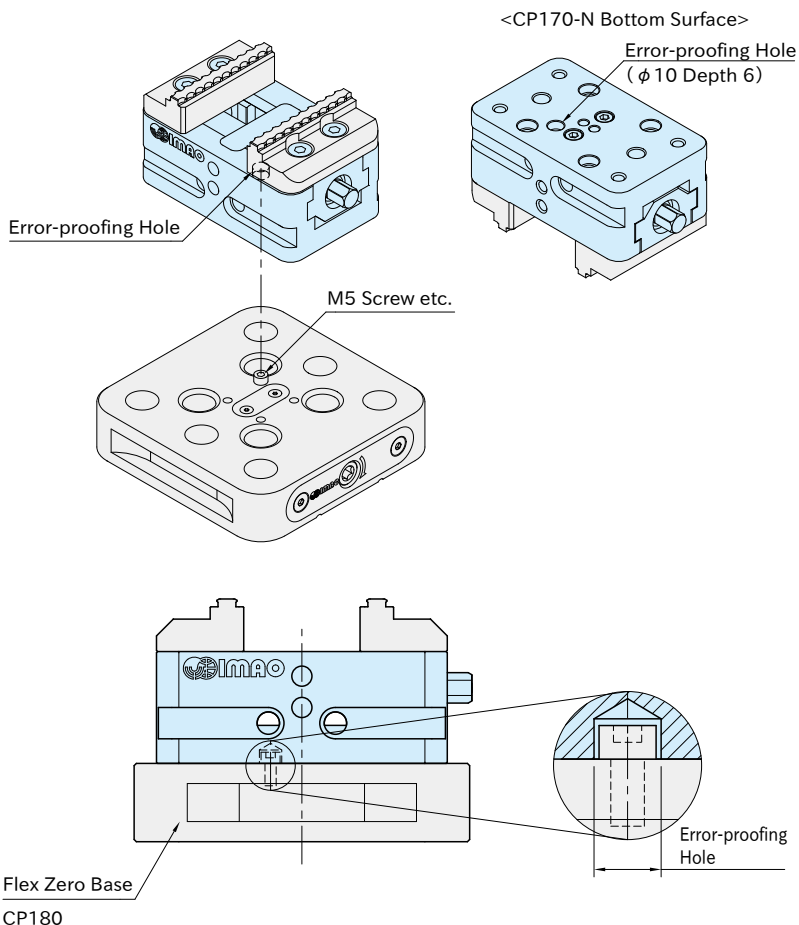
Part Number	S <sub>1</sub>	S <sub>2</sub>	S <sub>3</sub>
CP170-08013N	6 - 58	11.5 - 71	54.5 - 114
CP170-08017N	6 - 98	11.5 - 111	54.5 - 154

\*) 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

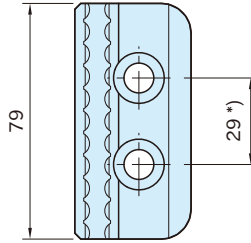


CP175-08001RS (Serrated)

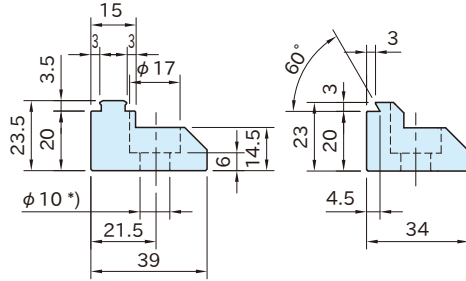


CP175-08001D (Dovetail)

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

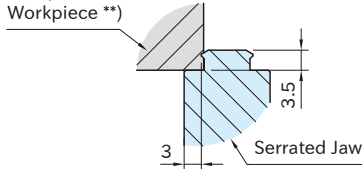
(Dovetail)(2 pcs. as a set)

How To Use

Use as jaws of CP170-N Centering Clamps.

Serrated Jaw

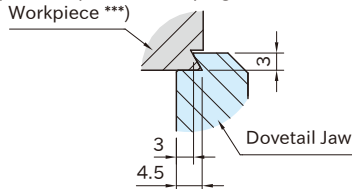
The serrated tips bite into workpiece and clamp powerfully.



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

Dovetail Jaw

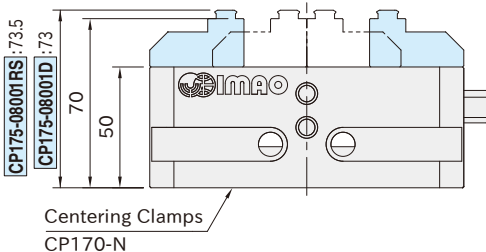
Dovetail jaw holds workpiece at two surfaces and provides positive clamping.



\*\*\* Preparation of dovetail groove on workpieces is required. Usable as edge clamping jaws without dovetail preparation.

Technical Information

Dimensions of Centering Clamps with Jaws



Dovetail groove preparation

Machine dovetail grooves on workpiece to the specifications below.

