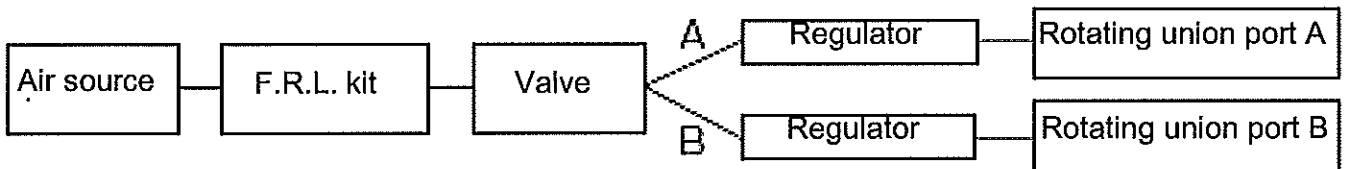


3. Attach VIDA CLAMP to a machine tool. (For attaching VIDA CLAMP, see Basic Attachment on page 15.)

### **Pneumatic piping**

Attach the rotating union securely to the chuck. (For using the rotating union, see page 7.)

Carry out piping with the precision regulator installed in the circuit to make the air pressure variable.



### **Setting the jaw finishing pressure and loader clearance**

For O.D. clamping, finish the jaws by gradually changing the difference between the air source and jaw finishing pressures in units of 0.05 MPa.

For I.D. clamping, gradually change the jaw finishing pressure in units of 0.05 MPa.

Example: For O.D. clamping, use 0.4 MPa (port B) as the standard setting.

Example: For I.D. clamping, use 0.1 MPa (port B) as the standard setting.

### **Finish the jaws.**

Considering the loader clearance, initially finish the jaws so that the clamping force increases as much as possible. If the clamping force is too strong, refinish the jaws to decrease the clamping force.