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**Back pressure (reduction force)**

In step 5, the air is released from rear chambers A and B. Subsequently, pressure is applied to these chambers at pressure lower than the jaw finishing pressure depending on the situation. (The jaws' clamping force decreases as this pressure becomes closer to the jaw finishing pressure.) This operation provides a solution for excessive clamping force without requiring remachining the workpiece at lower jaw finishing pressure.

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**Lead-in (increased force)**

In Step 4, the air is released from Rear Chambers A and B. At this time, air is oppositely supplied at a proper pressure into Front Chambers A and B. (Higher pressure becomes an increased force.) This operation shall be regarded as counter-measures against a weak clamping force.