

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 A) as the standard setting.

Example: For I.D. clamping, use 0.1 MPa (port A) 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.