ML311055 ADJUSTMENT PROCEDURES

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***** CAUTION MUST BE USED TO PREVENT ADJUSTMENT SCREW FROM EJECTING, WHICH MAY CAUSE INJURY ****

This assumes the customer mounting bracket has Ø 0.31 inch clearance holes for the M6 jaw mounting screws. This would give about 9 degrees play in the jaw when loosely placed onto the jaws.

Steps to properly adjust ML311055 for maximum grip force

1. Remove all air pressure prior to proceeding.
2. Remove the port plug in the back of the brass cap.
3. Add a 1/8-28 BSPP long threaded adjustment piece to the back of the brass cap. This will not seal the unit and air may pass through. **NOT INTENDED FOR PRODUCTION!!** Roughly 0.440 inch depth would get through the plug. (See Figure 1.)
4. Do not engage the piston yet with the adjustment tooling.
5. Install the jaw tooling, but leave it loose; do not tighten it yet.
6. Apply roughly 80 psi close pressure. This will move the piston fully near the cap.
7. Rotate the adjustment tooling until it engages the piston, tooling will stop rotating.
8. Remove the air pressure.
9. Slowly rotate the adjustment tooling about four rotations.
10. Apply about 80 psi to close the gripper to make sure piston is bottomed out on the adjustment tooling.
11. Lightly squeeze the jaw tooling together and tighten the fasteners. The jaw tooling should make contact with each other. If not, back off on the adjustment tooling.
12. Remove the air pressure.
13. Remove the adjustment tooling.
14. Reinstall the port plug.
15. Test the unit.

If there's not enough grip force, repeat procedure but use less piston engagement. This procedure depends on how much clearance is between the tooling mounting holes and the fasteners. Adjustment may be needed depending on the amount of clearance.

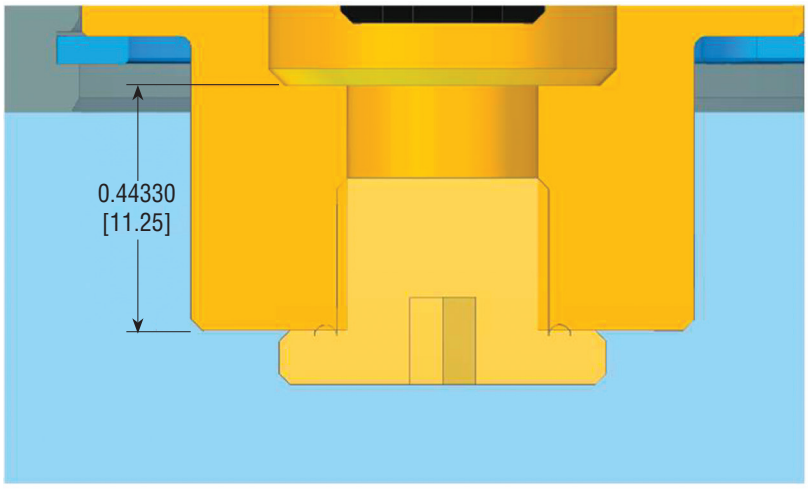

Figure 1