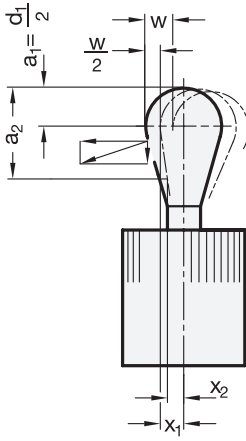


Technical and assembly instructions



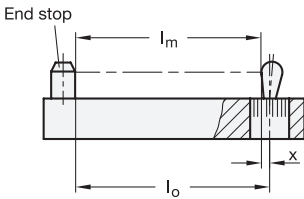
- w = Movement of pin
 - F = Side thrust in N
 - Initial thrust = F_0
 - End thrust = $1,1 \times F_0$
 - $a_2 - a_1$ = Clamping range for workpiece
 - x = Distance centre line – Thrust point at $\frac{W}{2}$
 - x_1 for highest thrust point (a_1)
 - x_2 for lowest thrust point (a_2)
 - l_0 = Distance end stop – Bore of side thrust bush pin
 - l_0 = $l_m + x$
 - l_m = average length of workpiece $\frac{l_{max} + l_{min.}}{2}$
- For contact points (workpiece height) between a_1 and a_2 a value for x has to be used lying between x_1 and x_2 (interpolation).

3.1

3.2

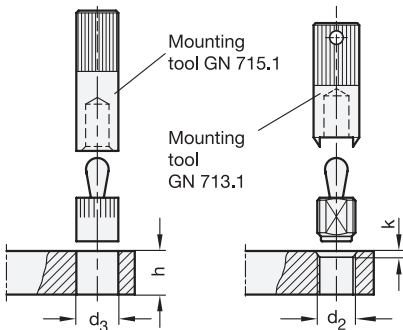
3.3

3.4



By observing the above values the full movement of the side thrust pin will be available to cover the tolerance of the workpiece.

3.5

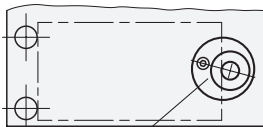


For inserting the side thrust pins the use of a mounting tool GN 715.1 or GN 713.1 is recommended.

3.6

3.7

3.8



Eccentric bushing GN 715.2

Eccentric bushings GN 715.2 are a tooling accessory for GN 714 / GN 715.

They enable a precise optimum setting of side thrust pins. This allows an adjustment to l_0 to accommodate for instance a larger tolerance range on a workpiece.

3.9

