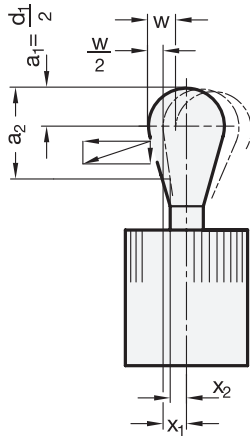
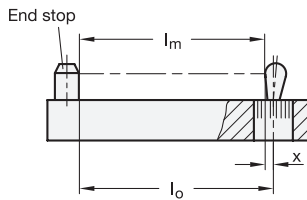


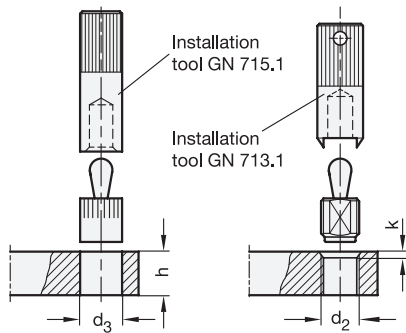
Technical and assembly instructions



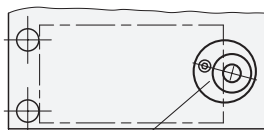
- w = Movement of thrust pin
 - F = Side thrust force in N / lbf
Initial thrust = F_0
End thrust = $1.1 \times F_0$
 - $a_2 - a_1$ = Clamping range for workpiece
 - x = Distance center line – Thrust point
at $\frac{w}{2}$
 x_1 for highest thrust point (a_1)
 x_2 for lowest thrust point (a_2)
 - l_0 = Distance end stop – Bore of side thrust pin
 - l_0 = $l_m + x$
 l_m = average length of workpiece $\frac{l_{max} + l_{min.}}{2}$
- For thrust points (workpiece heights) between a_1 and a_2 a value for x lying between x_1 and x_2 has to be used (interpolation).



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



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



Eccentric bushing GN 715.2

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

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