

Presetting & inspection

Make efficient use of machine time.

Machine can be used either for active machining or for non-productive setting-up operations on an idle machine.

You can optimise machine capacity by presetting away from the machine in a presetting station, while the machine is actively working on another workpiece.

So – preset away from the machine, lift in the preset package, secure it with a few simple manual operations, press the start button and the wire EDM machine is working again – One Minute Set-up.

System 3R's presetting stations are constructed on a modular system, where the customer chooses a suitable packet of prepared "measuring stones", for which the customer chooses the necessary chuck/reference elements in order to match the installation on the wire EDM machine table, as well as a pneumatic control unit if required.



Pneumatic chuck for Macro
3R-602.10-1

Manual chuck for Macro
3R-602.27

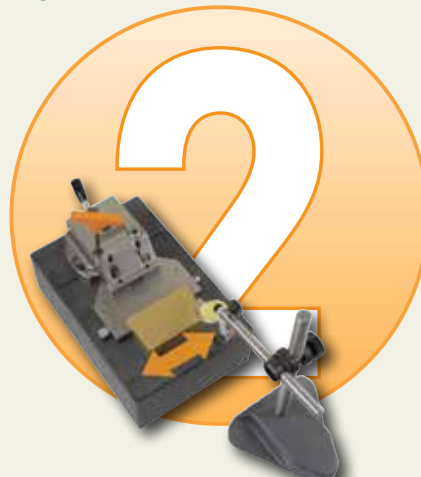
Reference element
3R-200.1J-U

Pneumatic chuck for MacroTwin
3R-602.12-1

Presetting stone
3R-228U

Presetting station
3R-228.1

Actuator
3R-611.4



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Presetting stone, 3R-228J

Stone with three ground faces, a reference element and a clearance stone. Together with a surface plate and a dial indicator, 3R-228J is an excellent presetting tool for a modest outlay.

- Dimensions 150x110x80 mm
- Weight 5.4 kg.



Presetting stone, 3R-228U

Mounting stone with bushings and holes for mounting chuck/reference elements. Use together with existing measuring machine or surface plate and a dial indicator.

- Dimensions 300x200x100 mm.



Presetting station, 3R-228.1

Surface plate with reference stops, a mounting stone with bushings and holes for mounting a chuck/reference element and through holes for mounting on the surface plate, and a check stone. A dial indicator is required.

- Dimensions 500x300 mm.



Presetting kit, Econo, 3R-228E & 3R-228EI

Mounting stone with bushings and holes for mounting chuck/reference elements. Use together with existing measuring machine or surface plate.

Note: 3R-228EI delivers with dial indicator measuring inch.

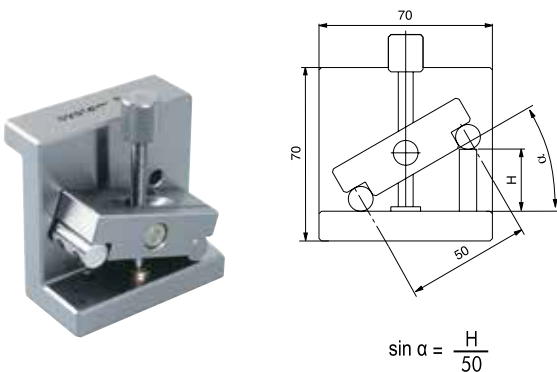
- Dimensions 300x200x100 mm
- Presetting stone
- Measuring stand
- Dial indicator (measures in mm).



Sine ruler, 3R-216

With magnetic attachments for setting angles on swivelling elements. Angles are set with gauge blocks.

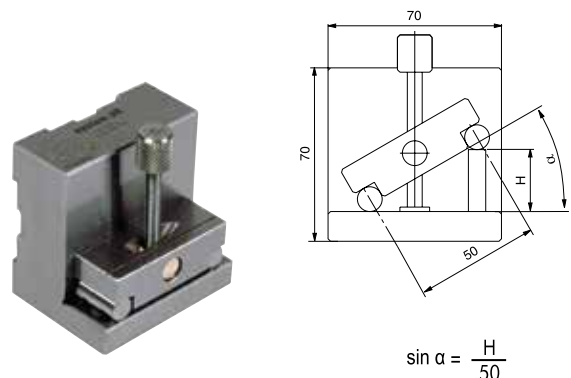
- Measuring length 50 mm
- Weight 1.2 kg.



Sine ruler, Macro, 3R-216.6

For setting angles on swivelling elements. Angles are set with gauge blocks.

- Measuring length 50 mm
- Weight 1.4 kg.

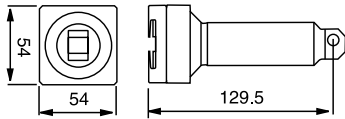


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Master, 3R-606.2

Master for determining the position of vertical Macro chucks. Cylinder ground to the Macro references. Supplied with engraved dimensions in the X-, Y- and Z-directions.

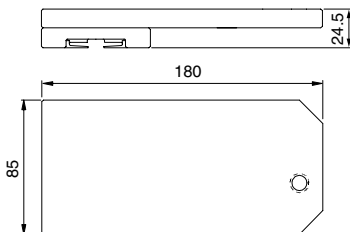
- Drawbar not included.



Master, 3R-206.10

Master for horizontal Macro chucks. One long side ground to the Macro references. Supplied with engraved dimensions in the X-, Y- and Z-directions.

- Drawbar not included.
- For automatic changing, 3R-WP1 must be added.



Wire alignment unit, 3R-220.3

Unit with double-insulated reference contacts for wire alignment.

- Tightening torque 7 Nm
- For Mitsubishi machines
- Four wires in the cable
- Weight 2.2 kg.

