

System 3R

Instruction for MacroMagnum Pallet

3R-681.51-SA

General Description

Unhardened pallet with hardened references and hole markings for eight clearance holes. The pallet can be mounted directly onto steel or other fixture.

- Adapted for automatic changing
- Solid and semi hardened
- Weight: 4.5 kg (9.9 lbs)

Parts included

Description	Article no.	Quantity
Pallet, one pc.	3R-681.51-SA	1
Quality certificate	C-00531	1
Instruction (this document)	I-500	1

Table 1

Mounting

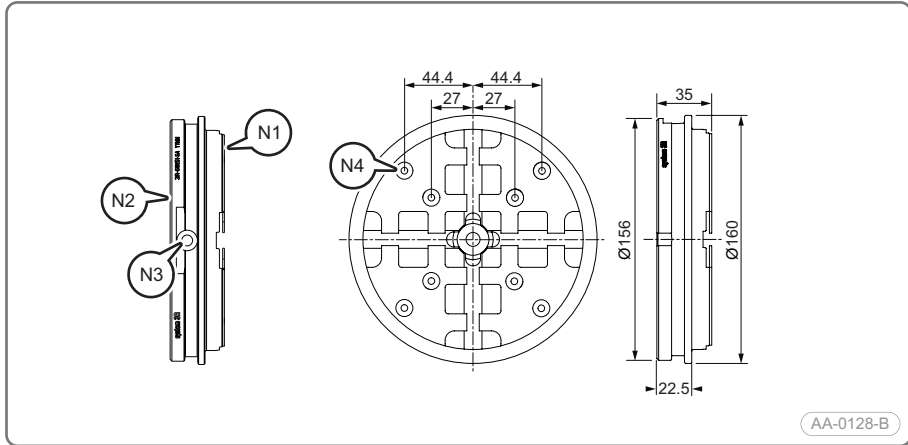


Fig. 1

NOTICE! For the best repetition accuracy the flatness of the mounting surface should be within 0.01 mm.

NOTICE! Add anticorrosive additive when water based cutting liquid is being used.

N1. To achieve top accuracy in repetition and in combination with air sensing, flatness deviation should be within 0.002 mm indicated on MacroMagnum reference element after assembly.

N2. Mount the workpiece from the top side, don't drill deeper than 21 mm within the $\varnothing 156$ mm.

N3. Bore for ID carrier: 3R-863.01

N4. Counterbore $\varnothing 11$ (8x) to mark dedicated through holes for M6 screws.

- In EDM applications, apply antirust oil on the contact surfaces.

Maintenance

When not in use

Wipe and protect with anti-rust oil.