

System 3A



Folio: 210mm*285mm 1/16
 Sheets: 1.25 2 inset
 Revision: 2013 first printing
 Printing: 0-5000
 Code: JZH-Z-3A7-5000

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System 3A

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A-ONE 



3A 快速定位夹具系统
3A RAPID POSITIONING JIG SYSTEM

专业 可靠 耐用 精密
professional reliable durable precision

公司简介

深圳市精钻精密五金工具有限公司成立于 2000 年，专业生产 3A 快速定位夹具系列等产品、零点快速定位夹持系统、球锁快速装夹具系统、数控机床夹头、导套、工装夹具。深圳公司建筑面积 3000 平方米。江西的工业园区 26000 平方米，厂区面积 18000 平方米。

公司拥有从德国、瑞士、美国、日本引进的先进生产设备。如德国 JUNG 成型磨床、德国 ELB 高精度平面磨床、美国 MOORE 坐标磨床、瑞士内外圆磨床、螺纹磨床、日本 OKUMA 加工中心、日本津上数控车床。公司建立了 $20 \pm 0.5^{\circ}\text{C}$ 恒温精磨房及高精度恒温计量中心，引进德国 ZEISS 三坐标测量机、NIKON 投影仪、ZEISS 工具显微镜、TESA 测高仪等高精度的检测设备。公司产品凭借品质稳定、性价比高，得到海内外客户的高度肯定。

公司全面推行 ISO9001 质量管理体系，为生产高品质产品提供了强有力的保证。

Company profile

Shenzhen Jingzuan Precision Hardware & Tools Co., Ltd. was established in 2000 and is dedicated to manufacture 3A fast positioning fixture system, zero-point fast positioning clamping system, ball lock fast-installation fixture system, numerical control machine clamping chuck, guide sleeve, and fixture so on. Shenzhen company covers an area of 3,000 square meters. Jiangxi Industrial Park covers an area of 26,000 square meters, with the factory area of 18,000 square meters.

The company has the advanced production facility introduced from Germany, Switzerland, the USA and Japan, such as JUNG form grinding machine and ELB high-precision surface grinding machine of Germany, MOORE jig grinding machine of USA, internal and external grinding machine and thread grinding machine of Switzerland, and OKUMA machining center and TSUGAMI numerical control machine of Japan. The company established constant-temperature grinding room of $20 \pm 0.5^{\circ}\text{C}$ and high-precision constant temperature measuring center, and introduced high-precision measuring equipment, such as German ZEISS coordinate measuring machine, ZEISS tool microscope and TESA MICRO-HITE altimeter. The stable quality and high cost performance ratio are highly appreciated by domestic and overseas customers.

The fully implemented ISO 9001 quality management system is a great asset to high-quality products of the company.

- 3A 快速定位夹具系统使用简单，将柔性 and 刚性完美结合。通过客户长期使用，见证了重复定位 $2\mu\text{m}$ 精度。
- 标准化的接口—实现铣削、钻削、车削、磨削、电火花成型、线切割机床以及测量和预调台高效转换，确保加工品质，提高生产效率。



- 3A fast positioning fixture system is easy to use and makes perfect combination of flexibility and rigidity. Customers witnessed the resetting of the precision of $2\mu\text{m}$ after the long-term use. So simple and reliable!
- Standardized interfaces – highly efficient conversion among the milling, drilling, turning, grinding, EDM shaping, linear cutting machine, measuring and presetting station, which can ensure machining quality and improve the production efficiency.





3A 快速定位夹具系统
3A RAPID POSITIONING JIG SYSTEM

Suitable for all kinds of processing
适用于各种加工

专业 可靠 耐用 精密
professional reliable durable precision



快 Fast

秒速装夹，快速的装夹方式取代传统的人工锁紧装夹，大量减少人工作业量及时间。

Clamping in seconds. the way of fast clamp instead of traditional manual lock clamp greatly reduce manual work and save time.

省 Save

省去加工中的校正动作。适合多样化及特殊工件加工。实现机外随意预调及检测。

Save alignment of processing suitable for variety and special workpiece machining achieve free preset and detection on outside.

准 Precision

唯一标准化接口，精确的重复定位。
Unique standard interface, precise repeatability.



经过无数次长时间使用证明品质令人满意！
After countless long use to prove quality is satisfactory!

Accuracy, we can do it.
精准，我们能做到



完整的、一流的生产加工设备、专职的技术人员及优秀的生产工艺管控，保证了产品的交货期及配合客户应急的快速生产。

Complete, first-class processing equipment, professional technician and excellent manufacturing technique control, to ensure the product delivery and coordinate with emergency fasten manufacture as customer request.

- ① CNC 精加工 CNC precision machining
- ② CNC 精加工 CNC precision machining
- ③ CNC 精加工 CNC precision machining
- ④ CNC 车床 CNC lathe
- ⑤ JUNG 精磨车间 JUNG surface grinding machine
- ⑥ JUNG 精磨加工 JUNG surface grinding machining
- ⑦ MOORE 坐标磨车间 MOORE coordinate grinding





德国蔡司三坐标检测仪 ZEISS CONTURA
ZEISS coordinate measuring machine



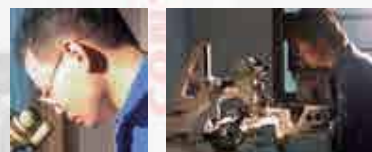
VAST 测头
VAST probe



德国蔡司工具显微镜
ZEISS tool microscope



NIKON V-16A 投影仪
NIKON V-16A projector



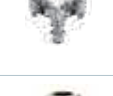
万能工具显微镜
ZEISS universal tool-measuring microscope

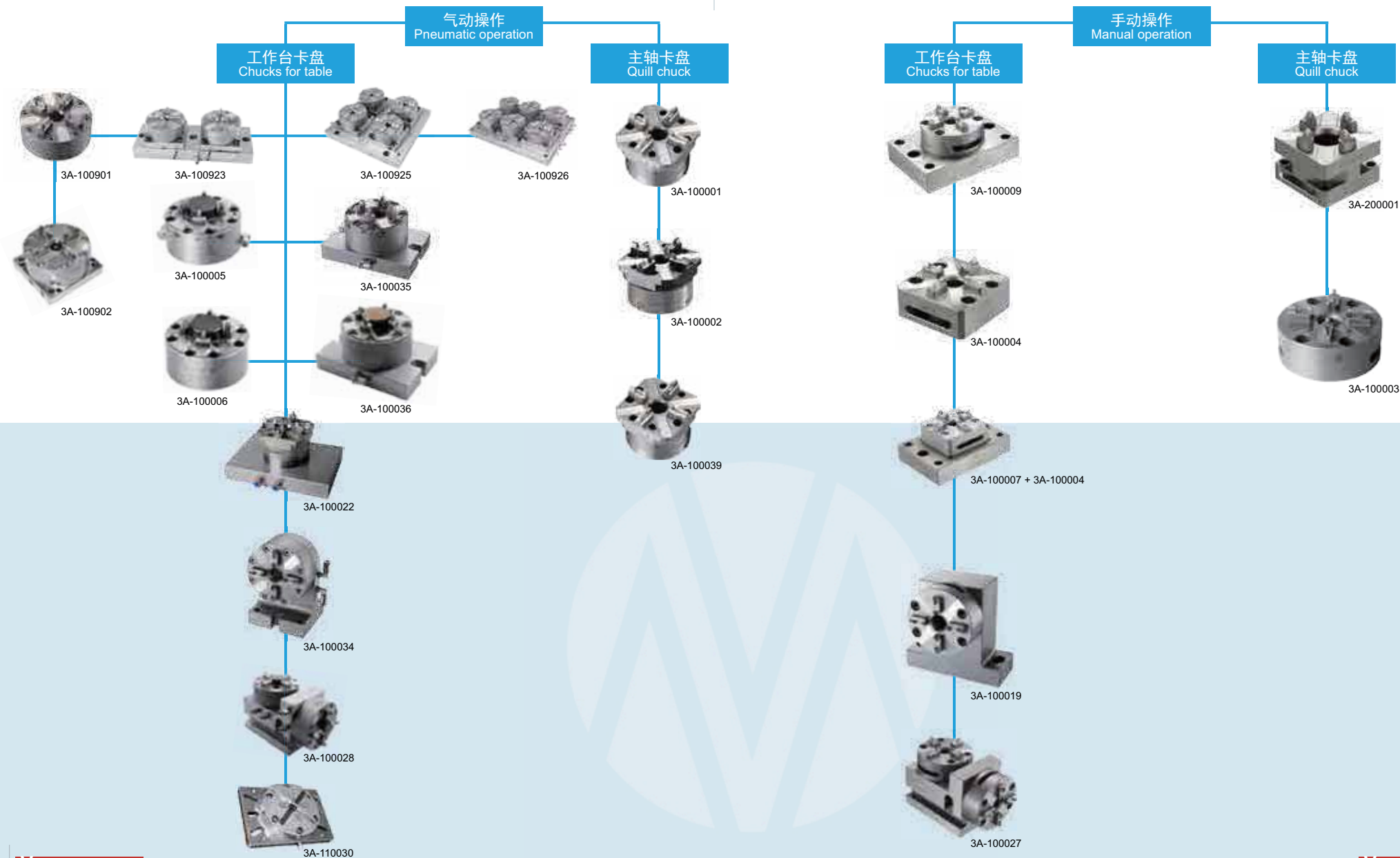


瑞士 TESA 测高仪 规格: 0~600
TESA MICRO-HITE altimeter Version:0-600



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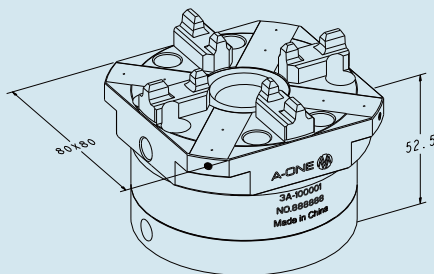
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3A-100001 80 型气动卡盘
Rapid-action chuck automatic

规格 钢, 硬质
夹紧力 4000N
连接 用两条气流管路从背面
操作 自动按钮操作
应用 工作台或主轴

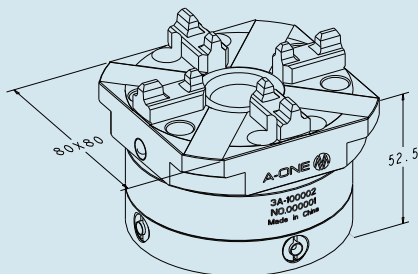
Version Steel, hardened
Clamping 4000N
Connections At the rear with two lines
Operation Automatic button operation
Application Used for working table or spindle



3A-100002 80 型气动卡盘
Rapid-action chuck automatic

规格 钢, 硬质
夹紧力 4000N
连接 侧面气枪操作或接气管
操作 外置气动阀
应用 主轴或工作台、可用于车床

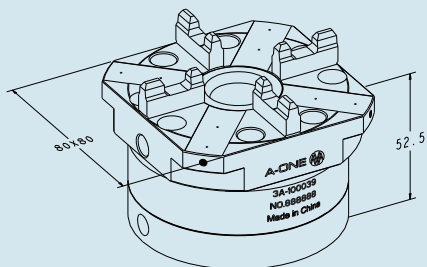
Version Steel, hardened
Clamping 4000N
Connections The side air gun operation or trachea
Operation Switch locates outside
Application On the machine tool spindle, working table or lathe



3A-100039 自动卡盘
Automatic chuck

规格 标准型。夹紧力最大至 2500N
连接 在背面
应用 用于有自动电极交换装置的电火花成型机床、自动装料的机床和生产线

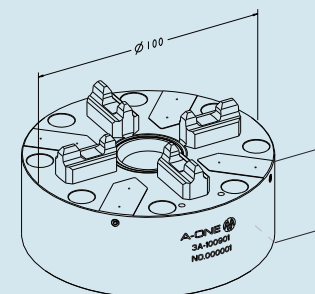
Version Standard type. Clamping power up to 2500N
Connections On back
Application EDM sinking machines with automatic electrode change, machine tools with automatic loading, production lines



3A-100901 100 型气动卡盘 (不含底板)
ITS chuck 100 p 102x102 (without pallet)

规格 钢, 硬质
夹紧力 10000N
连接 用两条气流管路从背面
操作 气阀
应用 用于客户自行设计的夹具

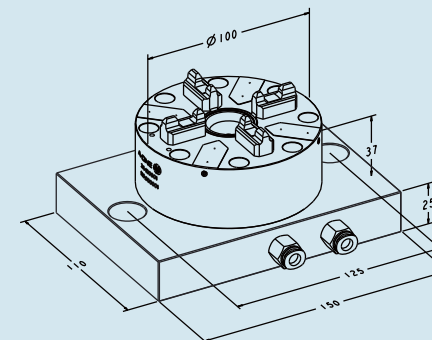
Version Steel, hardened
Clamping 10000N
Connections At the rear with two lines
Operation Air valves
Application Can be used with customized tools



3A-100902 100 型单中心气动卡盘 (含底板)
ITS chuck 100 P (with plate)

规格 钢, 硬质
夹紧力 10000N
操作 气阀
应用 可装夹电极夹头, 强力定位片承载的托板

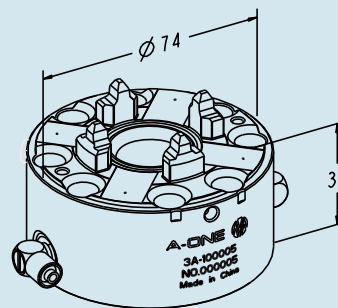
Version Steel, hardened
Clamping 10000N
Operation Air valves
Application Mounted on the electrode holder, power position of bearing plate



3A-100005 50 型卡盘
ITS Chuck 50 Inox

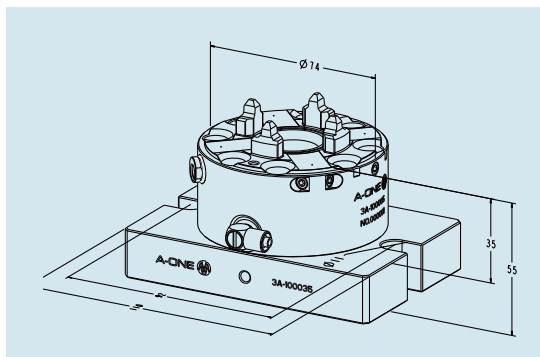
规格 系统尺寸 50, 不锈钢, 防腐蚀
夹紧力 2800N
连接 4-M6 从背面或 8 个 M5 螺钉从正面
应用 可用于客户设计的夹具
注意 自动操作、气路从侧面或底部

Version System size 50, stainless steel, corrosion-resistant
Clamping 2800N
Connections 4xM6 from bottom side or 8xM5 from front side
Application Can be used with customized tools
Note Automatically, on the side or at the bottom



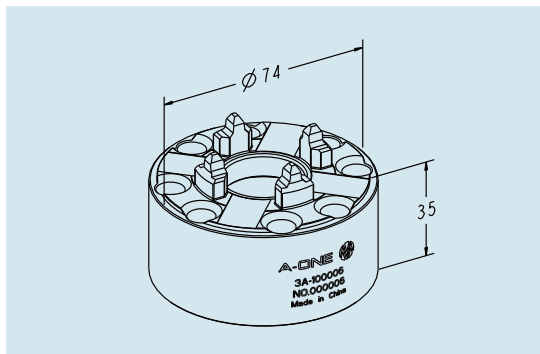
3A-100035 50 型卡盘带底板
ITS Chuck 50 Inox with base plate

规格	系统尺寸 50, 不锈钢, 防腐蚀, 带底板
夹紧力	2800N
连接	4-M6 从背面或 8 个 M5 螺钉从正面
应用	可用于客户设计的夹具
注意	自动操作, 气路从侧面或底部
Version	System size 50, stainless steel, corrosion-resistant, with plate
Clamping	2800N
Connections	4×M6 from bottom side or 8×M5 front side
Application	Can be used with customized tools
Note	Automatically, on the side or at the bottom



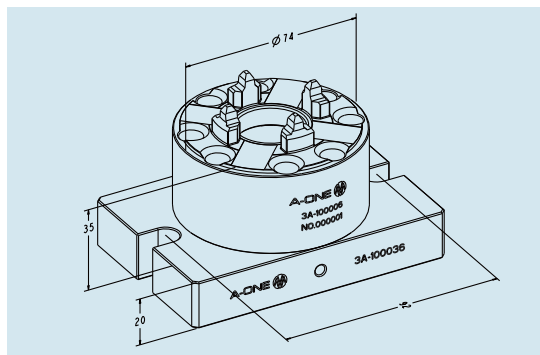
3A-100006 50 型简易卡盘
ITS Chuck 50 Inox

规格	系统尺寸 50, 不锈钢, 防腐蚀
夹紧力	2800N
连接	4×M6 从背面或 8 个 M5 螺钉从正面
应用	可用于客户设计的夹具
注意	自动操作, 背面进气
Version	System size 50, stainless steel, corrosion-resistant
Clamping	2800N
Connections	4×M6 from bottom side or 8×M5 from front side
Application	Can be used with customized tools
Note	Automatically, at the rear



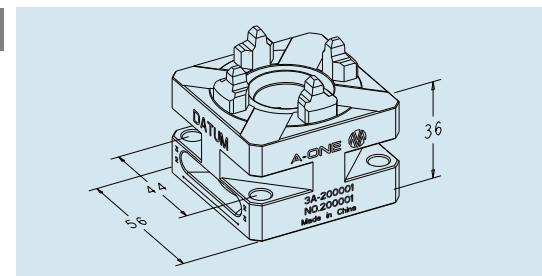
3A-100036 50 型简易卡盘
ITS Chuck 50 Inox with base plate

规格	系统尺寸 50, 不锈钢, 防腐蚀, 带底板
夹紧力	2800N
连接	4×M6 从背面或 8 个 M5 螺钉从正面
应用	可用于客户设计的夹具
注意	卡盘可以手动或自动操作, 侧面进气
Version	System size 50, stainless steel, corrosion-resistant, with plate
Clamping	2800N
Connections	4×M6 from bottom side or 8×M5 from front side
Application	Can be used with customized tools
Note	Automatically or manually, on the side



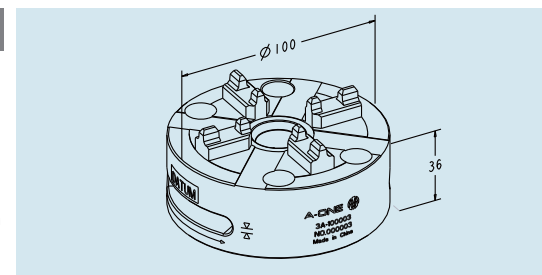
3A-200001 50 型手动卡盘
Quick chuck 50

规格	系统尺寸 ITS 50, 手动, 不锈钢
连接	4 个 M8 螺钉从背面或 4 个 M6 带螺母的柱头螺钉
应用	在电火花 / 线切割机床上装夹精铣和磨过的工件
注意	夹紧力高达 4000N
Version	System size ITS 50, manual, corrosion resistant
Connections	4×M8 from the rear or 4×M6 stud bolts with nuts
Application	On EDM/WEDM centers for light milling and grinding workpieces
Note	Clamping power 4000N



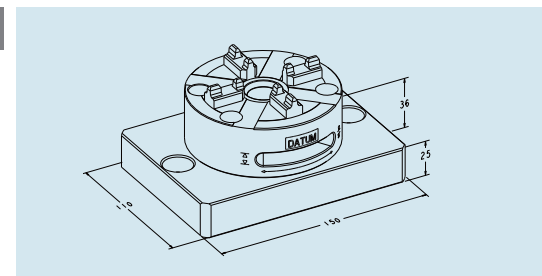
3A-100003 圆形手动卡盘
Quick chuck 100 P

规格	系统尺寸 100, 手动, 防腐蚀
安装	用所附的 4 个 M8 螺钉
应用	车床、铣床、磨床、电火花或线切割机床
注意	夹紧力: 10000N
Version	System size 100, manual, corrosion-resistant
Mounting	With four M8 bolts supplied
Application	Turning, milling, grinding or EDM/WEDM machines, in dividers and fixtures
Note	Clamping power up to 10000 N



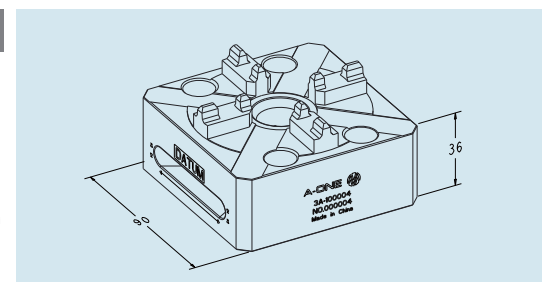
3A-100009 手动单中心卡盘
Quick chuck 100 P with base plate

规格	防腐蚀, 带底板
夹紧力	10000N
安装	用螺丝或压板
应用	CNC 加工中心用, 亦可用在铣床、磨床
Version	Corrosion-resistant, with plate.
Clamping	Power 10000N
Assembly	With bolts or clamps
Application	To be used on CNC lathe, Milling or grinding machine



3A-100004 方型手动卡盘
Square manual chuck

规格	系统尺寸 90, 手动, 防腐蚀
安装	用所附的 4 个 M8 螺钉
应用	车床、铣床、磨床、电火花或线切割机床
注意	夹紧力: 10000N
Version	System size 90, manual, corrosion-resistant
Mounting	With four M8 bolts supplied
Application	Turning, milling, grinding or EDM/WEDM machines, in dividers and fixtures
Note	Clamping power up to 10000 N

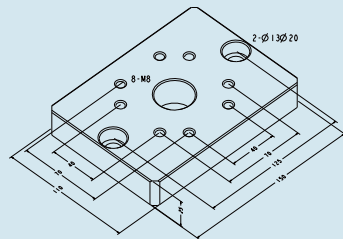


3A-100007 手动单中心卡盘底板
Quick chuck 100 P with base plate

规格 手动锁紧功能，单个基准接口，卡盘需另购
安装 直接安装在工作台上
应用 适用于 CNC、三次元检测台或其它机床

Version Power manual lock, one air connections, manual chuck supplied separately

Attachment To be mounted directly on the table of machining center
Application To be used on CNC lathe, coordinates measuring machine or other machines

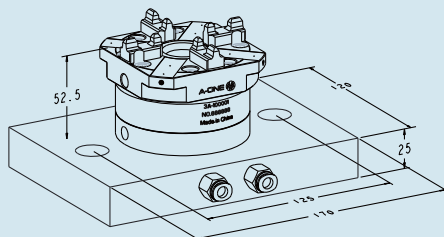


3A-100022 气动单中心卡盘底板
Base plate for single auto chuck-vertical

规格 气动锁紧功能，单个基准接口，卡盘需另购
夹紧力 4000N
安装 直接安装在工作台上
应用 适用于 CNC、三次元检测台

Version Power pneumatic lock, one air connection, pneumatic chuck supplied separately

Clamping Power 4000N
Attachment To be mounted directly on the table of machining center
Application To be used on CNC lathe, coordinates measuring machine



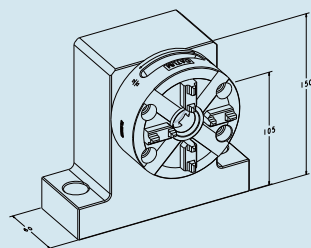
3A-100019 手动立式底座
Base plate for single manual-horizontal

规格 手动锁紧功能，可侧向四面加工，卡盘需另购
安装 直接安装在工作台上
应用 用于 CNC 加工中心

Version Power manual lock, four sides of workpiece can be machined, manual chuck supplied separately

Attachment To be mounted directly on the table of machining center

Application To be used on CNC lathe



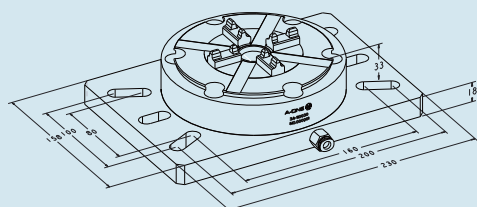
3A-110030 强力卡盘
Power chuck

规格 扁平型，高度 51 mm，基础板 158mm x 230mm
连接 侧面或背面二线连接
操作 侧面用气枪，或侧面、背面二线接控制盒
信息 基础板的标准布孔适合于间距 40mm 和 50mm 的 T 型槽相匹配

Version Extra-flat version. Height 51 mm
Base plate 158 mm x 230 mm

Connections On the side or at the rear with two lines
Operation With airgun on the side. With control unit through the two lines on the side or at the rear

Information The borehole pattern of this plate fits 40mm and 50mm T-slot distances

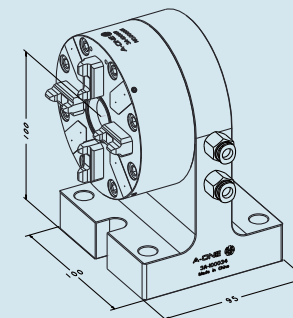


3A-100034 气动立式卡盘
Single autochuck-horizontal

规格 气动锁紧功能，可侧向四面加工，含卡盘
安装 直接安装在工作台上
应用 用于 CNC 加工中心

Version Power pneumatic lock, four sides of workpiece can be machined, with chuck

Attachment To be mounted directly on the table of machining center
Application To be used on CNC lathe

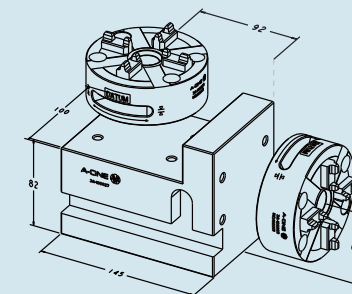


3A-100027 直角座
Square block for quick chuck loop

规格 钢，硬质，防腐蚀
应用 既可在水平又可在垂直位置安装 1 至 2 个 3A-100003
注意 卡盘需另购

Version Steel, hardened, corrosion-resistant
Application For attaching 1 or 2 chucks in horizontal and vertical position 3A-100003

Note manual chuck supplied separately

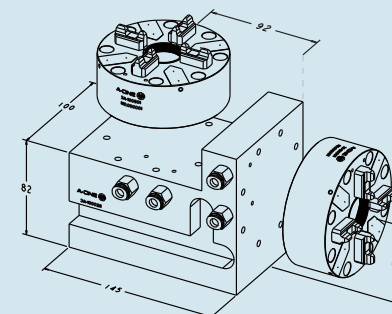


3A-100028 直角座
Square block for quick chuck loop

规格 钢，硬质，防腐蚀
应用 既可在水平又可在垂直位置安装 1 至 2 个卡盘 3A-100901
注意 卡盘需另购

Version Steel, hardened, corrosion-resistant
Application For attaching 1 or 2 chucks in horizontal and vertical position 3A-100901

Note manual chuck supplied separately



3A-100923 两中心 100 型气动卡盘
Auto chuck-double

规格 不锈钢, 淬硬, 气动控制 (0.6-0.8Mpa) 清洁功能, 预制底板 (尺寸可按工作台订做)

夹紧力 10000N

安装 直接安装在机床工作台上

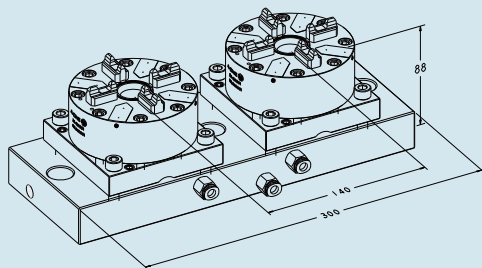
应用 安装孔请参考安装说明书加工

Version Stainless steel, hardened, pneumatic power(0.6-0.8Mpa) cleaning function, Base plate can be made in accordance with different size of table(customized)

Clamping 10000N

Attachment To be directly mounted on the table of machining center

Application Please refer to the installation instructions for processing mounting holes



3A-100925 四中心 100 型气动卡盘
Auto chuck-quatro

规格 不锈钢, 淬硬, 气动控制 (0.6-0.8Mpa) 清洁功能, 预制底板 (尺寸可按工作台订做)

夹紧力 10000N

安装 直接安装在机床工作台上

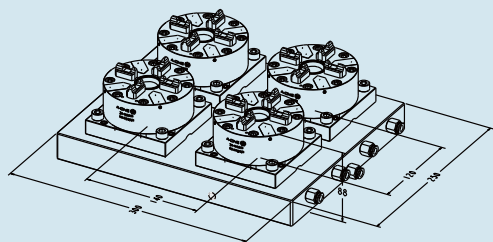
应用 安装孔请参考安装说明书加工

Version Stainless steel, hardened, pneumatic power(0.6-0.8Mpa) cleaning function, Base plate can be made in accordance with different size of table(customized).

Clamping 10000N

Attachment To be directly mounted on the table of machining center

Application Please refer to the installation instructions for processing mounting holes



3A-100926 六中心 100 型气动卡盘
Auto chuck-hexa

规格 不锈钢, 淬硬, 气动控制 (0.6-0.8Mpa) 清洁功能, 预制底板 (尺寸可按工作台订做)

夹紧力 10000N

安装 直接安装在机床工作台上

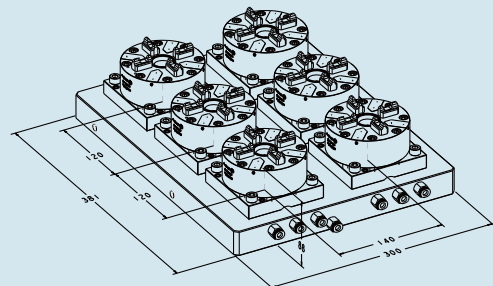
应用 安装孔请参考安装说明书加工

Version Stainless steel, hardened, pneumatic power(0.6-0.8Mpa) cleaning function, Base plate can be made in accordance with different size of table(customized)

Clamping 10000N

Attachment To be directly mounted on the table of machining center

Application Please refer to the installation instructions for processing mounting holes



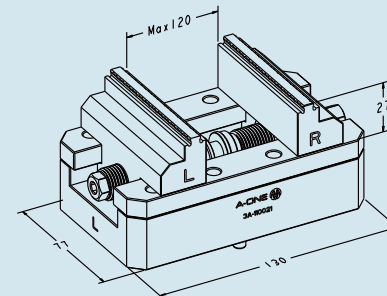
3A-110021 简易自定心虎钳
Self centering vise

规格 双向自定中心, 重复精度小于 0.01mm
两个 M10 螺丝连接工作台或托板
最大可夹持工件尺寸 120mm

应用 适用于立式和卧式精密加工设备, 一次加工五个面
特殊钳口可定制

Version Double self centered and repeating accuracy 0.01mm
To be fixed on the machine table or base plate with 2-M10 bolts
Maximum work piece size 120mm

Application Suitable for vertical and horizontal precision processing machine, for 5-axis machining per time
Special jaw can be customized



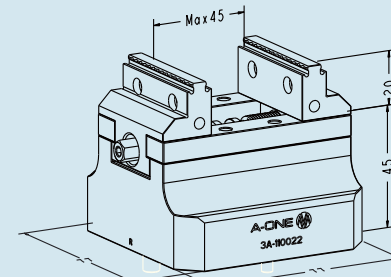
3A-110022 小虎钳
Small vise

规格 双向自定中心, 重复精度小于 0.01mm
两个 M6 螺丝连接工作台或托板
最大可夹持工件尺寸 70mm

应用 适用于立式和卧式精密加工设备, 一次加工五个面
特殊钳口可定制

Version Double self centered and repeating accuracy 0.01mm
To be fixed on the machine table or base plate with 2-M6 bolts
Maximum work piece size 70mm

Application Suitable for vertical and horizontal precision processing machine, for 5-axis machining per time
Special jaw can be customized



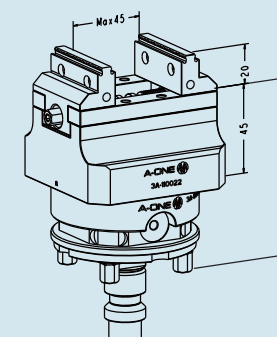
3A-110036 小虎钳 (ITS 50)
Small vise (ITS 50)

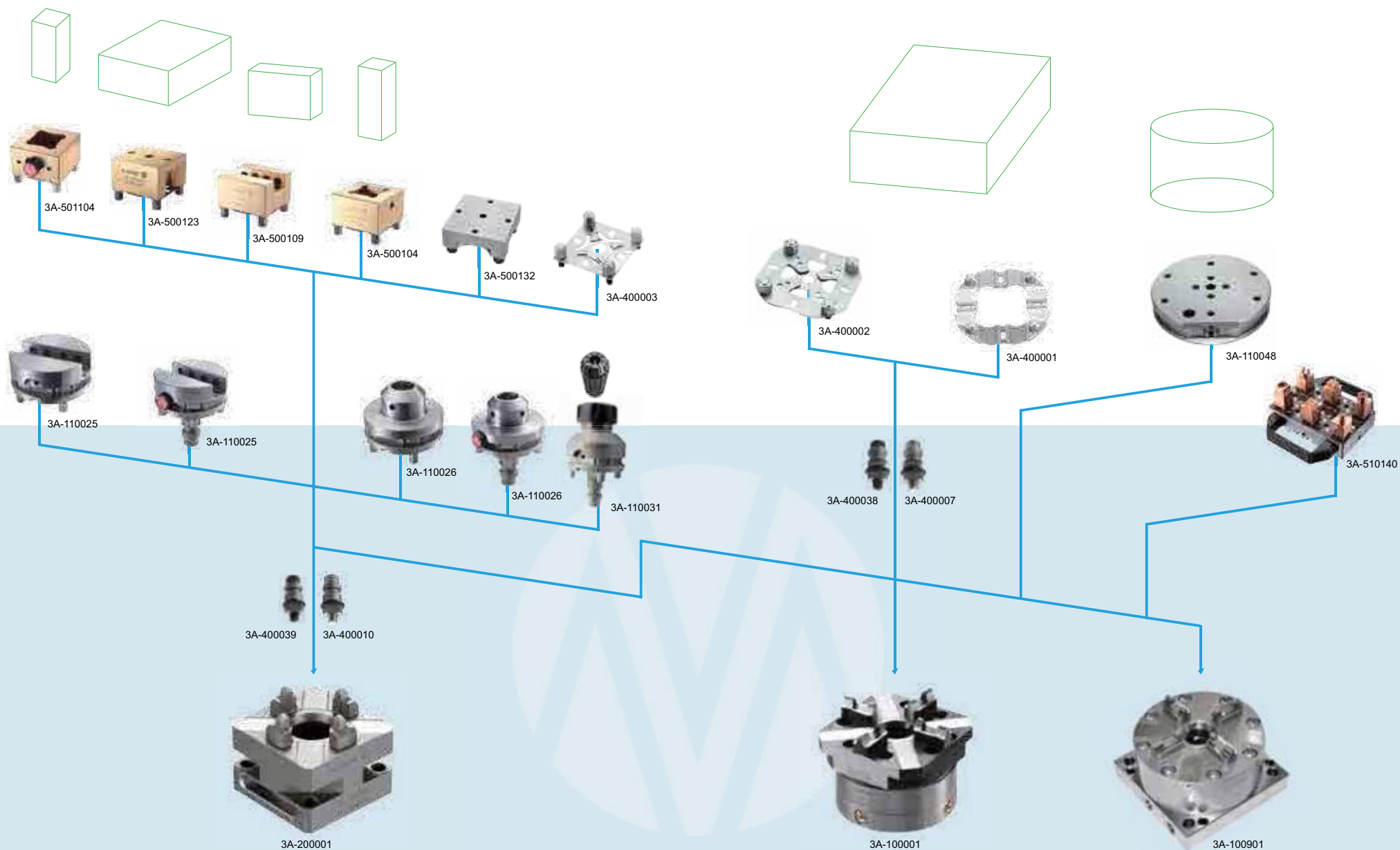
规格 系统尺寸 ITS 50, Ø72 机械握爪位, 含夹紧螺钉

应用 适用于 ITS 接口的精密加工设备及自动化生产线

Version System size ITS 50, Ø72 machining for gripper, including bolt

Application For ITS interface of precision machining equipment and automatic production







3A 快速定位夹具系统 3A RAPID POSITIONING JIG SYSTEM

Standard components Centering plates 标准组件 定位片

定位片是夹持电极的最经济的基础件。它可直接装于电极毛坯或托板上。这样，电极的夹具也与 ITS 匹配。安装孔的布孔只需简单的用钻孔模板或用 NC 编程的方法，直接在坯料上钻孔。

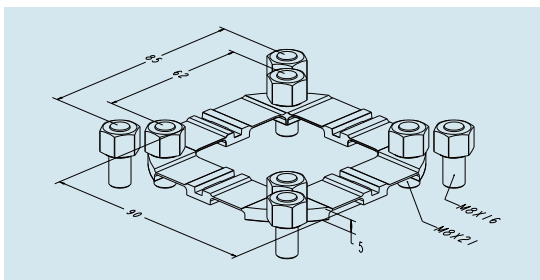
The centering plates are the most cost-effective base for clamping electrodes. They are mounted directly onto the blanks or pallets. This way, jigs and fixtures are also ITS compatible. The hole pattern for mounting is simply drilled into the blank with a drilling template, or by means of an NC program.

技术参数	Technical data	ITS 定位片	ITS centering plates
材料	Material	耐腐蚀	corrosion-resistant
在卡盘上的系统精度	System accuracy in chuck	0.002mm	0.002mm
规格	Versions:		
定位片 50	Centering plate 50	小型电极	small electrode weights
定位片 100M8	Centering plate 100 M8	工件和电极	workpieces and electrodes
定位片 G	Centering palte 100 G	工件，切削加工中的夹具	workpieces, jigs and fixtures for chip-removal machining
操作	Handling	用 A-ONE 搬运系统或电极交换装置	with A-ONE handling systems or electrode changer.

3A-400001 强力定位片 Centering plate G Inox

规格 磨削，每组含 8 个 M8 的支撑脚
应用 工件，切削加工中的夹具
安装 按随附的安装说明而定

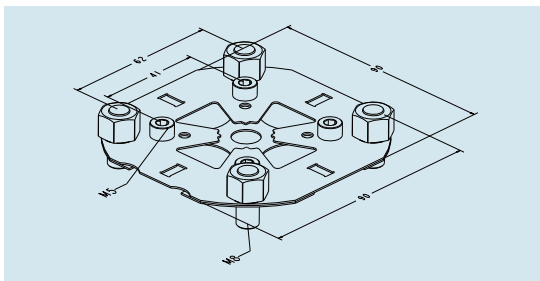
Version Ground, including 8 supporting feet M8
Application For workpieces, jigs and fixtures in chip-removal machining
Mounting According to accompanying fitting instructions



3A-400002 90 型定位片 Centering plate 100 M8

规格 耐腐蚀，每组含 4 个 M8 的支撑脚和 4 个 M5 螺钉
应用 工件和电极
安装 装于电极或工件托板上，也可直接安装于毛坯表面上

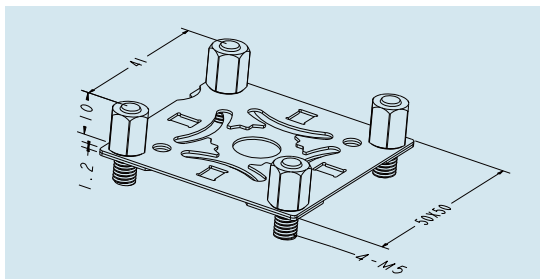
Version Corrosion-resistant, including 4 supporting feet M8 and 4×M5 screws per plate
Application Workpieces and electrodes
Mounting Mounted on the electrode plate or workpiece, and on plane surface blank too.



3A-400003 50 型定位片 Centering plate 50

规格 耐腐蚀，每组含 4 个支撑脚
应用 小电极
安装 装于电极或工件托板上，也可直接安装于毛坯表面上

Version Corrosion-resistant, including 4 supporting feet per plate
Application Small electrode weights
Mounting Mounted on the electrode plate or workpiece, and on plane surface blank too.



Standard electrode holder 标准电极夹具座

专业 可靠 耐用 精密
professional reliable durable precision

标准电极夹头用于电极的整个加工和储存过程中。经济实惠，用户可储备大量这样的夹头以供备用。标准夹具供货时不带夹紧螺钉。

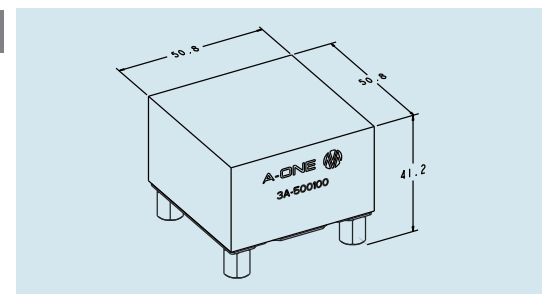
Standard electrode holders are used to contain electrodes for the entire machining cycle and for storage. Their economical unit price enables users to stock such holders in large quantities. The standard fixture are supplied without chucking spigots.

技术参数	Technical data	ITS 标准电极夹头	ITS standard electrode holders
材料	Material	主体：铜	body: copper
		定位片：耐腐蚀	centering plate: corrosion-resistant
在卡盘上的系统精度	System accuracy in chuck	0.002mm	0.002mm
建议最大电极载重	Recommended max. weight with electrode	20kg/44lbs	20kg/44lbs
操作	Handling	用 A-ONE 搬运系统或电极交换装置	with A-ONE Handling systems or electrode changer.

3A-500100 铜电极夹具座 Uniblank

规格 一套 12 个，主体未加工
应用 安装各种形状的电极和工件
安装 按实际需要

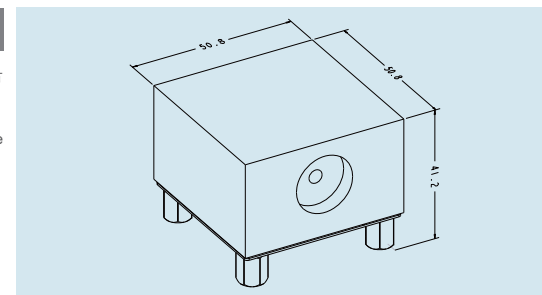
Version Set of 12 units, fitted without machining of body
Application To mount electrodes and workpieces of various shapes
Mounting As required



3A-501100 铜电极夹具座 Uniblank

规格 一套 12 个，预留安装数据承载器位置。单独订购芯片 3A-400054

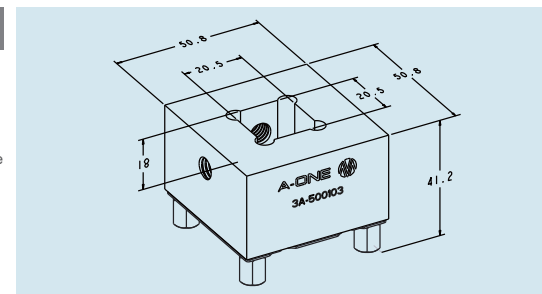
Version Set of 12 units, prepared for the installation of the code carrier. order chip 3A-400054 separately



3A-500103 铜电极夹具座 Prisround

规格 一套 12 个，每个包含 2 个固定螺钉
应用 用于夹持最大 20mm 正方形电极或工件

Version Set of 12 units, Each contains 2 fixed screws
Application For holding the largest 20mm square electrode or workpiece

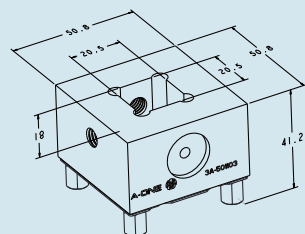


3A-501103

铜电极夹具座
Prisround

规格 一套 12 个，预留安装数据承载器位置。单独订购芯片 3A-400054

Version Set of 12 units, prepared for the installation of the code carrier. order chip 3A-400054 separately

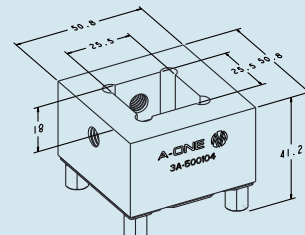


3A-500104

铜电极夹具座
Prisround

规格 一套 12 个，每个包含 2 个固定螺钉
应用 用于夹持最大 25mm 正方形电极或工件

Version Set of 12 units, Each contains 2 fixed screws
Application For holding the largest 25mm square electrode or workpiece

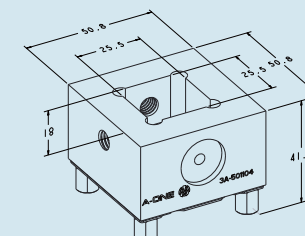


3A-501104

铜电极夹具座
Prisround

规格 一套 12 个，预留安装数据承载器位置。单独订购芯片 3A-400054

Version Set of 12 units, prepared for the installation of the code carrier. order chip 3A-400054 separately

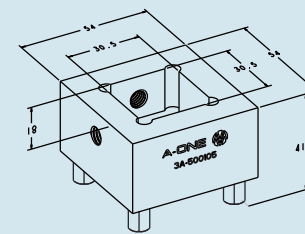


3A-500105

铜电极夹具座
Prisround

规格 一套 12 个，每个包含 2 个固定螺钉
应用 用于夹持最大 30mm 正方形电极或工件

Version Set of 12 units, Each contains 2 fixed screws
Application For holding the largest 30mm square electrode or workpiece

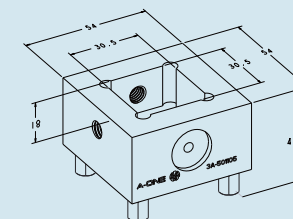


3A-501105

铜电极夹具座
Prisround

规格 预留安装数据承载器位置。单独订购芯片 3A-400054

Version Prepared for the installation of the code carrier. Order chip 3A-400054 separately

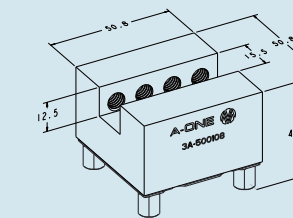


3A-500108

铜电极夹具座
Uniholder

规格 一套 12 个，每个包含 4 个固定螺钉
应用 用于夹持最大 15mm 长方形电极或工件

Version Set of 12 units, Each contains 4 fixed screws
Application For holding the largest 15mm oblong electrode and workpiece

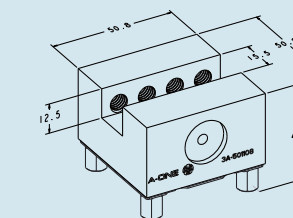


3A-501108

铜电极夹具座
Uniholder

规格 一套 12 个，预留安装数据承载器位置。单独订购芯片 3A-400054

Version Set of 12 units, prepared for the installation of the code carrier. Order chip 3A-400054 separately

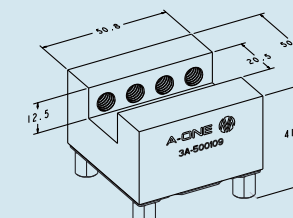


3A-500109

铜电极夹具座
Uniholder

规格 一套 12 个，每个包含 4 个固定螺钉
应用 用于夹持最大 20mm 长方形电极或工件

Version Set of 12 units, Each contains 4 fixed screws
Application For holding the largest 20mm oblong electrode and workpiece

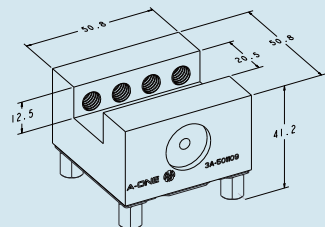


3A-501109

铜电极夹具座
Uniholder

规格 一套 12 个，预留安装数据承载器位置。单独订购芯片 3A-400054

Version Set of 12 units, prepared for the installation of the code carrier. Order chip 3A-400054 separately

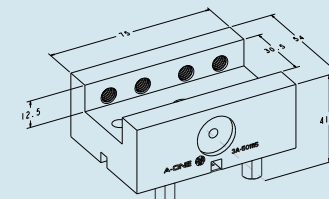


3A-501115

铜电极夹具座
Uniholder

规格 预留安装数据承载器位置。单独订购芯片 3A-400054

Version Prepared for the installation of the code carrier
Order chip 3A-400054 separately

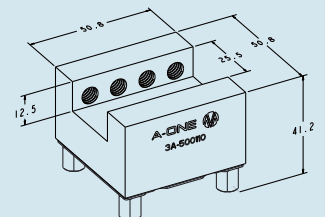


3A-500110

铜电极夹具座
Uniholder

规格 一套 12 个，每套包含 4 个固定螺钉
应用 用于夹持最大 25mm 长方形电极或工件

Version Set of 12 units, Each set contains 4 fixed screws
Application For holding the largest 25mm oblong electrode and workpiece

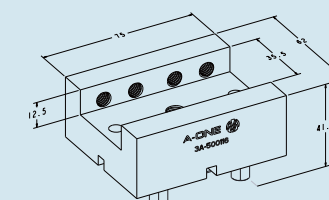


3A-500116

铜电极夹具座
Uniholder

规格 一套 12 个，每个包含 4 个固定螺钉
应用 用于夹持最大 35mm 长方形电极或工件

Version Set of 12 units, Each contains 4 fixed screws
Application For holding the largest 35mm oblong electrode and workpiece

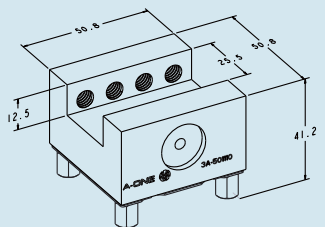


3A-501110

铜电极夹具座
Uniholder

规格 预留安装数据承载器位置。单独订购芯片 3A-400054

Version Prepared for the installation of the code carrier. order chip 3A-400054 separately

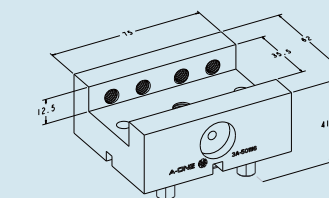


3A-501116

铜电极夹具座
Uniholder

规格 预留安装数据承载器位置。单独订购芯片 3A-400054

Version Prepared for the installation of the code carrier.
Order chip 3A-400054 separately

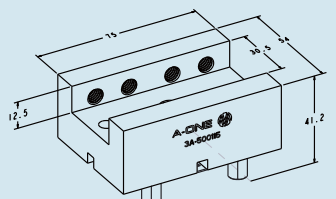


3A-500115

铜电极夹具座
Uniholder

规格 一套 12 个，每个包含 4 个固定螺钉
应用 用于夹持最大 30mm 长方形电极或工件

Version Set of 12 units, Each contains 4 fixed screws
Application For holding the largest 30mm oblong electrode or workpiece

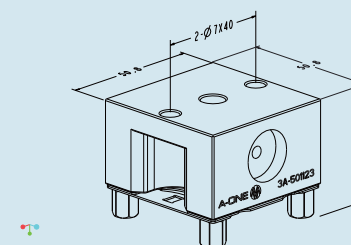


3A-500123

铜电极夹具座
Uniplate

规格 50.8×50.8 表面平
应用 安装基准表面大于 50mm 的电极或工件

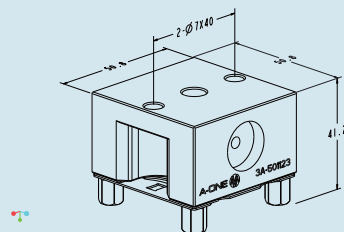
Version 50.8×50.8 surface
Application To mount electrodes and workpieces with shaft sizes of up to 50mm



3A-501123 铜电极夹具座 Uniplate

规格 预留安装数据承载器位置。单独订购芯片 3A-400054

Version Prepared for the installation of the code carrier
Order chip 3A-400054 separately



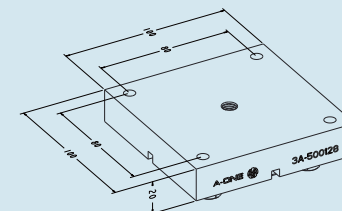
3A-500128 铝电极夹具座 Aluminum electrode holder

规格 100×100 表面平, 90 型定位面

应用 安装基准表面大于 100mm 的电极或工件

Version 100×100 surface, type 90 locating surface

Application The mounting datum plane is greater than 100mm electrode or ten workpiece



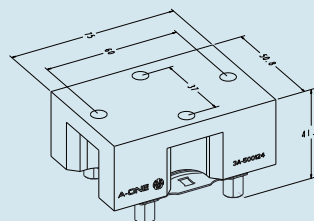
3A-500124 铜电极夹具座 Uniplate

规格 50.8×75 表面平

应用 安装基准表面大于 75mm 的电极或工件

Version 50.8×75 surface

Application To mount electrodes and workpieces with shaft sizes of up to 75mm



3A-520103 钢电极夹具座 Steel holder

材质 S136H

硬度 HRC30-36

规格 一套 12 个, 每个包含 2 个固定螺钉

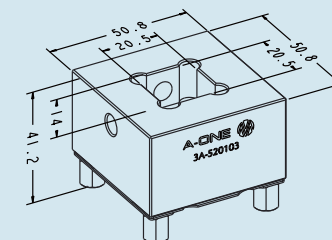
应用 用于夹持最大 20mm 正方形电极或工件

Material S136H

Hardness HRC30-36

Version Set of 12 units, Each contains 2 fixed screws

Application For holding the largest 20mm square electrode or workpiece



3A-500132 铝质万用块 80×80mm Uniplate olu 80×80mm

规格 一套 4 个, 铝质, 系统尺寸 100, 带 M8 支撑脚。

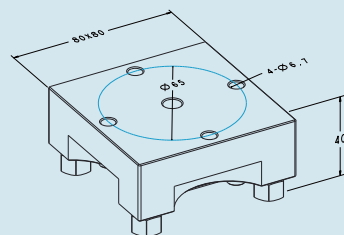
应用 安装基准表面大于 70 mm 的电极和工件。

安装 用 4 个 M6 螺钉与基准面相连。

Version Set of 4 units, aluminum, system size 100, with M8 supports feet.

Application To mount electrodes and workpieces with a base surface of more than 70 mm.

Mounting With 4 x M6 bolts into the base surface.



3A-520104 钢电极夹具座 Steel holder

材质 S136H

硬度 HRC30-36

规格 一套 12 个, 每个包含 2 个固定螺钉

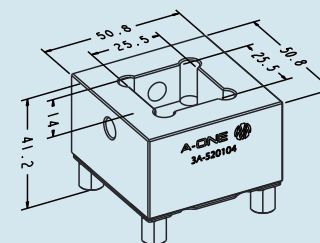
应用 用于夹持最大 25mm 正方形电极或工件

Material S136H

Hardness HRC30-36

Version Set of 12 units, Each contains 2 fixed screws

Application For holding the largest 25mm square electrode or workpiece



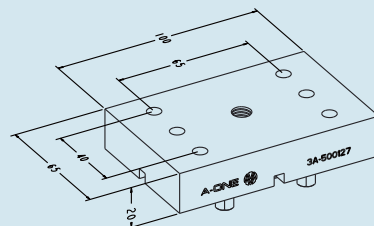
3A-500127 铝电极夹具座 Aluminum electrode holder

规格 65×100 表面平

应用 安装基准表面大于 100mm 的电极或工件

Version 65×100 surface

Application The mounting datum surface is greater than 100mm electrode or workpiece



3A-520105 钢电极夹具座 Steel holder

材质 S136H

硬度 HRC30-36

规格 一套 12 个, 每个包含 2 个固定螺钉

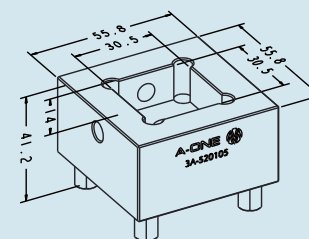
应用 用于夹持最大 30mm 正方形电极或工件

Material S136H

Hardness HRC30-36

Version Set of 12 units, Each contains 2 fixed screws

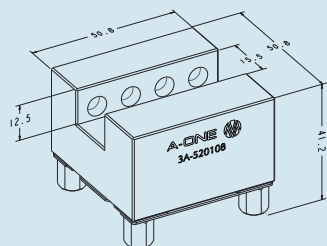
Application For holding the largest 30mm square electrode or workpiece



3A-520108 钢电极夹具座 Steel holder

材质 S136H
硬度 HRC30-36
规格 一套 12 个，每个包含 4 个固定螺钉
应用 用于夹持最大 15mm 长方形电极或工件

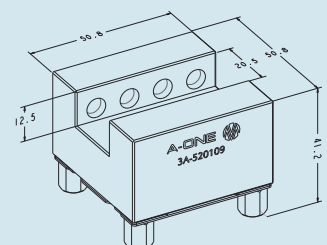
Material S136H
Hardness HRC30-36
Version Set of 12 units, Each contains 4 fixed screws
Application For holding the largest 15mm rectangle electrode and workpiece



3A-520109 钢电极夹具座 Steel holder

材质 S136H
硬度 HRC30-36
规格 一套 12 个，每个包含 4 个固定螺钉
应用 用于夹持最大 20mm 长方形电极或工件

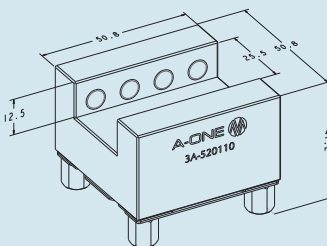
Material S136H
Hardness HRC30-36
Version Set of 12 units, Each contains 4 fixed screws
Application For holding the largest 20mm rectangle electrode and workpiece



3A-520110 钢电极夹具座 Steel holder

材质 S136H
硬度 HRC30-36
规格 一套 12 个，每套包含 4 个固定螺钉
应用 用于夹持最大 25mm 长方形电极或工件

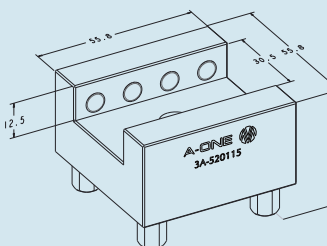
Material S136H
Hardness HRC30-36
Version Set of 12 units, Each set contains 4 fixed screws
Application For holding the largest 25mm rectangle electrode and workpiece



3A-520115 钢电极夹具座 Steel holder

材质 S136H
硬度 HRC30-36
规格 一套 12 个，每个包含 4 个固定螺钉
应用 用于夹持最大 30mm 长方形电极或工件

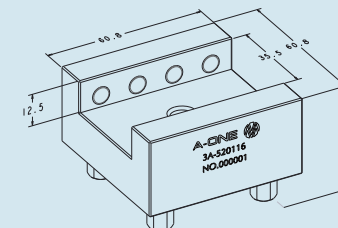
Material S136H
Hardness HRC30-36
Version Set of 12 units, Each contains 4 fixed screws
Application For holding the largest 30mm rectangle electrode or workpiece



3A-520116 钢电极夹具座 Steel holder

材质 S136H
硬度 HRC30-36
规格 一套 12 个，每个包含 4 个固定螺钉
应用 用于夹持最大 35mm 长方形电极或工件

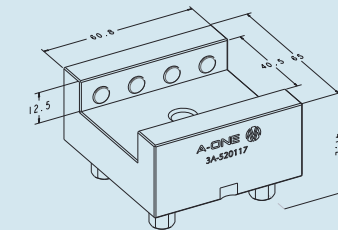
Material S136H
Hardness HRC30-36
Version Set of 12 units, Each contains 4 fixed screws
Application For holding the largest 35mm rectangle electrode and workpiece



3A-520117 钢电极夹具座 Steel holder

材质 S136H
硬度 HRC30-36
规格 一套 12 个，每个包含 4 个固定螺钉
应用 用于夹持最大 40mm 长方形电极或工件

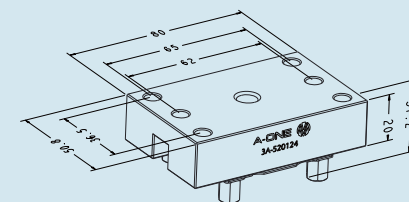
Material S136H
Hardness HRC30-36
Version Set of 12 units, Each contains 4 fixed screws
Application For holding the largest 40mm rectangle electrode and workpiece



3A-520124 钢电极夹具座 Steel holder

材质 S136H
硬度 HRC30-36
规格 50.8×75 表面平
应用 安装基准表面大于 75mm 的电极或工件

Material S136H
Hardness HRC30-36
Version 50.8×75 surface
Application To mount electrodes and workpieces with shaft sizes of up to 75mm



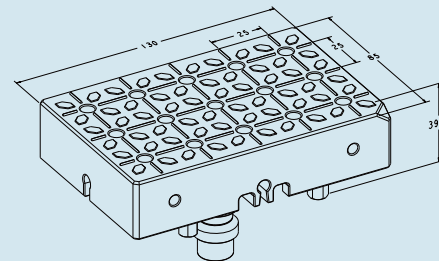
3A-510140 电极托板 Electrode to ask board

规格 托板及定位槽采用整体材料磨削而成，定位精度和使用寿命大幅提升。防滑尖齿的结构设计，只需底部一个螺丝锁紧，装夹更方便可靠，多个可拆电极拼装加工和放电，既省材料和工时，又容易保证各电极的位置关系。两侧面有手柄安装孔 2-M6-90。

应用 ITS 接口，适用于电极制造

Version Pallet and locating nest make up of whole material grinding, Greatly enhance positioning accuracy and operation life. Antiskid sharp tooth structure, only need a bolt lock on bottom, convenient and reliable for clamping. Many removable electrode assemble and discharge, not only save material but also save time. It is easy to ensure each electrode positional relation. Both sides have handle mounted hole 2-M6-90.

Application ITS connections, suitable for electrode manufacturing



3A-400013 扭力扳手 Torque wrench

规格 扭力可调
应用 安装调试 3A-400003 定位片 (50 型) 脚钉用

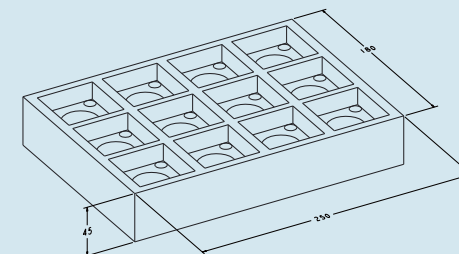
Version Torque is adjustable
Application Can be used when assemble screws in 3A-400003 (50 type) centering plate



3A-400022 12 格泡沫盒 System stand 50 12-fold

规格 一套 10 个, 苯乙烯泡沫盒
应用 储存和运输系统尺寸 50 的电极夹头

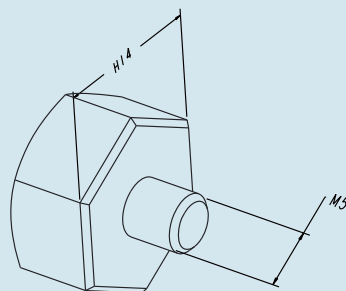
Version Set of 10 styrene stands
Application Storage and transport of electrode holders system size 50



3A-400054 带芯片的固定装置 H14 Chip with holder

规格 衬套中装有嵌入式数据载体。电器导线互联系统芯片: 只读
应用 应用于任何预先准备放置芯片的 A-ONE 电极夹头和托板

Version Sleeve fitting with built-in datacarrier. Rapid chip: read only
Application In any A-ONE electrode holder and pallet which has been prepared for it



3A-400012 电极手推车 Hand carry electrode cart

规格 不含胶盒
应用 方便摆放电极座, 安全可靠, 外形美观大方, 经济适用

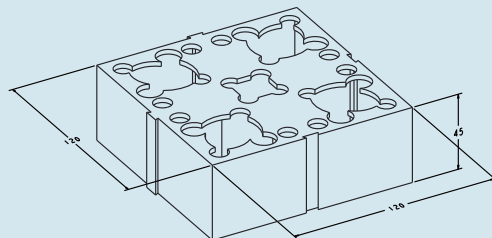
Version Plastic case is not included
Application Convenient storage of electrode holder. Safe and reliable. Beautifully design and economical



3A-300025 高胶盒 System stand

规格 塑料, 一套 10 个
应用 用于存放 4 个 50 的电极夹头或 1 个 $\phi 115/148$ mm 的托板
注意 系统座可无间隙地连在一起, 例如, 可存放在抽屉里

Version Plastic, set of 10
Application As a rack for four electrode holders 50 or a pallet $\phi 115/148$ mm
Please note System racks can be stuck together without any gaps, for example, to be stored in drawers



3A-400021 电极手推车 Electrode cart

规格 不含胶盒
应用 可拆式手推车, 包装运输方便, 结构紧凑

Version Plastic case is not included
Application Electrode cart that can be disassembled. Convenient for packing and transportation strong structure

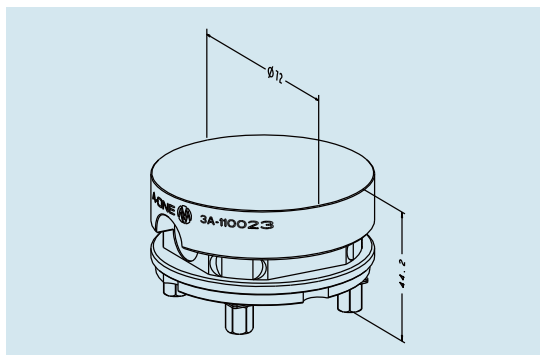


3A-110023

实心夹头 Ø72；一套 6 个
Uniblack Ø72 ; 6 pieces

规格 一套 6 个，系统尺寸 50，不含夹紧螺钉
应用 安装各种形状的电极和工作件
安装 根据需要钻连接孔

Version Set of 6 units, system size 50. Without chucking spigots
Application To mount electrodes and workpieces of various shapes
Mounting Attachment boreholes to be drilled according to requirements

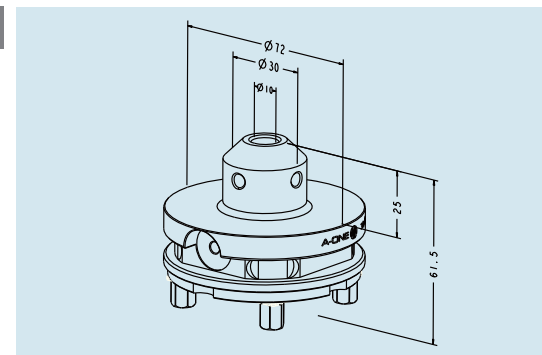


3A-110028

坯料夹头 Ø10/Ø72；一套 6 个
Blank holder Ø10/Ø72; 6 pieces

规格 一套 6 个，系统尺寸 50，不含夹紧螺钉
应用 夹持 10 mm 的圆柱形工件

Version Set of 6 units, system size 50. Without chucking spigots
Application To clamp cylindrical parts with Ø 10 mm

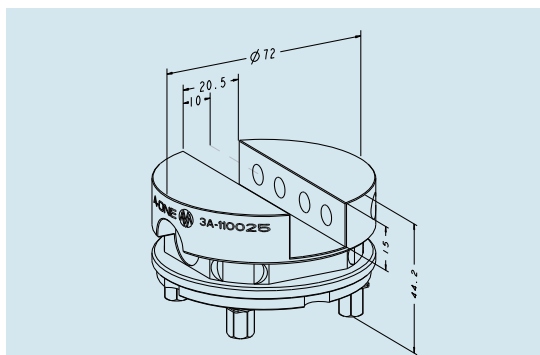


3A-110025

直槽夹头 Ø72；一套 6 个
Uniholder Ø72 ; 6 pieces

规格 一套 6 个，系统尺寸 50，不含夹紧螺钉
应用 安装接杆尺寸最大至 20 mm 的电极和工作件

Version Set of 6 units, system size 50. Without chucking spigots
Application To mount electrodes and workpieces with shaft of up to 20mm

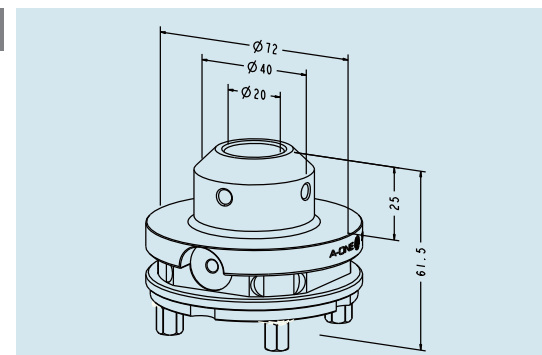


3A-110026

坯料夹头 Ø20/Ø72；一套 6 个
Blank holder Ø20/Ø72; 6 pieces

规格 一套 6 个，系统尺寸 50，不含夹紧螺钉
应用 夹持 20 mm 的圆柱形工件

Version Set of 6 units, system size 50. Without chucking spigots
Application To clamp cylindrical parts with Ø 20 mm

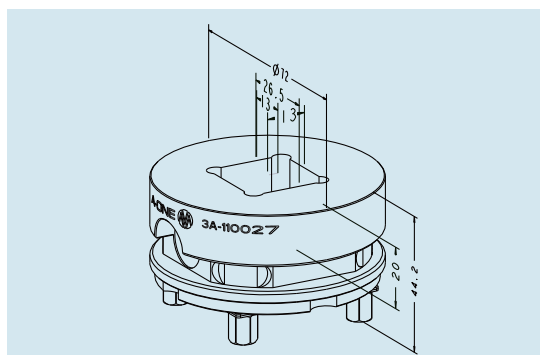


3A-110027

方孔夹头 Ø72；一套 6 个
Prisround Ø72 ; 6 pieces

规格 一套 6 个，系统尺寸 50，不含夹紧螺钉
应用 安装接杆尺寸最大至 25 mm 见方的电极和工作件

Version Set of 6 units, system size 50. Without chucking spigots
Application To mount electrodes and workpieces with shafts of up to square 25mm

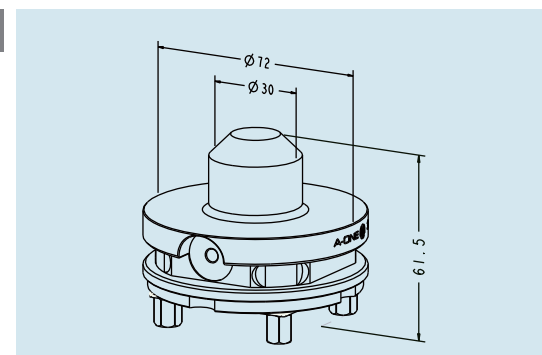


3A-110029

坯料夹头 Ø72；不带布孔；一套 6 个
Blank holder Ø72; Without borehole; 6 pieces

规格 一套 6 个，系统尺寸 50，不含夹紧螺钉
应用 夹持圆柱形工件
安装 根据需要钻最大直径 Ø12 mm 的连接孔

Version Set of 6 units, system size 50. Without chucking spigots
Application To clamp cylindrical parts
Mounting Attachment borehole up to max Ø12 mm to be drilled according to requirements



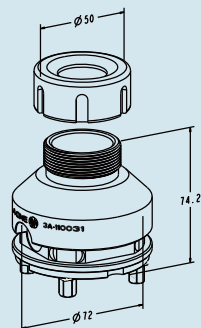
Holder Ø72
夹具座 Ø72
Precision pallets
精密托板

3A-110031

弹簧套筒夹头 Ø72;
Collet chuck holder Ø72

规格 每个弹簧套筒夹头都配有夹紧拉钉，系统尺寸 50。
应用 夹持圆柱形工件。夹持范围 Ø2mm-Ø20mm。
注意 单独订购弹簧套筒。

Version One collet chuck holder with chucking spigot. System size 50.
Application To clamp cylindrical parts. Clamping range Ø2 mm - Ø20 mm.
Please note Ordered collet chucks separately.



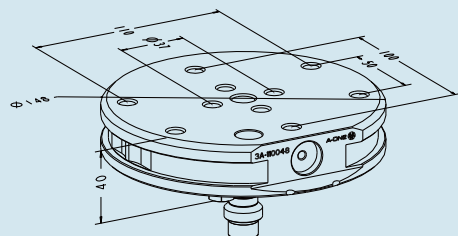
3A-110048

托板 Ø148
Pallet Kit Ø148

规格 钢，耐腐蚀。托板集成中心定位系统。
应用 用于所有 A-one 强力卡盘和生产型卡盘。在切削加工过程中适用于工件和夹具。
安装 用 M8 螺钉穿过托板，或用 M10 螺钉穿过坯料。

Version Steel, corrosion-resistant. Centering integrated in the pallet.
Application For use on all A-one Power Chuck and Production Chuck. To accommodate workpieces and fixtures in chip-cutting machining processes.

Mounting Through pallet with M8 bolts or through blank with M10 bolts



Chuckling spigots
夹紧拉钉

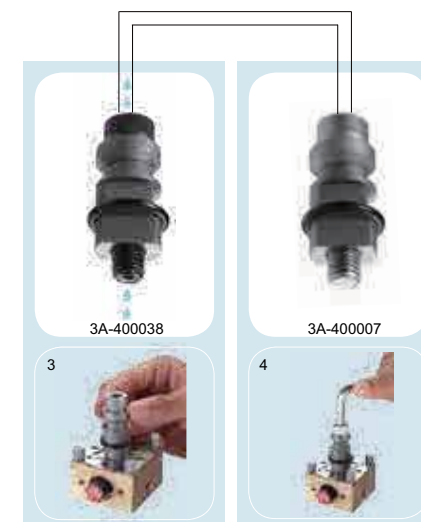


- 1、可移动的上部用作误差补偿。
Movable upper part for error compensation
- 2、锁紧球槽。
Groove for ball lock
- 3、与料仓的接合平面
Bonding plane with silo
- 4、O 形密封圈。
Groove for O-ring seal
- 5、握爪平面
Flats for gripper

手动 Manual



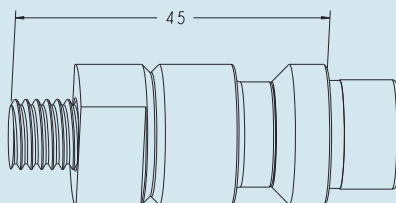
自动 Automatic



3A-400005 拉钉组合
Chucking spigot F/M production

规格 固定型，手动。螺钉 12.9，可带中心冲洗孔
应用 用于切削过程中的托板

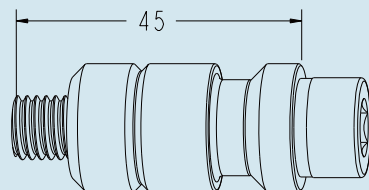
Version Fixed type, manual. Bolt 12.9, with flushing hole
Application In Pallets for chip-cutting machining processes



3A-400010 拉钉组合
Chucking spigot F/M production

规格 固定型，手动。螺钉 12.9，无中心冲洗孔
应用 用于切削过程中的托板

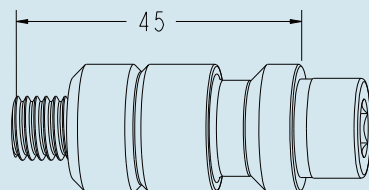
Version Fixed type, manual. Bolt 12.9, without flushing hole
Application In Pallets for chip-cutting machining processes



3A-400039 拉钉组合
Chucking spigot F/M EDM for flushing

规格 固定型，手动。螺钉带中心冲洗孔
应用 用于电极夹头，用于电火花加工和轻型切削加工

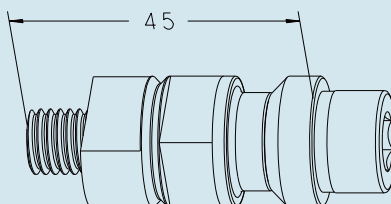
Version Fixed type, manual. Bolt with flushing hole
Application For electrode holder, for EDMing and easy machining with light cutting force



3A-400007 拉钉组合
Chucking spigot F/A Inox

规格 固定型，自动。不锈钢螺钉，无中心冲洗孔
应用 适用于电极库

Version Fixed type, automatic. Bolt stainless, without flushing hole
Application On all holders used on electrode library

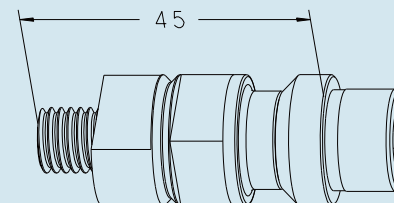


Square electrode clamping
system and system plus
方形电极系统和十字夹头

3A-400038 拉钉组合
Chucking spigot F/A EDM M10*45 for flushing

规格 固定型，自动。螺钉有中心冲洗孔
应用 用于电极夹头，用于电火花加工和轻型切削加工

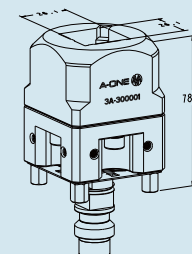
Version Fixed type, automatic. Bolt with flushing hole
Application For electrode holder, for EDMing and machining with light cutting force



3A-300001 方形 25×25 电极夹头
Square 25×25 electrode holder

规格 ITS 系统尺寸 50
应用 电火花和线切割

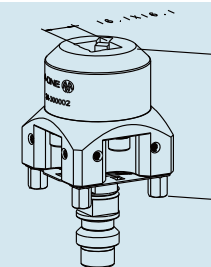
Version ITS system size 50
Application EDM/WEDM



3A-300002 方形 15×15 电极夹头
Square 15×15 electrode holder

规格 ITS 系统尺寸 50
应用 电火花和线切割

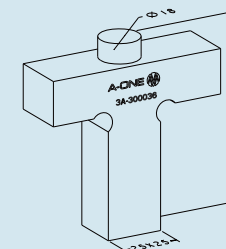
Version ITS system size 50
Application EDM/WEDM



3A-300036 方形 25 校正规
Square 25 alignment rail

规格 钢，硬质，磨削
应用 测量夹头与 ITS 系统的同轴度和角度精度

Version Steel, hardened, ground
Application Testing of concentricity and angular accuracy of holder to ITS system





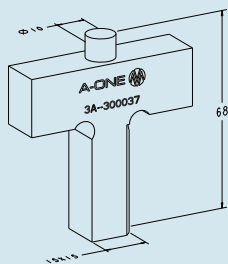
3A 快速定位夹具系统 3A RAPID POSITIONING JIG SYSTEM

Square electrode clamping system and system plus 方形电极系统和十字夹头 Special electrode holders 特殊电极夹头

3A-300037 方形 15 校正规 Square 15 alignment rail

规格 钢, 硬质, 磨削
应用 测量夹头与 ITS 系统的同轴度和角度精度

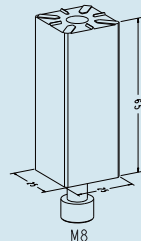
Version Steel, hardened, ground
Application Testing of concentricity and angular accuracy of holder to ITS system



3A-300013 压花杆 Angle holder

规格 钢, 硬质, 磨削。模压面 25 mm
应用 在坯料上压定心十字槽

Version Steel, hardened, ground. Embossed profile 25 mm
Application Embossing of centering prisms in blanks



3A-300014 压花杆 Angle holder

规格 钢, 硬质, 磨削。模压面 25 mm
应用 在坯料上压定心十字槽

Version Steel, hardened, ground. Embossed profile 25 mm
Application Embossing of centering prisms in blanks

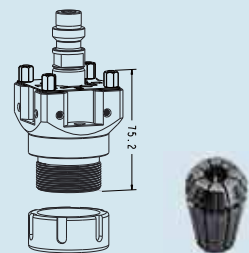


3A-300022 弹簧套筒夹头 Collet chuck holder 50

规格 系统尺寸 50, 包括扳手, 弹簧套筒需另购
应用 夹持最大至 $\varnothing 20$ mm 的圆形料件

Version System size 50, incl wrench, set of collet chucks to be separately supplied
Application For round material up to $\varnothing 20$ mm

* 弹簧套筒 $\varnothing 2-\varnothing 20$ mm
同心度: 普通级 0.02 mm, A 级 0.01 mm 及 UP 级 0.005 mm
* Set of collet chucks $\varnothing 2-\varnothing 20$ mm
The concentricity: general class 0.02 mm, A class 0.01 mm and UP class 0.005 mm



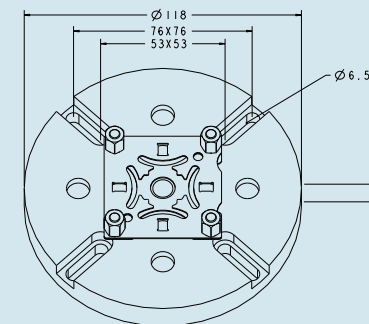
A-ONE EDM tools A-ONE EDM 工具

3A-300004 千秋架改装板 Adapter plate

规格 表面发黑, M6 螺丝过槽
应用 千秋架与 ITS 卡盘连接板

Version Black coated, M6 screws passing slot
Application Chiaki frame and ITS chuck plate

专业 可靠 耐用 精密
professional reliable durable precision

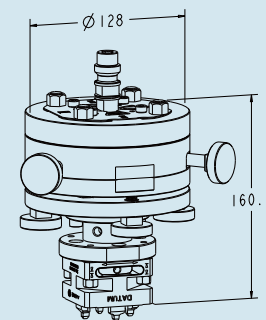


3A-300008 EDM 活动卡盘 Adjustable EDM holder

规格 可在 X, Y, Z 多向微调精度。可由标准加工转换为普通加工。
应用 卡盘需另购 适用于电火花成型机, 快捷转换

Version X, Y, Z axis precise adjustment. easy and quick change from standard process to normal process. chuck supplied separately

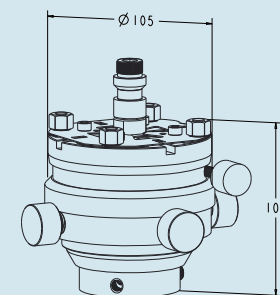
Application To be used on EDM for quick change



3A-300010 千秋架 Changeable EDM chuck

规格 可在 X, Y, Z 多向微调精度。可由标准加工转换为普通加工
应用 适用于电火花成型机, 快捷转换

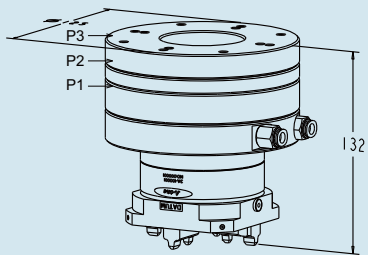
Version X, Y, Z axis precise adjustment. easy and quick change from standard process to normal process
Application To be used on EDM for quick change



3A-300016

EDM 卡盘安装套装
Adapter plate for auto chuck

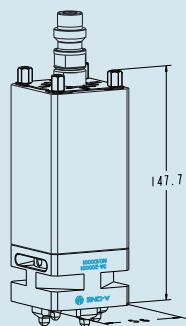
- 规格** 按客户机床定制，卡盘可选 3A-100001、3A-100901（气动卡盘）或 3A-100003（手动卡盘）
重复定位精度 0.002mm
配气动开关，卡盘需另购
如需订货，请参考示意图提供以下数据：
与机头对应的安装孔的大小 (ØZ/MZ) 和相对位置 (X,Y)
是否需要绝缘板组件 P1、P2、P3
适用于电火花成型机，直接安装在机头上
- 应用**
- Version** Customized in accordance with different EDMs. Select either 3A-100001、3A-100901(Auto chuck) or 3A-100003 (Manual chuck)
Repeating accuracy 0.002mm
Switches are supplied, chuck supplied separately
If customized, refer to drawings and data
Diameter and number of holes (ØZ / MZ) on EDM head and their X, Y positions
Whether insulating plates are needed or not, P1, P2, P3
- Application** To be directly mounted on EDM head



3A-300017

EDM 延长杆
Extention chuck

- 规格** 56X56X150
- 应用** 用于汽车或电器模具等深型腔电蚀加工
- Version** 56 X56X150mm.
- Application** To be used in deep cavity cutting for automotive molds or electrical molds



3A-300018

EDM 延长杆
Extention chuck

- 规格** 56X56X200
- 应用** 用于汽车或电器模具等深型腔电蚀加工
- Version** 56X56X200mm.
- Application** To be used in deep cavity cutting for automotive molds or electrical molds



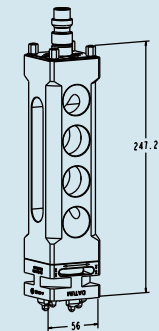
Extention chuck 延长杆

EDM motor drill 快速细水口夹具

3A-300042

200V 延长杆
200V Extention chuck

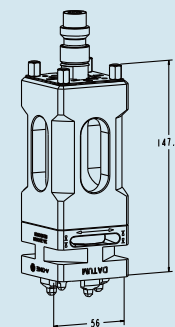
- 规格** 硬质钢，耐腐蚀，结构稳定
- 应用** 适用于火花机 Z 轴延长或大型模具深型腔电蚀加工
- Version** Alloy steel. Corrosion-resistant. Robust structure
- Application** Can be extended vertically or deep cavity machining of big size mold



3A-300043

100V 延长杆
100V Extention chuck

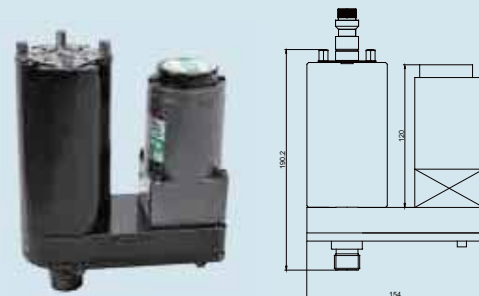
- 规格** 硬质钢，耐腐蚀，结构稳定
- 应用** 适用于火花机 Z 轴延长或大型模具深型腔电蚀加工
- Version** Alloy steel. Corrosion-resistant. Robust structure
- Application** Can be extended vertically or deep cavity machining of big size mold



3A-300023

快速细水口夹具
EDM motor drill

- 规格** 安装于 3A 系列基准卡盘上或直接安装于火花机
电极可自动旋转放电，提高排渣功能，避免积碳，转速可自动调节
比传统细水口放电加工效率提高 3-6 倍
适用于模件细水口放电加工
- 应用**
- Version** To be installed with 3A standard chucks series or directly on EDM quill. Electrode rotates motor driven to discharge, enhancing chip removal. Rotating speed is controllable. Cutting speed 3-6 times faster than normal EDM drill (non rotational)
- Application** Suitable for tiny nozzle hole drill electro-discharge machining





3A 快速定位夹具系统 3A RAPID POSITIONING JIG SYSTEM

Visual measuring scope 在线影像测量仪

Magnetic plate 磁力托板

3A-300026 在线影像测量仪 Visual measuring scope

- 在线影像测量仪是机械加工过程中一种辅助测量仪器。产品体积小，重量轻，可自由安装于机床主轴上，对工件进行直接测量，测量数据可由数据线传输到显示器上，工作人员可现场观察工件产品质量（如产品尺寸，光洁度，气孔，裂纹，沙眼等）第一时间对产品进行修正
- 提高加工精度：测量时工件没有移动，机床可直接进行二次设定加工，可精准加工出我们所需要的尺寸。测量仪直接安装在 3A 系列卡盘上，重复定位精度 0.002MM，也可以根据生产要求安装于不同机床
- 提高工作效率：减少了由测量到二次加工所需要的工件校正时间，减少人为设定误差

- Visual measuring scope is a supplementary instrument that can be used directly during machine processing.Scope is small size with light weight that it can be mounted on the machine head to measure workpieces.As measured data is directly sent to monitor,operator can check the quality immediately on-site such as size,fineness,presence of air holes,cracks,dit etc.Therefore immediate correction can be made.
- Enhanced machining accuracy:As workpiece is not moved during measuring process,next process can be set up at the same machine and required precision can be met.Scope can be mounted on any 3A series chucks with repeat accuracy of 0.002mm,which can be maintained on differ on machines.
- Enhanced efficiency:Due to the reduction of measurements step and possibly correction step as second process,lessen personal set up error.



磁力托板 Magnetic plate

- 装强力定位片 3A-400001 和拉钉配 A-ONE 卡盘 3A-110030 强力卡盘等使用
- 夹持工件，用于平面磨及 EDM 放电加工
- 吸引力：16kg/cm²
- 不含卡盘
- With strong positioning plate 3A-400001 and screws with A-ONE 3A-110030 such as the use of powerful chuck
- Clamping workpiece,used for grinding plane and EDM sinking
- Attraction:16kg/cm²
- Without chuck



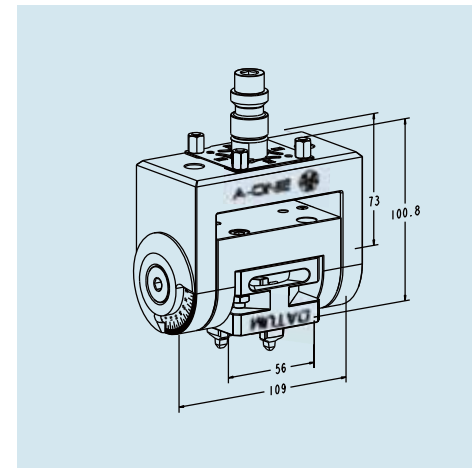
编号 Model No.	规格 (mm) Specification
3A-110201	150*150*45
3A-110202	150*220*50
3A-110203	150*300*50
3A-110204	150*250*50

Copper tungsten threaded electrode 钨铜螺纹电极

Tilting chuck 角度旋转卡盘

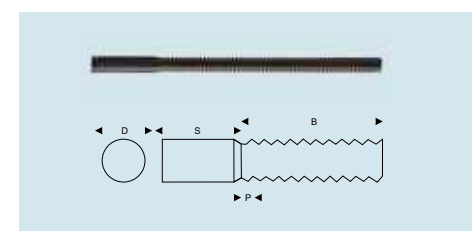
3A-300050 角度旋转卡盘 Angled clamping unit UnoSet for quick chuck 50

- 适用于线切割或电火花
- 50 型手动卡盘，游标尺设定角度尺寸
- 不锈钢（淬硬）
- 最大负荷：6kg；最大工件尺寸 100mm
- 有冲洗连接孔
- Can be used for EDM or WEDM
- 50 type manual chuck can be mounted.Angle scale on the side
- Stainless steel,hardened
- Maximum load:6kg, Maximum electrode size:100mm
- Center hole for oil flushing

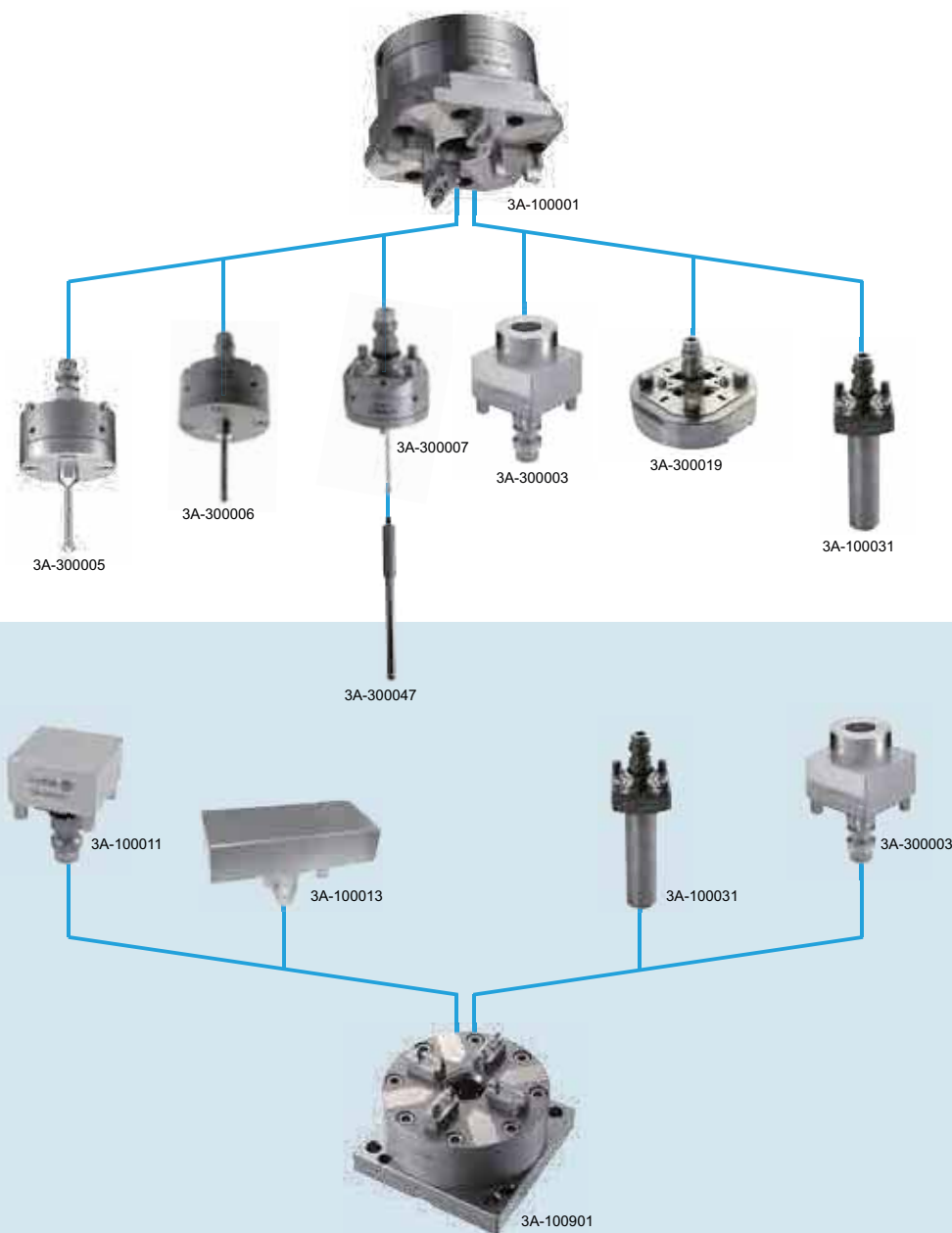


钨铜螺纹电极 Copper tungsten threaded electrode

材料 Material	成分 Composition (by wt)	密度 Density (g/cm ³)	电导率 Electrical conductivity (%IACS)	硬度 Hardness (HRB)
WD TM 10075	Tungsten: 70% (钨含量 70%) Copper: 30% (铜含量 30%)	14.6	38	94



型号 M(Model)	规格 Specifications	牙距 P(Pitch)	柄径 D(Outer diameter)	柄长 S(Shank length)	牙长 B(Thread length)
3A-300061	M3	0.50	2.20	15	55
3A-300062	M4	0.70	3.00	15	55
3A-300063	M5	0.80	3.70	25	55
3A-300064	M6	1.00	4.50	25	55
3A-300068	M8	1.25	6.30	25	55-75
3A-300069	M10	1.50	8.00	25	55-75
3A-300070	M12	1.75	9.70	25	55-75
3A-300071	M14	2.00	11.50	25	55-75
3A-300072	M16	2.00	13.50	25	55-75
3A-300073	M18	2.50	15.00	25	55-75
3A-300074	M20	2.50	17.00	25	55-75

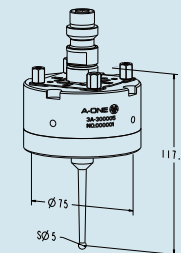


3A-300005

EDM 零位基准
Sensor with ball Ø5

规格 Ø5 固定型, 重复定位精度: X,Y,Z 向 0.002mm
应用 在数控电火花成型机床上工件的自动测量

Version Ø5 fixed type, Repetition accuracy: x,y,z 0.002mm
Application Automatic measurement of workpieces in CNC EDM sinking centers

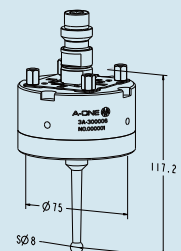


3A-300006

EDM 零位基准
Sensor with ball Ø8

规格 Ø8 固定型, 重复定位精度: X,Y,Z 向 0.002mm
应用 在数控电火花成型机床上工件的自动测量

Version Ø8 fixed type, Repetition accuracy: x,y,z 0.002mm
Application Automatic measurement of workpieces in CNC EDM sinking centers



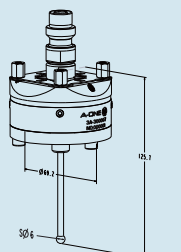
3A-300007

EDM 零位基准
Sensor with ball Ø6

规格 带有弹簧装卡的探针对称度: 0.002mm 可动式定位球, 防破坏性设计。Ø6 活动型
应用 适用于 EDM 电火花成型机, 工件或电极基准零位的找正

Version Holder with spring-loaded sensing pin symmetric accuracy: 0.002mm. Trouble free flexible ball design. Ø6 flexible type

Application To be used on zero point correction for EDM, workpiece and electrode

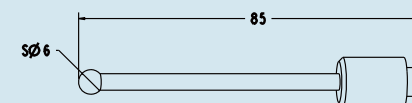


3A-300047

测头
Replacement sensor pin Ø6

规格 Ø6, 无垫圈

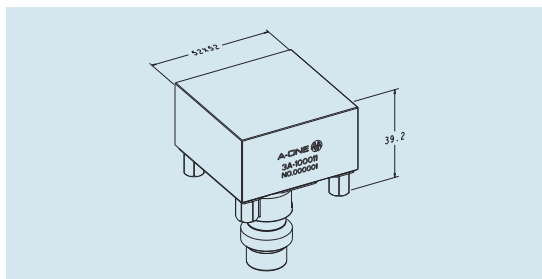
Version Ø6, without spacer washer



3A-100011 CNC 零位基准 CNC zero point gauge

应用 工件或电极基准位的找正
用于 CNC 加工中心

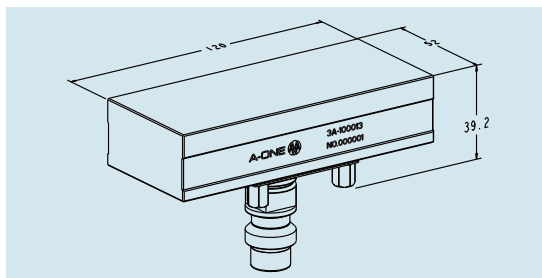
Application To be used on correction of workpiece or electrode datum.
For CNC machining center



3A-100013 CNC 零位基准 CNC zero point gauge

应用 用于卡盘水平方向, X,Y 方向平行检测, 校正

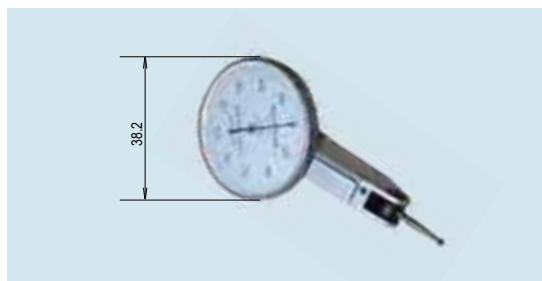
Application On the chucks, horizontal level can be inspected and adjusted on X, Y axis direction



3A-400036 千分表 0.002mm Dial gauge

规格 测量范围 $\pm 0.2\text{mm}$, 刻度值 0.002mm
应用 用于预设设定和预调工作站, 及 ITS 定位装置上

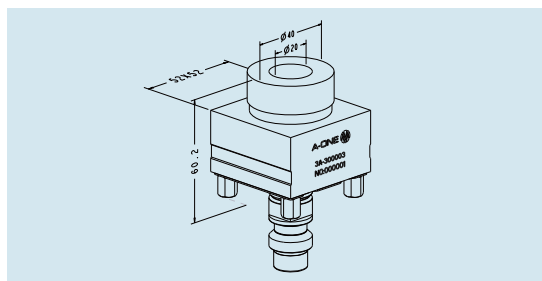
Version Measuring range $\pm 0.2\text{mm}$, Graduation 0.002mm
Application On Preset setup and pre-setting cells, and on ITS centering devices



3A-300003 CNC 零位基准 CNC gauging pin

规格 系统尺寸 ITS 50, 同时拥有圆形和方形两种规格基准
应用 ITS 卡盘零位找正或获得

Version ITS system size 50, have both two specification gauge: circle and square
Application ITS chucks datum alignment or obtain



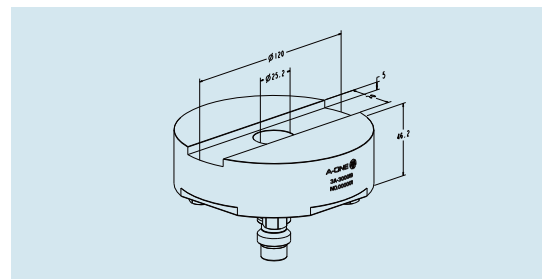
3A-300019 EDM 检测基准 EDM Alignment pallet

规格 系统尺寸 ITS 100 $\Phi 120$ 托板, 校正长度 115mm, 中心孔 $\Phi 25\text{mm}$

应用 ITS 卡盘, 强力卡盘等卡盘径向、轴向和角度位置的校正

Version ITS system size 100, Pallet $\Phi 120\text{mm}$, alignment length 115mm, center borehole $\Phi 25\text{mm}$

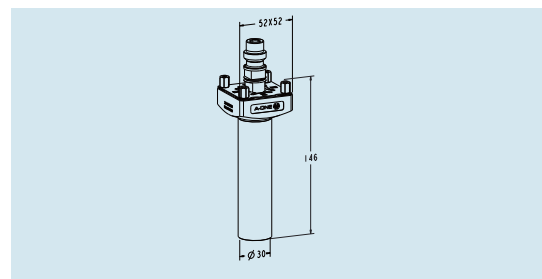
Application Alignment of radial, axial and angular position of ITS chucks, power chuck and so on



3A-100031 检测杆 Checking pin $\Phi 50$

规格 系统尺寸 ITS 50, 硬质、磨削
应用 ITS 卡盘径向、轴向和角度位置的校正

Version ITS system size 50, Hardened, ground
Application Alignment of radial, axial and angular position of ITS chucks



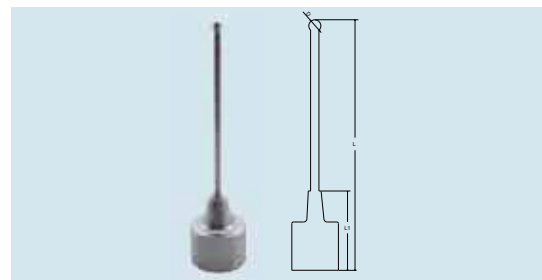
3A-300090 定位球 Locating ball

特点及用途:

- 1、直接安装到火花机工作台上
- 2、采用不锈钢材料, 配磁性底座
- 3、球体圆度 0.002mm

Features and application:

1. Mounted directly on the EDM workbench
2. Made of stainless steel, with a magnetic base
3. Ball roundness 0.002mm



规格 (specifications)	D	L1	L
$\Phi 6 \times 80$	$\Phi 6$	45	80
$\Phi 6 \times 100$	$\Phi 6$	45	100
$\Phi 6 \times 150$	$\Phi 6$	45	150
$\Phi 8 \times 80$	$\Phi 8$	45	80
$\Phi 8 \times 100$	$\Phi 8$	45	100
$\Phi 8 \times 150$	$\Phi 8$	45	150
$\Phi 10 \times 80$	$\Phi 10$	45	80
$\Phi 10 \times 100$	$\Phi 10$	45	100
$\Phi 10 \times 150$	$\Phi 10$	45	150



3A 快速定位夹具系统
3A RAPID POSITIONING JIG SYSTEM

A-ONE Measurement and
control componets
A-ONE 测量和控制元件

电极预调台是最理想的设置和预调站，用于快速检测 Z 轴向平面或在 Y 轴向校正工件。有了移动推车，您可根据工作情况将其放置在任何需要的地方。

Electrode presetting station is the ideal setting and presetting station for rapid detection of the Z-axis plane or workpiece calibration in Y-axis. With the mobile cart, you can place it at any place where it is needed according to work conditions.



选择夹持系统，预调站模块化设计，按需要选择夹持系统。
Select the clamping system, building block design of presetting station, select the clamping system as needed.



沿着固定的导轨，用活动表座上的千分表校正工件的 Z 平面或 Y 轴向校正。
Along fixed rails, use micrometer gauge on the movable gauge stand calibration Z plane of the workpiece or Y axis calibration.

技术参数 Technical parameters

操作时重量：根据实际承载重量订做
Weight of operation: customized based on the actual load weight

千分表刻度：0.002mm
Micrometer gauge scale: 0.002mm

测头系统：模拟式千分表安装于活动表座上
Probe system: analog type micrometer gauge mounted on the movable gauge stand



Zero point system
零点定位系统



- 一、易安装，自引导定位、高精度、气压操作。
- 二、节省装夹时间，提高装夹精确度，保证重复定位精度。
- 三、拆卸结构简单，无需找正调零，避免损坏高精度零点定位孔和定位销。
- 四、体积小，夹紧力强。
- 五、大直径锁紧波珠，松开时自行复位，更耐负荷。
- 六、实现机外预调，提高机床使用率。

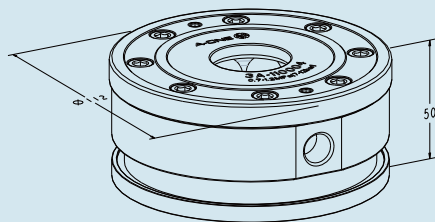
1. Easy to install, self-guided positioning, high precision and pneumatic operation;
2. Save time of fixture installation, improve accuracy, insure resetting precision;
3. Simple demounting structure, no need of alignment and zero set, avoid damage to high-precision positioning holes and pins;
4. Small volume but strong clamping;
5. More resistant to load, large-diameter locking balls can reset itself when released;
6. Preset externally and improve machine use ratio.



3A-110004 外置式 20 型零点卡盘
External 20 Type zero-point positioning system

松开 气压 -6bar
锁紧 内部机械锁紧
重复定位精度 0.003mm
材质 不锈钢
特点 内部机械锁紧，端盖和活塞硬化处理

Undamp Air pressure -6 bar
Locking Internal mechanical locking
Resetting precision 0.003mm
Material Stainless steel
Characteristic Internal mechanical locking, end cap and plunger hardening



应用:
机床工作台，双工作台加工中心中的工作台更换定位夹紧，快换工作台，快换托板，工件离线安装，工装夹具的更换，生产线主要功能组件的快速定位安装；汽车发动机生产线中的专机更换动力头，汽车焊接生产中主要组件的快速安装、更换。自动化柔性加工中工业机器人的搬运定位夹紧系统其它需要快速定位、夹紧的任意场合包括食品、生物和化工场合。

注意:
这种定位器结构紧凑而且具有很高的夹紧力和支撑力。只需要打开定位器时通入气压（最小 6bar/ 最大 12bar）。通过机械结构定位锁紧，结构紧凑，无泄漏风险。

提供:
一安装图纸，一自动化解决方案

Application:
Replace positioning fixture for machine tool working table and working table of double-table machining center, quick-change working table, quick-change pallet, workpiece off-line installation and fixture and jigs replacement. fast positioning and installation of main functional units of production line: specially-made power head replacement for automobile engine production line; quick installation and replacement of main components of automotive welding production; industrial robots handling, locating and clamping systems for automated flexible manufacturing; other applications that require fast positioning and clamping.

Note:
With a compact structure, zero-point positioning system has a high clamping force and holding power. For opening the zero-point positioning fixture, it is only required to draw into the air pressure (min 6 bar / max 12 bar). Positioning and locking via mechanical structure, with compact structure, no risk of leakage.

Provide:
- Installation drawings
- Automation solutions

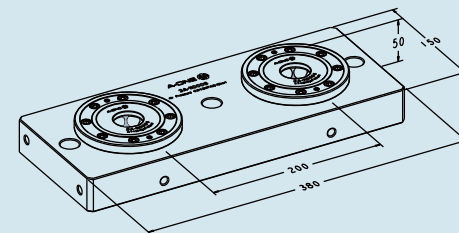


For example (Centering base plate-double)

3A-110006 两中心零点卡盘
Centering base plate-double

规格 基础板，钢，未淬硬；安装距离 200mm
连接 侧面，打开：气动
应用 适用于双托板。直接安装在机床台面上
注意 客户可自行配作连接孔
当心 钻孔时不要钻穿任何气路

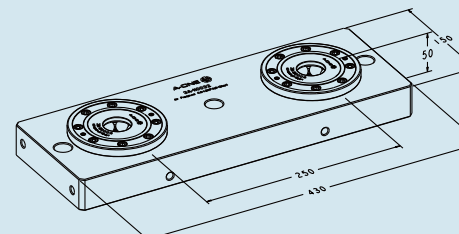
Version Base plate, steel, unhardened; set-up distance 200mm
Connections Lateral, to open: pneumatic
Application To accommodate double pallets for direct assembly on machine tables
Note Attachment boreholes can be drilled by customers
Caution Do not drill through any air or oil ducts



3A-110032 两中心零点卡盘
Centering base plate-double

规格 基础板，钢，未淬硬；安装距离 250mm
连接 侧面，打开：气动
应用 适用于双托板。直接安装在机床台面上
注意 客户可自行配作连接孔
当心 钻孔时不要钻穿任何气路

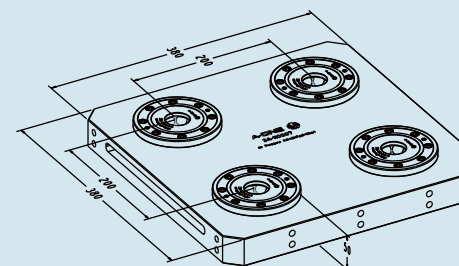
Version Base plate, steel, unhardened; set-up distance 250mm
Connections Lateral, to open: pneumatic
Application To accommodate double pallets for direct assembly on machine tables
Note Attachment boreholes can be drilled by customers
Caution Do not drill through any air or oil ducts



3A-110007 四中心零点卡盘
Centering base plate-quatro

规格 基础板，钢，未淬硬；安装距离 200mm
连接 侧面，打开：气动
应用 适用于多个托板。直接安装在机床台面上
注意 客户可自行配作连接孔
当心 钻孔时不要钻穿任何气路

Version Base plate, steel, unhardened; set-up distance 200mm
Connections Lateral, to open: pneumatic
Application To accommodate multiple pallets for direct assembly on machine tables
Note Attachment boreholes can be drilled by customers
Caution Do not drill through any air or oil ducts

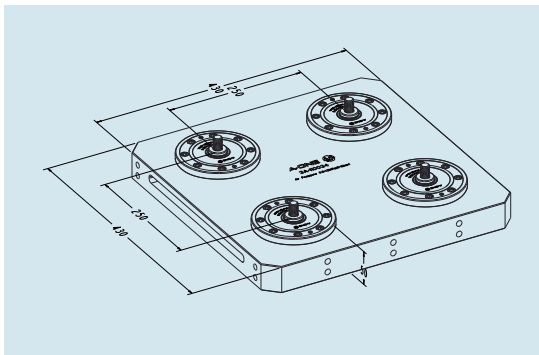


3A-110034

四中心零点卡盘
Centering base plate-quatro

规格 基础板, 钢, 未淬硬; 安装距离 250mm
连接 侧面, 打开: 气动
应用 适用于多个托板。直接安在机床台面上
注意 客户可自行配作连接孔
当心 钻孔时不要钻穿任何气路

Version Base plate, steel, unhardened; set-up distance 250mm
Connections Lateral, to open:pneumatic
Application To accommodate multiple pallets.for direct assembly on machine tables
Note Attachment boreholes can be drilled by customers
Caution Do not drill through any air or oil ducts

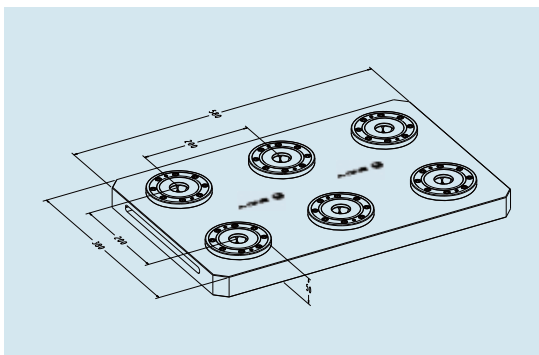


3A-110014

六中心零点卡盘
Centering base plate-hexa

规格 基础板, 钢, 未淬硬; 安装距离 200mm
连接 侧面, 打开: 气动
应用 适用于多个托板。直接安在机床台面上
注意 客户可自行配作连接孔
当心 钻孔时不要钻穿任何气路

Version Base plate, steel, unhardened; set-up distance 200mm
Connections Lateral, to open:pneumatic
Application To accommodate multiple pallets.for direct assembly on machine tables
Note Attachment boreholes can be drilled by customers
Caution Do not drill through any air or oil ducts

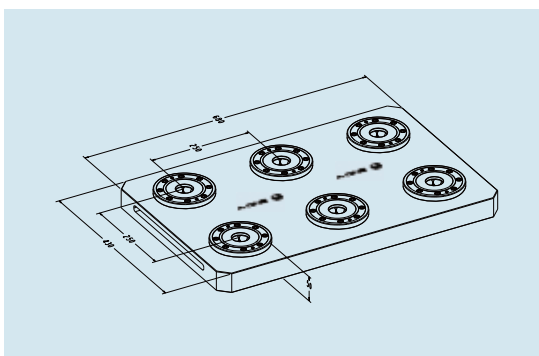


3A-110015

六中心零点卡盘
Centering base plate-hexa

规格 基础板, 钢, 未淬硬; 安装距离 250mm
连接 侧面, 打开: 气动
应用 适用于多个托板。直接安在机床台面上
注意 客户可自行配作连接孔
当心 钻孔时不要钻穿任何气路

Version Base plate, steel, unhardened; set-up distance 250mm
Connections Lateral, to open:pneumatic
Application To accommodate multiple pallets.for direct assembly on machine tables
Note Attachment boreholes can be drilled by customers
Caution Do not drill through any air or oil ducts



3A-110042

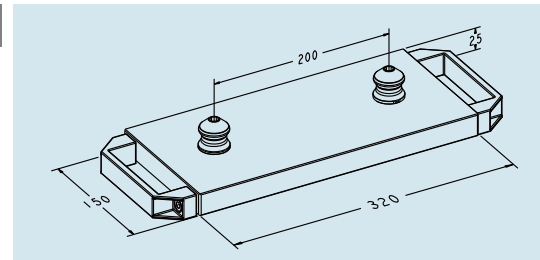
托板
Pallet

(中心距 200mm)

规格 铝托板, 2 联式, 含补偿拉钉 1 件, 定位拉钉 1 件
应用 夹持工件, 虎钳和量具
附件 卡盘需单独订购

(Set-up distance 200mm)

Version Aluminum pallet,2-fold, including 1 compensation spigot,1 precision pallet stopper,
Application To clamp workpieces,vises and gauges
Accessories To be ordered separately



3A-110043

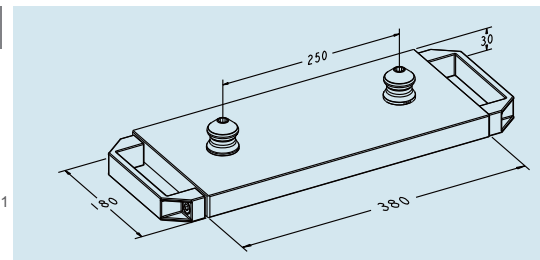
托板
Pallet

(中心距 250mm)

规格 铝托板, 2 联式, 含补偿拉钉 1 件, 定位拉钉 1 件
应用 夹持工件, 虎钳和量具
附件 卡盘需单独订购

(Set-up distance 250mm)

Version Aluminum pallet,2-fold, including 1 compensation spigot,1 precision pallet stopper,
Application To clamp workpieces,vises and gauges
Accessories To be ordered separately



3A-110044

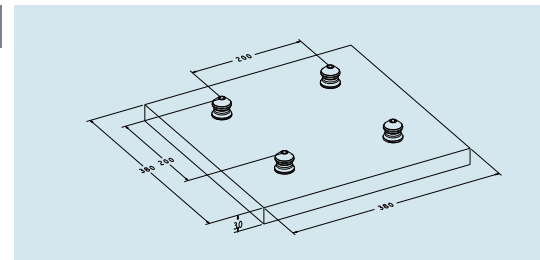
托板
Pallet

(中心距 200mm)

规格 铸铝托板, 4 联式, 含补偿拉钉 1 件, 定位拉钉 1 件, 夹紧拉钉 2 件
应用 夹持工件, 虎钳和量具
附件 卡盘需单独订购

(Set-up distance 200mm)

Version Cast aluminum pallet,4-fold, 1 compensation spigot,1 precision pallet stopper,2 chucking spigots
Application To clamp workpieces,vises and gauges
Accessories To be ordered separately



3A-110045

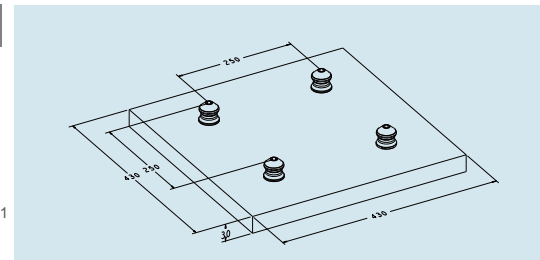
托板
Pallet

(中心距 250mm)

规格 铸铝托板, 4 联式, 含补偿拉钉 1 件, 定位拉钉 1 件, 夹紧拉钉 2 件
应用 夹持工件, 虎钳和量具
附件 卡盘需单独订购

(Set-up distance 250mm)

Version Cast aluminum pallet,4-fold, 1 compensation spigot,1 precision pallet stopper,2 chucking spigots
Application To clamp workpieces,vises and gauges
Accessories To be ordered separately



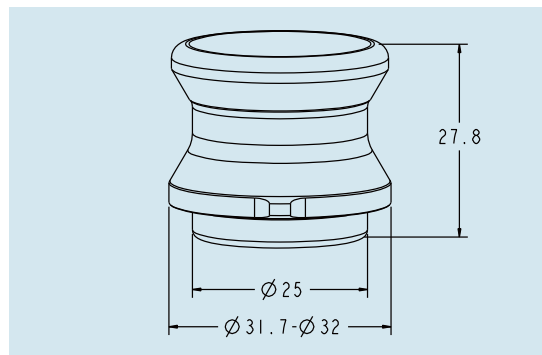
3A-400015 补偿拉钉 Compensation spigot

规格 用螺栓锁在工件托板上，起补偿定位作用，需配合定位拉钉、夹紧拉钉使用。确保轴向及径向定位精度 0.005mm

应用 配合 3A-1100004 用

Version To be fixed on pallets. Compensation and positioning functions. To be used with positioning fixing stopper and clamping fixing stopper. To ensure axial and radial positioning accuracy 0.005mm

Application To be used with 3A-1100004



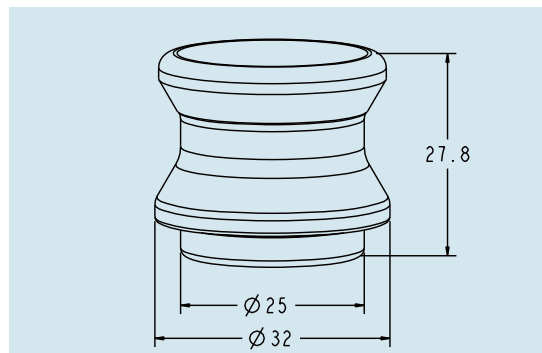
3A-400016 定位拉钉 Positioning pallet stopper

规格 一个具有定位功能的夹紧拉钉（无定位间隙）

应用 用于托板的自动装载/卸载。定位拉钉决定了基准点（无定位间隙）

Version A positioning function of clamping rails (no clearance)

Application To be used for the automatic loading or unloading, the location of rivet determines the reference point (no clearance)



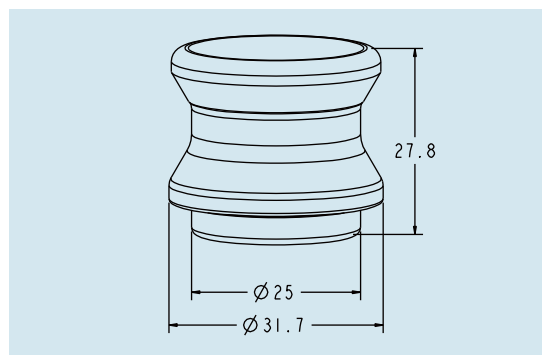
3A-400017 夹紧拉钉 Clamp pallet stopper

规格 一个具有定位功能的夹紧拉钉

应用 用于托板的自动装载/卸载。定位拉钉决定了基准点（无定位间隙）

Version A positioning function of clamping rails

Application To be used for the automatic loading or unloading, the location of rivet determines the reference point (no clearance)

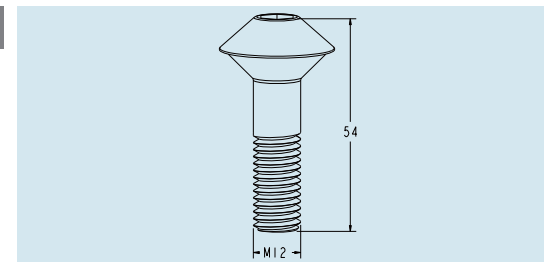


3A-400014 螺栓 Bolt

定位接头螺栓
等级 10.9
适合所有内置式和外置式零点快速定位夹持器

Positioning of the joint bolt
Level: 10.9
For quick positioning so built-in and built-out type zero and holder

Model.No.	M	L	L1	Weight(g)
3A-400014	M12	54	9.0	70



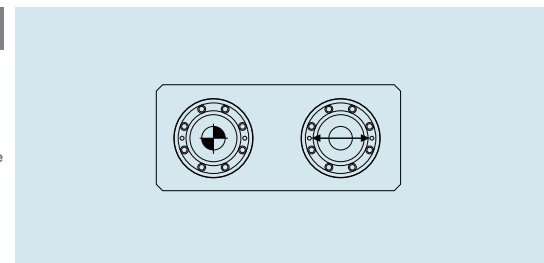
3A-400049 夹紧拉钉套装（2 件套） Chuckling spigot set 2

规格 1 个定位拉钉，1 个补偿拉钉

安装 用所提供的螺栓穿过托板或夹紧拉钉

Version 1 centering spigot, 1 compensation spigot

Mounting With the bolts supplied through the pallet or through the chuckling spigot



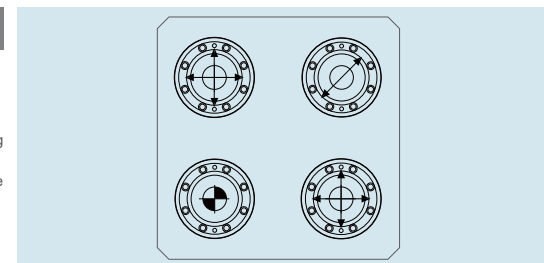
3A-400050 夹紧拉钉套装（4 件套） Chuckling spigot set 4

规格 1 个定位拉钉，1 个补偿拉钉，2 个夹紧拉钉

安装 用所提供的螺栓穿过托板或夹紧拉钉

Version 1 centering spigot, 1 compensation spigot, 2 chuckling spigots

Mounting With the bolts supplied through the pallet or through the chuckling spigot



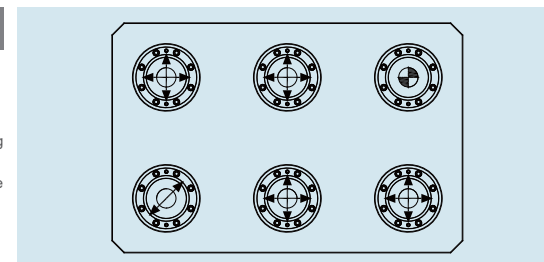
3A-400053 夹紧拉钉套装（6 件套） Chuckling spigot set 6

规格 1 个定位拉钉，1 个补偿拉钉，4 个夹紧拉钉

安装 用所提供的螺栓穿过托板或夹紧拉钉

Version 1 centering spigot, 1 compensation spigot, 4 chuckling spigots

Mounting With the bolts supplied through the pallet or through the chuckling spigot



3A-400046 定位柱
Checking pin

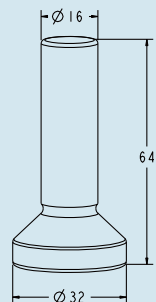
适合所有零点快速夹持器

适用：定位柱用于安装定位器，把定位柱装入机床主轴，把定位器装在定位柱上，把机床工作台移动到要求的位置，然后把定位器固定在工作台上，这样可以在工作台上精确的安装整个系列的定位器

Be used for all zero fast holders

Application: Positioning column used to install the locator, the load of machine tool spindle positioning column, put locators on the positioning column, move the machine table to the requirements of the position, and then put the locator and fixed on the workbench, this can be installed on the workbench accurate a whole series of locator

Model.No.	ØD1	ØDN	H	Weight(g)
3A-400046	16	32	64	225



3A-400023 大理石预调台
Granite pre-set table

可根据客户实际需要报价
Quotation as per customer request

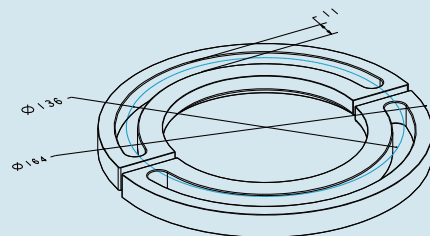
编号 (model)	卡盘数量 (chuck quantity)	规格 (specifications)	中心距 (centering distance)
3A-400023	2	2-200	200
3A-400044	2	2-250	250
3A-400063	4	4-200	200
3A-400045	4	4-250	250



3A-400018 环形压板
Round clamp

规格 环形压板二件一套
应用 用于安装 3A-110004

Version 2 pcs/set.
Application To be used with 3A-110004.



3A-400024 4通手动阀
Manual valve

规格 四口三位 (VBH220)

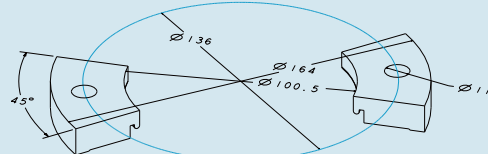
Version 4 points of air connector



3A-400019 扇形压板
Angle clamp

规格 一套两件，结构简单，占空间小
应用 用于安装 3A-110004，非重切削

Version 2 pcs/set. Simple design with minimum space
Application To be used with 3A-110004. For non heavy cutting



3A-400028 增压阀
Air booster

规格 配消音器，压力表
应用 用于增加气压，最大增压两倍，最大流量 400 (1/min) (ANR)

Version Included silencer and pressure gauge.
Application To increase air pressure up to two times. Maximum Air flow 400 liter per minute(ANR)



3A-110010

220 型零点虎钳
Clamp set base 220

- 规格** 钢, 硬质, 磨削; 有 2mm 间隔的定位齿, 上面可装夹持元件
- 应用** 可直接安装于工作台, 也可安装于托板上
- Version** Hardened steel, ground with 2.0mm space of positioning teeth on which work piece can be placed
- Application** Be mounted directly on the table or the pallet chuck.



3A-110011

320 型零点虎钳
Clamp set base 320

- 规格** 钢, 硬质, 磨削; 有 2mm 间隔的定位齿, 上面可装夹持元件
- 应用** 可直接安装于工作台, 也可安装于托板上。安装于 3A-400015, 3A-400016, 与 3A-110004 零点定位系统配合使用
- Version** Hardened steel, ground with 2.0mm space of positioning teeth on which work piece can be placed
- Application** Be mounted directly on the table or the pallet chuck. Can be used with 3A-400015, 3A-400016 or 3A-110004



3A-110012

夹爪
Clamp set block F

- 规格** 硬质钢, 包括用于连接的棒块
- 应用** 夹持表面已加工过的工件。用所提供的棒块装于底座 3A-110010 或 3A-110011 上
- Version** Hardened steel, T nut is supplied
- Application** To clamp already machined surface work piece. To be mounted on the base of 3A-110010, 3A-110011 clamp



3A-110013

F 挡块
F Clamp block

- 规格** 硬质钢, 包括用于连接的 T 型块
- 应用** 用所提供的 T 型块装于底座 3A-110010 或 3A-110011 上
- Version** Hardened steel, T nut is supplied.
- Application** To clamp already machined surface work piece. To be mounted on the base of 3A-110010, 3A-110011 clamp



A-ONE Ball lock system A-ONE 球锁轴系统

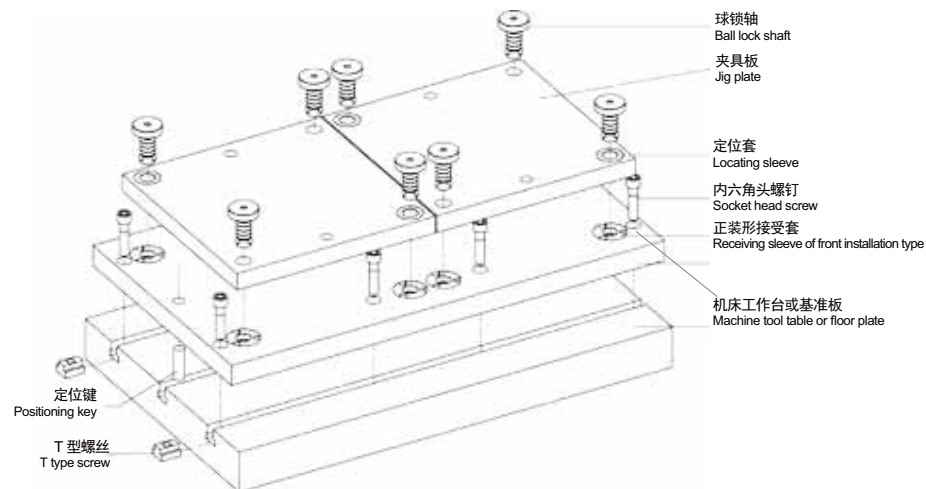
专业 可靠 耐用 精密
professional reliable durable precision

定位 Positioning

球锁系统可精确地定位工件, 无需为夹具找正并且确保重复定位精度在 $\pm 0.010\text{mm}$ 之内
Ball Lock system can accurately locate the workpiece. It is not necessary to make alignment for the fixture and the resetting precision can be ensured within $\pm 0.010\text{mm}$.

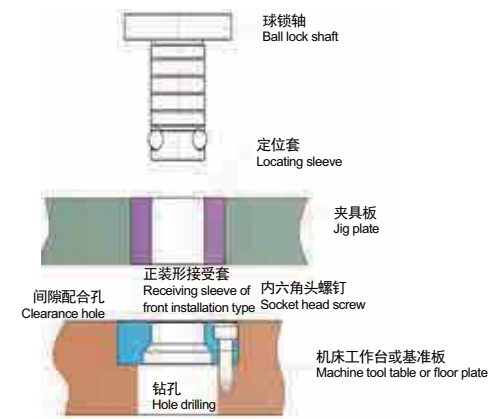
锁紧 Locking

球锁系统可将夹具牢牢地固定在基础板上, 每个轴最大可提供 9 吨的锁紧力。
Ball Lock system can firmly fix the jig plate on the floor plate with a maximum of nine tons locking force for each axle..



- 1) 基础板, 作为定位基准, 永久固定在机器工作台上。基础板上装有多球锁接受套, 配合不同大小的夹具板。
- 2) 夹具板, 装有两个球锁定位套, 与基础板上的接受套对应, 通过球锁轴锁紧
- 3) 球锁轴, 起定位和锁紧的作用, 通过与定位套配合, 将夹具板快速、精确地固定在基础板上。有多种尺寸可供选择。

- 1) Floor plate, as the positioning reference, is permanently fixed to the machine worktable. Several ball lock receiving sleeves are fitted on the floor plate to work with different sizes of jig plate.
- 2) Jig plate, with two ball lock locating sleeves fitted, corresponds to the receiving sleeve on the floor plate and can be locked through a ball lock shaft.
- 3) Ball lock shaft, with the function of locating and locking, works with the locating sleeve and fixes the jig plate quickly and accurately to the floor plate. There are a variety of sizes can be selected.



定位锁紧球锁轴 - 公制
Locating and locking ball lock shaft—Metric system

热处理	球锁轴, HRC 40-45
	接受套, HRC 50-54
	定位套, HRC 62-64
Heat treatment	ball lock shaft, HRC 40-45
	receiving sets, HRC 50-54
	locating sleeve, HRC 62-64

定位锁紧球锁轴尺寸
Dimensions of locating and locking Ball Lock Shaft

编码 Model No.	A	夹具板厚度 ±0.13mm Thickness of jig plate	B	C	D	六角扳手尺寸 Hex wrench dimension	最大螺丝扭矩 (N.m) Max screw torque	最大夹紧力 (KN) Max clamping force	推荐螺丝扭矩 (N.m) Recommended screw torque	推荐夹紧力 (KN) Recommended clamping force
3A-700004	20	20	10	40	38.5	3	5.3	13.3	4	10
3A-700003		25			40.5					
3A-700007	25	20	10	45	44.0	4	11	30	9	23
3A-700009		25			49.0					
3A-700012	30	20	13	50	49.0	5	18	44	15	35
3A-700014		25			54.0					



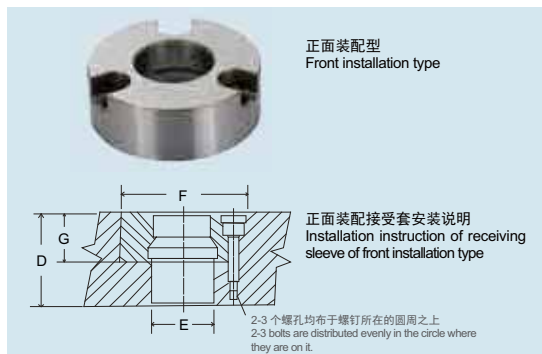
接受套 (公制)
Receiving sleeve of front installation type is often used for blind holes (clearance fit)

安装好的接受套表面应低于基础板表面约 0.3mm
The surface of fitted receiving sleeve should be about 0.3mm lower than the floor plate surface.

正装型接受套常用于盲孔 (间隙配合)
Receiving sleeve of front installation type is often used for blind holes (clearance fit)

安装尺寸 Installation dimension
正面装配 Front assembly

编号 Model No.	球锁轴直径 Diameter of ball lock shaft	实际外径 Actual external diameter	间隙孔直径 Diameter of clearance hole E	沉孔 Counterbore	深度 Depth	最小基础板厚度 Minimum floor plate thickness D
3A-700001	20	45	21.0	45	16.21	25
3A-700010	25	55	25.5	55	20.32	30
3A-700015	30	60	30.5	60	22.15	35



定位套
Locating sleeve

重复定位精度将决定是否需要一级、二级定位套各一个还是两个一级定位套。用两个一级定位套的情况下, 如果接受套两个孔的中心距在 ± 0.005 mm 公差范围内, 那就重复定位精度可以保持 ± 0.013 mm 以内。
Resetting precision will determine whether Class I & II locating sleeves are required one for each or only two Class I sleeves are required. If two Class I locating sleeves are applied and the center distance of the two holes of the receiving sleeve is within the tolerance range of ± 0.005 mm, the resetting precision can be maintained within ± 0.013 mm.

定位套及背面装配型接受套安装注意事项

为了减少轴在内孔中取不出来的可能性, 内孔和接受套外径配合的最大过盈量不得超过 0.013 mm。
Installation Considerations for locating sleeve and receiving sleeve of back assembly type In order to minimize the possibility that the shaft cannot be taken out from the bore, the maximum amount of interference between the bore and the receiving sleeve can not exceed 0.013 mm.

定位套尺寸
Dimension of locating sleeve

编号 Model No.	球锁轴直径 (mm) Diameter of ball lock shaft	夹具板厚度 Thickness of jig plate	一级定位套内径 Internal diameter of Class I locating sleeve	定位套外径 external diameter of locating sleeve
3A-700005	20	20	20	35
3A-700002		25		35
3A-700006	25	20	25	35
3A-700008		25		35
3A-700011	30	20	30	45
3A-700013		25		45





3A-200001



3A-200003



3A-200006



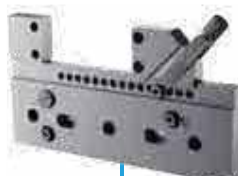
3A-200008



3A-200010



3A-200002



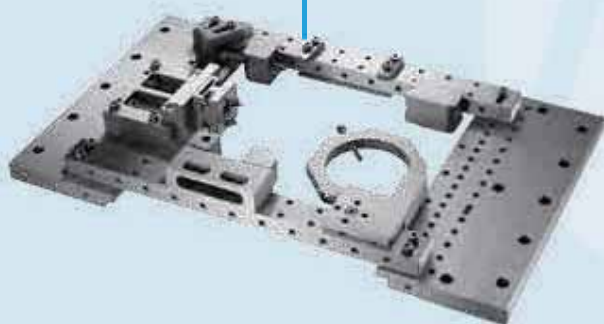
3A-200005



3A-200007

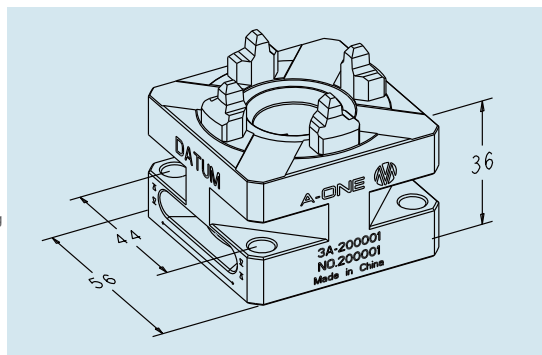


3A-200009



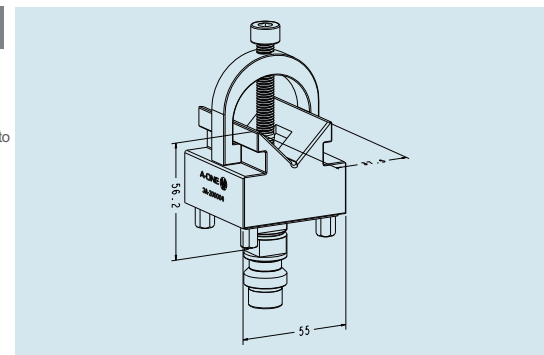
3A-200001 50 型手动卡盘 Quick chuck

- 规格** 系统尺寸 ITS 50, 手动, 不锈钢
- 连接** 4 个 M8 螺钉从背面或 4 个 M6 带螺母的柱头螺钉
- 应用** 在电火花机 / 线切割机床上装夹精铣和磨过的工件
- 注意** 夹紧力高达 4000N
- Version** System size ITS 50, manual, corrosion resistant
- Attachment** 4×M8 from the rear or 4×M6 stud bolts with nuts
- Application** On EDM/WEDM centers for light milling and grinding workpiece
- Note** Clamping power 4000N



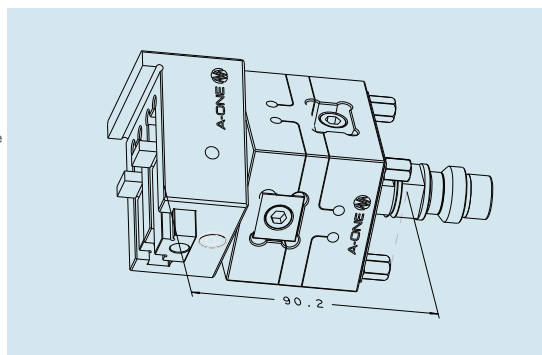
3A-200004 快速压紧式线割夹具 Rapid clamp holder for wire-cut EDM

- 规格** 可实现圆柱体工件的快速夹持定位加工方便、快捷
- 应用** 适用于各种品牌线割机
- Version** Quick clamp and position of round shape work piece to processing
- Application** To be used on all types of wire-cut EDM



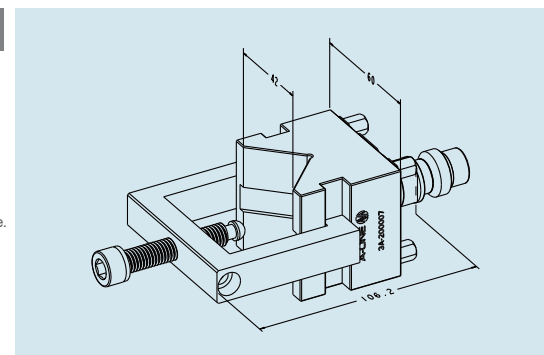
3A-200002 三向微调线割夹具 3 Axes high precision controljig

- 规格** X, Y, Z 多向精度微调。适合小型工件夹持定位
- 应用** 适用于各种品牌线割机
- Version** X, Y, Z axis precision control. Suitable for small work piece clamping position
- Application** To be used on all kinds of wire-cut EDM



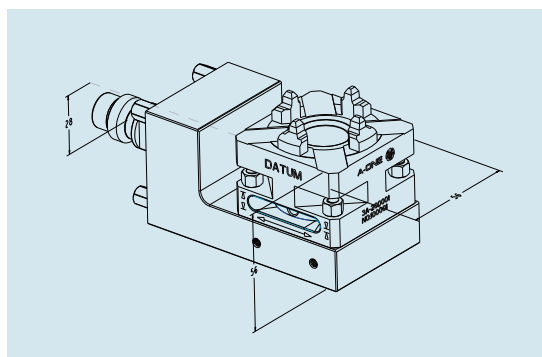
3A-200007 快速压紧式线割夹具 Rapid clamp holder for wire-cut EDM

- 规格** 可实现圆柱体工件的快速夹持定位加工方便、快捷
- 应用** 工件正反两面加工 (有相对位置要求) 适用于线割机, 加工中心
- Version** Quick clamp and positioning of round shape work piece. to processing
- Application** Changeover of holder allows four side cutting of work piece. To be used on wire-cut EDM or machining center



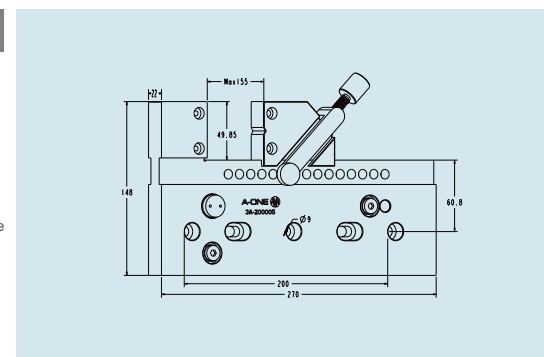
3A-200003 线割转向夹具座 Changeover holder

- 规格** 可由垂直加工转为水平式加工
- 应用** 加工方便、快捷 含卡盘 适用于各种线割机, 电火花
- Version** Can be changed from vertical position to horizontal position. Easy and quick change With chuck
- Application** To be used on all types of wire-cut EDM or EDM



3A-200005 可调式线割钳士 Adjustable vise

- 规格** 可在 X, Y, Z 多向精度微调
- 应用** 侧向夹持加工方便、快捷 适用于线割机, 直接安装在工作台上
- 附件** 含 T 型六角匙 1PCS
- Version** Precise adjustment to X, Y, Z axis Easy and quick clamping for side grip
- Application** Suitable to wire-cut EDM, to be directly installed on the table
- Accessories** T hexa wrench x 1 pc

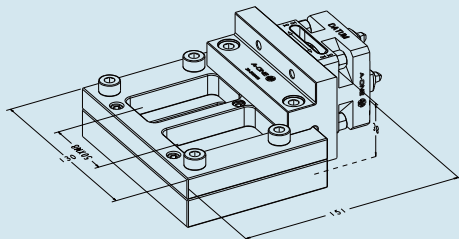


3A-200006 可调式线割夹具
Wire-cut vise

规格 可在 X、Y、Z 多向精度微调，手动锁紧功能，含卡盘
应用 适用于各种品牌线割机，直接安装在工作台上

Version Precise adjustment to X, Y, Z axis, Power manual lock, With chuck

Application Suitable to all types of wire-cut EDM, to be directly mounted on the table

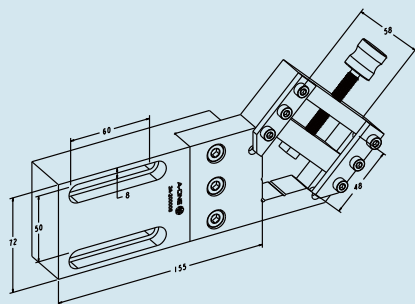


3A-200008 线割批士
Wire-cut vise

规格 可微调。精准，夹持工件方便，快捷
应用 适用于线切割机，直接安装在工作台上

Version Precise adjustment, and quick to clamp

Application Suitable to wire-cut EDM, to be directly mounted on the table

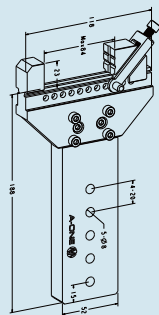


3A-200009 线割批士
Wire-cut vise

规格 可微调。精准，夹持工件方便，快捷
应用 适用于线切割机，直接安装在工作台上

Version Precise adjustment, and quick to clamp

Application Suitable to wire-cut EDM, to be directly mounted on the table

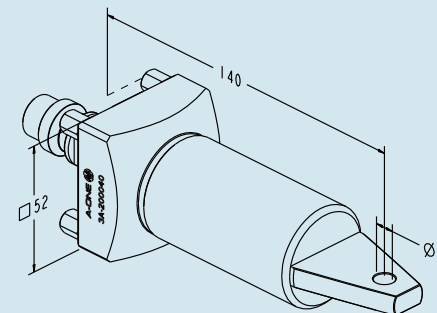


3A-200040 基准杆
Reference pin UnoSet

规格 硬质，磨削，孔 $\Phi 8\text{mm}$
应用 水平卡盘上确定测量基准

Version Hardened, ground, borehole $\Phi 8\text{ mm}$.

Application To determine reference measurements on horizontal chucks.



3A-200041 虎钳 40mm
Vise PalletSet W 40mm

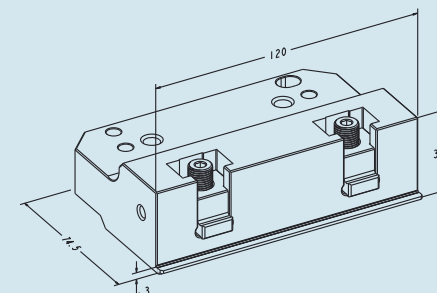
规格 虎钳，带从上部连接的固定 Z 支撑和夹爪。硬质，磨削。
夹持 最大 $150 \times 150 \times 40\text{mm}$
最大负载 12kg
应用 侧面夹持尺寸 $0-150\text{mm}$ 的工件。适用于固定式夹头或摆动式夹头

Version Vise with fixed Z-lip and jaws attached from above. Hardened and ground.

Clamping range max. $150 \times 150 \times 40\text{ mm}$.

Max. Load 12 kg

Application Lateral clamping of workpieces of $0-150\text{ mm}$ machined from the outside. To be fitted to fix or pendulum holders.



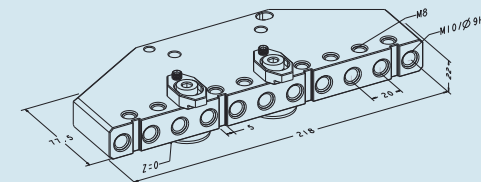
3A-200042 横梁托板
Beam pallet PalletSet W

规格 托板，适用于各类夹持元件。包括 Z 支撑和压板
应用 适用于固定式夹头或 3D 摆动式夹头
选项 棱形夹头和横梁虎钳夹持元件

Version Pallet to accommodate various clamping elements. Includes Z-supports and clips.

Application To be fitted to fix holders or pendulum holders 3D.

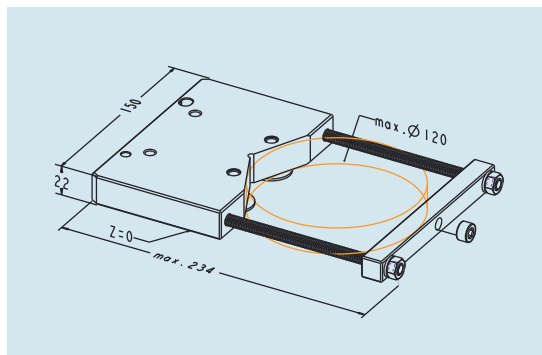
Options Prism holders and BeamVise clamping elements.



3A-200046 棱形夹头 120mm
Prism holder 120mm PalletSet W

规格 带可分离 Z 支撑的棱形夹持元件
应用 夹持最大尺寸至 $\Phi 120\text{mm}$ 圆柱形工件
安装 直接安装于固定式夹头或摆动式夹头
注意 最大负载 : 10kg

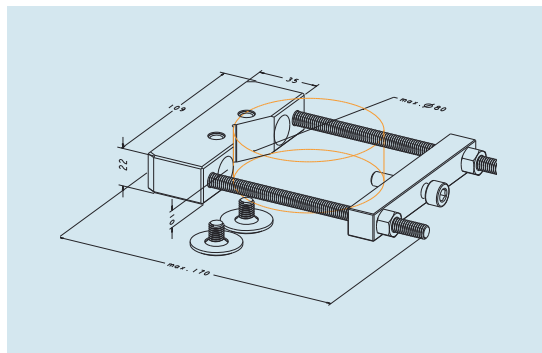
Version 3Prism and clamping bars with detachable Z-supports.
Application To clamp cylindrical workpieces of up to $\Phi 120\text{mm}$.
Mounting directly to fixholder or pendulum holder.
Note Max. load: 10 kg.



3A-200048 棱形夹头 80
Prism holder 80 PalletSet W

规格 带可分离 Z 支撑的棱形夹持元件
应用 夹持最大尺寸至 $\Phi 80\text{mm}$ 的圆柱形工件
安装 安装于横梁托板 3A-200042 或夹紧梁的前部
注意 最大负载 : 6kg

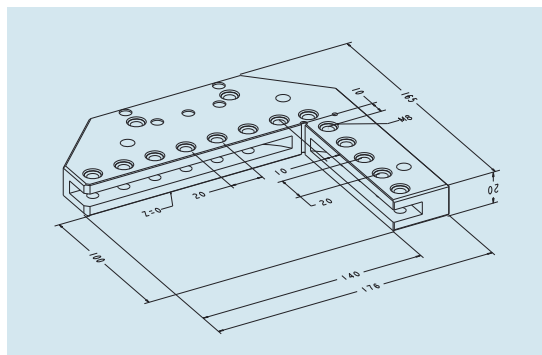
Version Prism and clamping part with detachable Z-supports.
Application Clamping of cylindrical workpieces of up to $\Phi 80\text{mm}$.
Mounting To be fitted to the front of beam pallet ER-018937 or clamping beams (cf. p 213).
Note Max. load: 6 kg.



3A-200047 万能虎钳方形块
UniVise square PalletSet W

规格 方形块, 带所有的夹持附件
应用 适用于固定式夹头或摆动式夹头
注意 最大负载 : 10kg

Version Square with all the clamping accessories.
Application To be fitted to fix holders or pendulum holders.
Note Max. load: 10 kg.

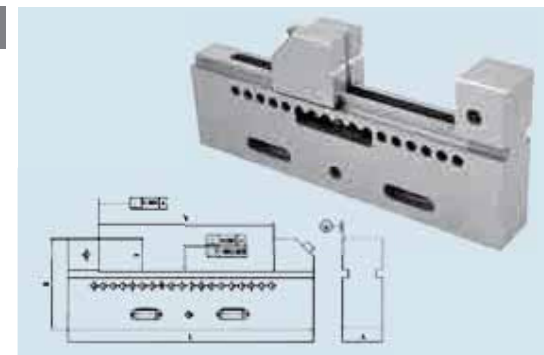


不锈钢工具平钳
Stainless steel vise

规格 普通型
应用 适用于线切割

Version Regular type
Application To be used on wire-cut EDM

编号 Model No.	A(mm)	h(mm)	H(mm)	W(mm)	L(mm)
3A-200016	31.5	30	85	50	120
3A-200017	31.5	30	90	100	170
3A-200018	32	35	100	150	226
3A-200019	35.5	40	100	214	300

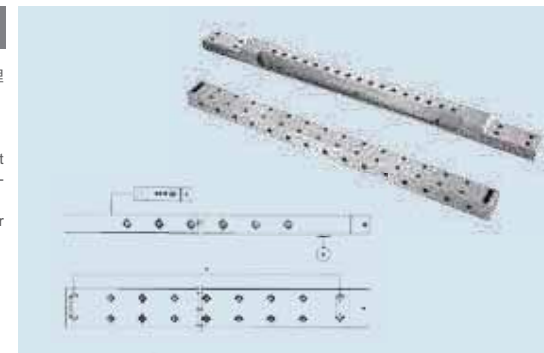


多用途导轨
Multiduty clamp

规格 材料为马氏体不锈钢, 热处理: 真空淬火 + 深冷处理 HRC50-55
应用 线切割机床上装夹精铣和磨过的工件

Version Material is Martensitic stainless steel, heat treated, vacuum quenching, cold process with HRC50-55
Application The workpiece which mounted on WEDM that has been milling and grinding work

编号 Model No.	A(mm)	H(mm)	L(mm)	孔间距 Hole spacing
3A-200026	46	25	440	30*60
3A-200027	46	35	590	30*60
3A-200028	50	40	740	30*80

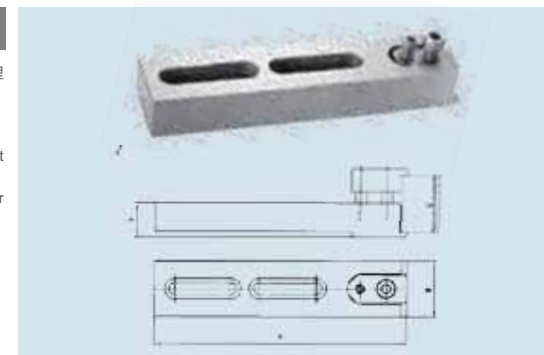


方型夹紧和件
Square support

规格 材料为马氏体不锈钢, 热处理: 真空淬火 + 深冷处理 HRC50-55
应用 线切割机床上装夹精铣和磨过的工件

Version Material is Martensitic stainless steel, heat treated, vacuum quenching, cold process with HRC50-55
Application The workpiece which mounted on WEDM that has been milling and grinding work.

编号 Model No.	A(mm)	B(mm)	H(mm)	L(mm)
3A-200029	200	40	30	5<L<50
3A-200030	300	50	40	50<L<100



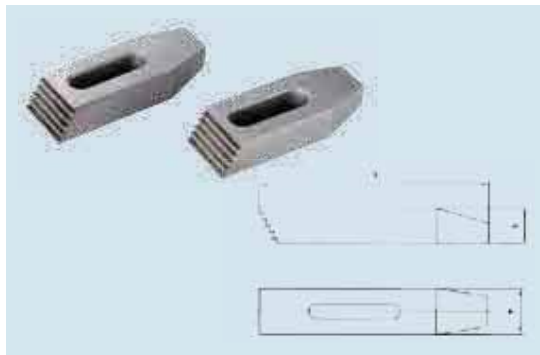
不锈钢压块
Stainless steel plate

规格 材料为马氏体不锈钢, 热处理: 真空淬火 + 深冷处理 HRC50-55
应用 铣床、磨床、电火花或线切割机床

Version Material is Martensitic stainless steel, heat treated, vacuum quenching, cold process with HRC50-55

Application Milling, grinding or EDM/WEDM machines, in dividers and fixtures

编号 Model No.	L(mm)	W(mm)	H(mm)
3A-200031	70	25	15
3A-200032	100	25	15



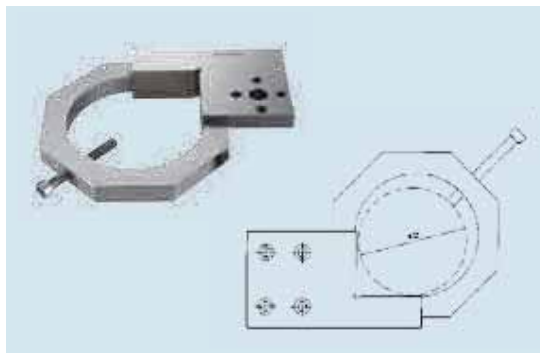
圆形夹紧件
Circular power clamp

规格 材料为马氏体不锈钢, 热处理: 真空淬火 + 深冷处理 HRC50-55
应用 线切割机床上装夹精铣和磨过的工件

Version Material is Martensitic stainless steel, heat treated, vacuum quenching, cold process with HRC50-55

Application The workpiece which mounted on WEDM that has been milling and grinding work.

编号 Model No.	ΦD(mm)
3A-200033	10-50
3A-200034	50-100



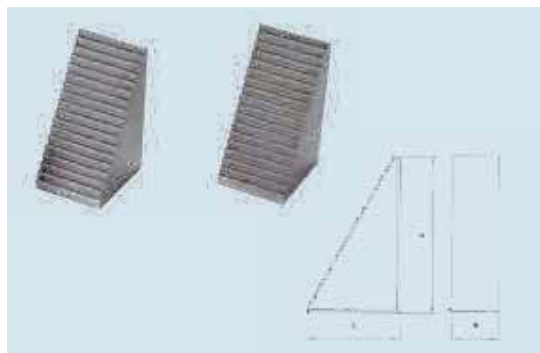
不锈钢角度垫块
Stainless steel angle block

规格 材料为马氏体不锈钢, 热处理: 真空淬火 + 深冷处理 HRC50-55
应用 铣床、磨床、电火花或线切割机床

Version Material is Martensitic stainless steel, heat treated, vacuum quenching, cold process with HRC50-55

Application Milling, grinding or EDM/WEDM machines, in dividers and fixtures

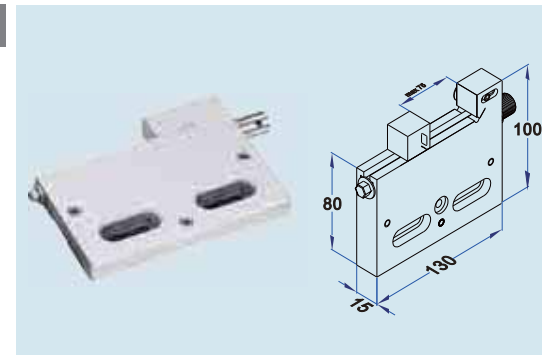
编号 Model No.	L(mm)	W(mm)	H(mm)
3A-200037	31	25	51
3A-200038	44	25	72
3A-200039	55	25	92



3A-210001 手动超薄慢走丝夹具 (虎钳)
Manual ultra-thin walking wire clamp

适用于各种线切割机床上的工件夹持
手动夹持工件使用方便灵活, 适用于小零件加工, 设计厚度为 13mm, 适用于端子零件

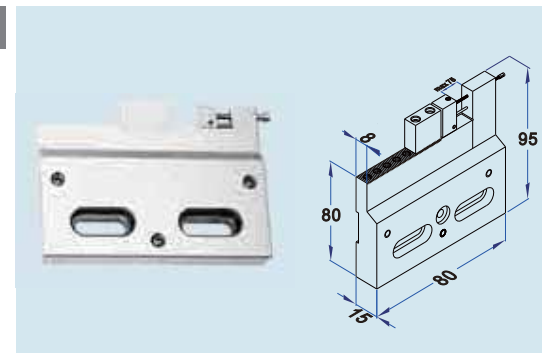
Accurate clamping is possible single body construction.
Designed for ease of use, short and small compact in size



3A-210002 超薄慢走丝夹具 (虎钳)
Ultra-thin walking wire clamp

适用于各种线切割机床上的工件夹持
主体可以微调, 操作方便灵活

Accurate clamping is possible single body construction
Designed for ease of use, short and small compact in size



3A-210003 手动慢走丝夹具 (虎钳)
Manual walking wire clamp (vise)

夹具材质为马氏体不锈钢, 具有抗腐蚀和耐磨损的特点
手动设计使用方便灵活, 适用于小零件加工
夹持范围: 0-100mm

The hold down feature prevents the work piece from lifting
Accurate clamping is possible single body construction
Designed for ease of use, short and small compact in size

材质 Material	硬度 Hardened	平行度 Parallelism	垂直度 Squareness
马氏体不锈钢 SUS440	HRC50-55°	0.005/100mm	0.005/100mm



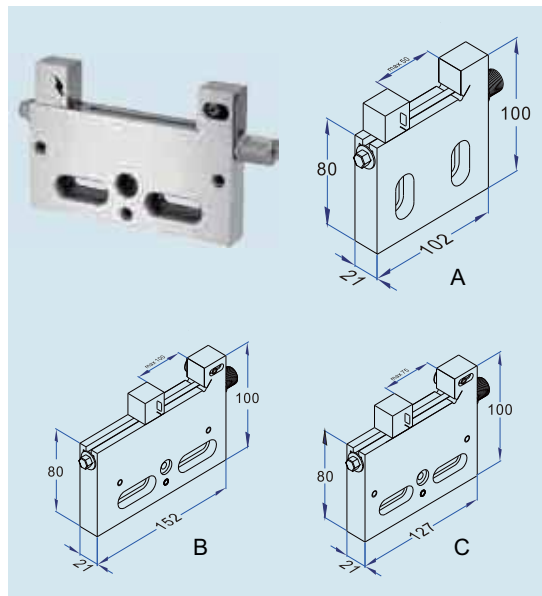
3A-210006 手动慢走丝夹具 (虎钳)
Manual walking wire clamp (vise)

夹具材质为马氏体不锈钢, 具有抗腐蚀和耐磨损的特点
手动设计使用方便灵活, 适用于小零件加工

The hold down feature prevents the work piece from lifting
Accurate clamping is possible single body construction
Designed for easy of use, short and samll compact in size

材质 Material	硬度 Hardened	平行度 Parallelism	直角度 Squareness
马氏体不锈钢 SUS440	HRC50-55°	0.005/100mm	0.005/100mm

规格 Model	外形尺寸 Size(mm)	最大夹持 Clamping(mm)
A	100X102X21	50
B	100X152X21	100
C	100X127X21	75

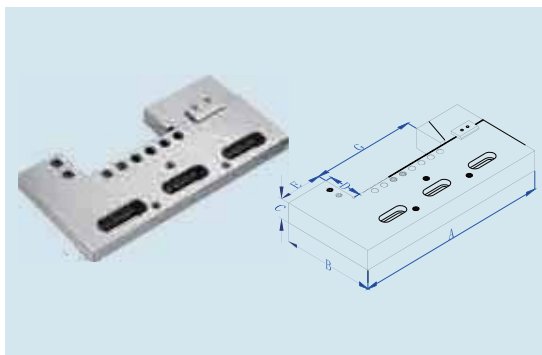


3A-210007 强力慢走丝夹具 (虎钳)
Power walking wire clamp (vise)

夹具材质为马氏体不锈钢, 具有抗腐蚀和耐磨损的特点
采用特殊的斜角设计, 夹持力强

Short and small, it's compact size is perfect for small work pieces
Accurate clamping is possible single body construction. Designed for ease of use, short and samll compact in size

Model	100	150
A	270	320
B	135	135
C	22	22
D	50	50
E	50	75
G(max)	100	150
weight(kg)	4	5.5
maximumload(kg)	10	12



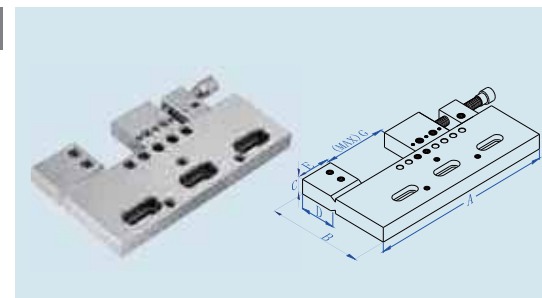
材质 Material	硬度 Hardened	平行度 Parallelism	直角度 Squareness
马氏体不锈钢 SUS440	HRC50-55°	0.005/100mm	0.005/100mm

3A-210008 手动慢走丝夹具 (虎钳)
Manual walking wire clamp (vise)

适用于各种线切割机床上的工件夹持
手动设计操作方便灵活, 减少工件装夹时间, 提升生产效率

The dive pin lock structure is attached to the screw holder, so quick clamping is possible
To make it easy to use, it has a simple design

Model	100	150
A	247	320
B	145	145
C	22	22
D	50	60
E	60	60
G(max)	100	150
weight(kg)	4.5	6
maximumload(kg)	8	10



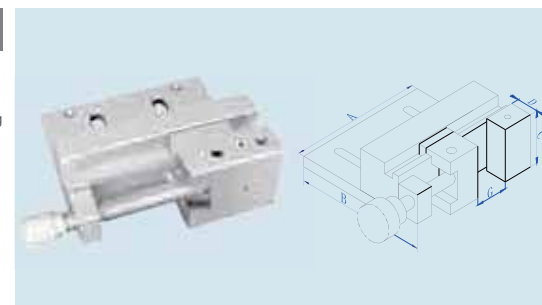
材质 Material	硬度 Hardened	平行度 Parallelism	直角度 Squareness
马氏体不锈钢 SUS440	HRC50-55°	0.005/100mm	0.005/100mm

3A-210010 手动直角万力
Manual square vise

适用于线切割机床加工各种零件
主体为马氏体不锈钢, 淬火后深冷, 具有防锈与耐磨损能力

The dive pin lock structure is attached to the screw holder, so quick clamping is possible
To make it easy to use, it has a simple design

Model	25	30
A	175	185
B	140	140
C	54	70
D	30	35
E	-	-
G(max)	82	100
weight(kg)	3.7	4.5
maximumload(kg)	5	8



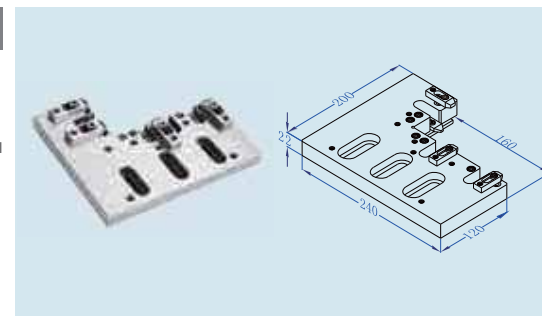
材质 Material	硬度 Hardened	平行度 Parallelism	直角度 Squareness
马氏体不锈钢 SUS440	HRC50-55°	0.005/100mm	0.005/100mm

3A-210011 直角万力
Square vise

适用于线切割机床加工各种板类零件与圆形零件
主体为马氏体不锈钢, 淬火后深冷, 具有防锈与耐磨损能力

The two step clamp type can be adjusted for use even on a thin material workpiece
It can be freely used both on the right and left
A substrate stopper that can be easily attached or removed is included

Weight(kg)	Maximumload(kg)	材质 Material	硬度 Hardened	平行度 Parallelism	直角度 Squareness
5.4	12	马氏体不锈钢 SUS440	HRC50-55°	0.005/100mm	0.005/100mm



3A-210012

手动慢走丝虎钳
Manual walking wire vise

适用于各种线切割机床上的工件夹持
手动设计操作方便灵活，减少工件装夹时间，提升生产效率
夹持范围：0-150mm

The dive pin lock structure is attached to the screw holder, so quick clamping is possible
To make it easy to use, it has a simple design

Weight (kg)	Maximum load (kg)	Material	Hardened	Parallelism	Squareness
2.8	8	马氏体不锈钢 SUS440	HRC50-55°	0.005/100mm	0.005/100mm

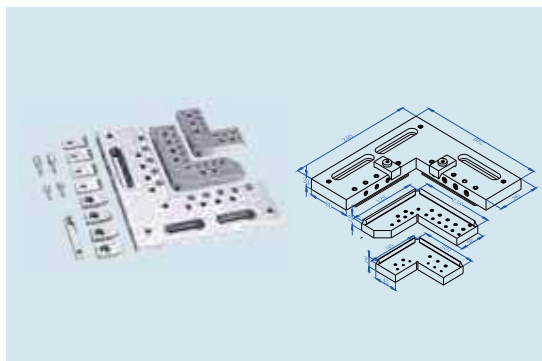


3A-210013

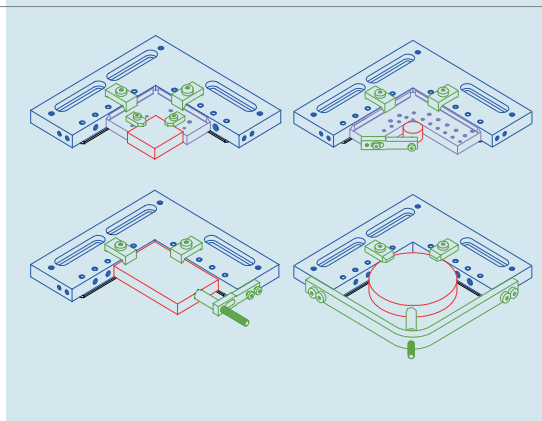
组合直角万力
Combination square vise

适用于线切割机床加工各种板类零件与圆形零件
主体为马氏体不锈钢，淬火后深冷，具有防锈与耐磨能力

For linear cutting machine to process various types of sheet parts and round parts
Body of martensitic stainless steel, deep cooling after quenching, with rust and abrasion resistance



装夹示意图
Clamping sketch



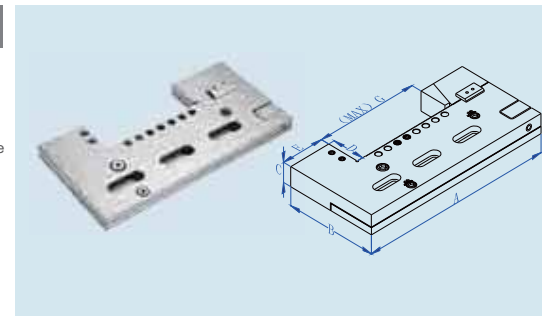
3A-210015

可调线切割夹具 (虎钳)
Adjustable wire-cut clamp (vise)

夹具材质为马氏体不锈钢，具有抗腐蚀和耐磨损的特点
采用特殊的斜角设计，夹持力强
夹具本体具有水平 / 平行 X、Y、Z 三轴微调功能

Short and small, it's compact size is perfect for small work pieces
Clamping force works to 45degree obliquely downward and it prevents the work piece from lifting

Size(mm)	Model	100	160
A		270	350
B		170	170
C		24	24
D		50	60
E		60	80
G(max)		100	160
weight(kg)		5.4	7.8
maximumload(kg)		6	10



Material	Hardened	Parallelism	Squareness
马氏体不锈钢 SUS440	HRC50-55°	0.005/100mm	0.005/100mm

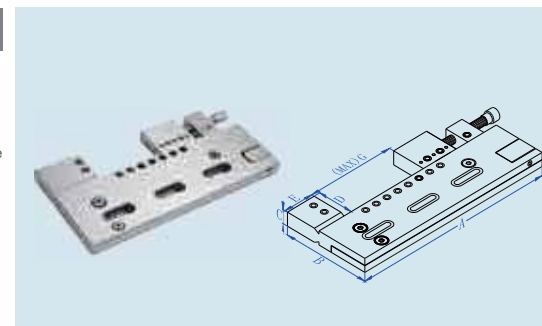
3A-210016

手动可调线切割夹具 (虎钳)
Manual adjustable wire-cut clamp(vise)

夹具材质为马氏体不锈钢，具有抗腐蚀和耐磨损的特点
手动夹持设计，操作方便、灵活、简单，提升生产效率
夹具本体具有水平 / 平行 X、Y、Z 三轴微调功能

Short and small, it's compact size is perfect for small work pieces
Clamping force works to 45degree obliquely downward and it prevents the work piece from lifting

Size(mm)	Model	100	160
A		260	350
B		170	170
C		24	24
D		50	60
E		60	80
G(max)		100	160
weight(kg)		4.8	7
maximumload(kg)		6	10



Material	Hardened	Parallelism	Squareness
马氏体不锈钢 SUS440	HRC50-55°	0.005/100mm	0.005/100mm

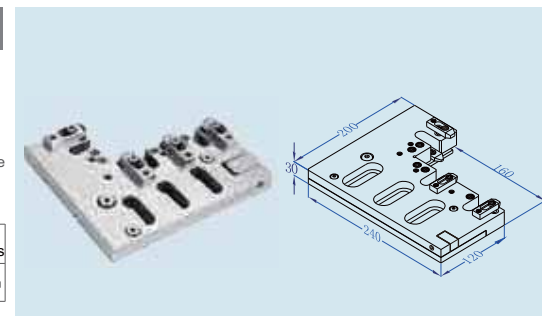
3A-210018

可调线切割夹具 (虎钳)
Adjustable wire-cut clamp (vise)

夹具材质为马氏体不锈钢，具有抗腐蚀和耐磨损的特点
夹具本体具有水平 / 平行 X、Y、Z 三轴微调功能

Short and small, it's compact size is perfect for small work pieces
Clamping force works to 45degree obliquely downward and it prevents the work piece from lifting

Weight (kg)	Maximum load (kg)	Material	Hardened	Parallelism	Squareness
4.5	8	马氏体不锈钢 SUS440	HRC50-55°	0.005/100mm	0.005/100mm

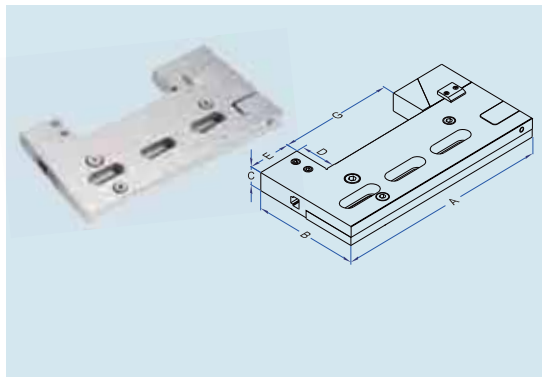


3A-210019 可调线切割夹具 (虎钳)
Adjustable wire-cut clamp (vise)

夹具材质为马氏体不锈钢, 具有抗腐蚀和耐磨损的特点
采用特殊的斜角设计, 夹持力强
夹具本体具有水平 / 平行 X、Y、Z 三轴微调功能

Short and small, it's compact size is perfect for small work pieces
Clamping force works to 45degree obliquely downward and it prevents the work piece from lifting

Model Size(mm)	100	160
A	240	300
B	160	160
C	24	24
D	50	50
E	60	60
G(max)	100	160
weight(kg)	5.4	7.8
maximumload(kg)	6	10



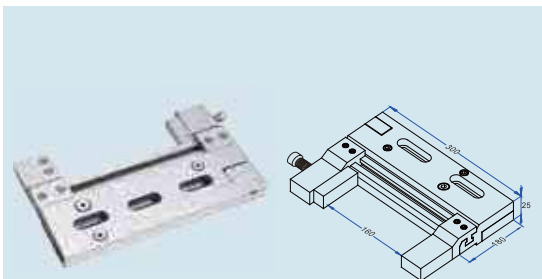
材质 Material	硬度 Hardened	平行度 Parallelism	直角度 Squareness
马氏体不锈钢 SUS440	HRC50-55°	0.005/100mm	0.005/100mm

3A-210020 可调组合线切割夹具 (虎钳)
Adjustable combination wire-cut clamp(vise)

夹具材质为马氏体不锈钢, 具有抗腐蚀和耐磨损的特点
采用特殊的斜角设计, 夹持力强
夹具本体具有水平 / 平行 X、Y、Z 三轴微调功能

Short and small, it's compact size is perfect for small work pieces
Clamping force works to 45degree obliquely downward and it prevents the work piece from lifting

材质 Material	硬度 Hardened	平行度 Parallelism	直角度 Squareness
马氏体不锈钢 SUS440	HRC50-55°	0.005/100mm	0.005/100mm



配送附件
Accessories

3A-210021 水平调节式通用底座
Horizontal adjustment type base plate

产品特点:

夹具采用了特殊球面支承, 简化了工件水平对中工作, 大大缩短了装夹时间, 提高了机械动作的效率。

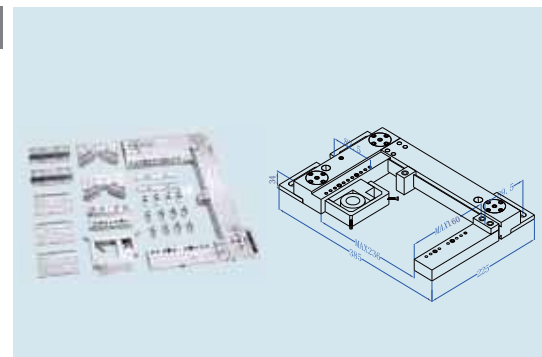
特别附件—夹具主体配合, 用于各种大小圆形零件的加工, 用于宽大平板的 L 块以及用于薄零件的钳口全部组合起来后, 可以更加有效地固定各种零件。

Features:

Through the adoption of special spherical bearings, horizontal centering of the work can be easily done, setup time is greatly shortened, and machine operation rate is improved.

Various works can be efficiently set by combining special accessories such as V block for large/small round work, L-type block for wide flat-plate work, and jaw, for thin work.

These are superior in rustproofing by adopting martensitic stainless steel(quenched/ground/finished)



3A-210022 横梁线切割夹具 (虎钳)
Beam wire-cut clamp (vise)

线切割虎钳与横梁配合使用, 钳口是可移动设计, 可夹持更大的工件, 操作方便快捷

Linear cutting vise is used in conjunction with beam; jaw with movable design, which can clamp larger workpieces



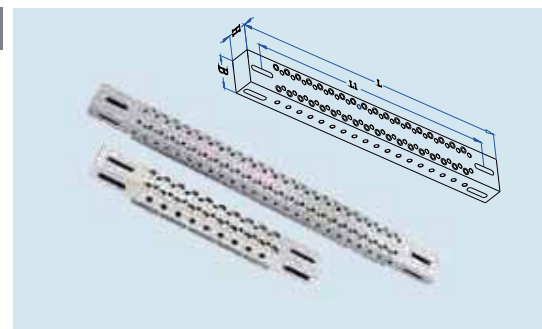
3A-210023 横梁
Beam

横梁适用于线切割机床大尺寸的零件加工, 产品可根据客户机床行程定做

2个一组可稳定固定平板零件
可配合 3A-210022 精密虎钳使用, 提升横梁的使用率

These are designed/manufactured in accordance with various work stands.
A flat-plate work can be stably fixed with one set of two pieces

Model Size(mm)	L	L1	B	H
**	370	-	50	25
**	450	-	50	30
**	550	-	50	30
**	650	-	60	35
**	750	-	60	40
**	950	-	80	45
weight(kg)	-	-	-	-
maximumload(kg)	-	-	-	-



L1 尺寸根据机床工作台中心距确定
The size of L1 according to machine table center distance

材质 Material	硬度 Hardened	平行度 Parallelism	直角度 Squareness
马氏体不锈钢 SUS440	HRC50-55°	0.005/100mm	0.005/100mm

3A-210024

横梁
Beam

横梁适用于线切割机大尺寸的零件加工，产品可根据客户机床行程定做

These are designed/manufactured in accordance with various work stands

Moder	Size(mm)	L	L1	B	H
**	370	-	45	30	
**	450	-	60	30	
**	550	-	60	30	
**	650	-	80	36	
**	750	-	80	36	
**	950	-	80	40	
weight(kg)	-	-	-	-	
maximumload(kg)	-	-	-	-	



3A-210025

横梁
Beam

横梁适用于线切割机大尺寸的零件加工，产品可根据客户机床行程定做

These are designed/manufactured in accordance with various work stands

Moder	Size(mm)	L	L1	B	H
**	370	-	45	30	
**	450	-	60	30	
**	550	-	60	30	
**	650	-	80	36	
**	750	-	80	36	
**	950	-	80	40	
weight(kg)	-	-	-	-	
maximumload(kg)	-	-	-	-	



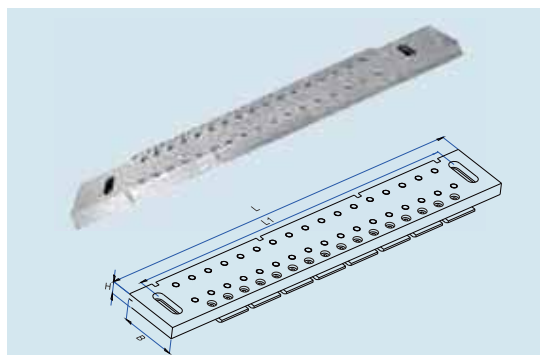
3A-210026

横梁
Beam

横梁适用于线切割机大尺寸的零件加工，产品可根据客户机床行程定做

These are designed/manufactured in accordance with various work stands

Moder	Size(mm)	L	L1	B	H
**	370	-	90	22	
**	450	-	90	22	
**	550	-	90	25	
**	650	-	90	25	
**	750	-	90	25	
**	950	-	90	30	
weight(kg)	-	-	-	-	
maximumload(kg)	-	-	-	-	



3A-210027

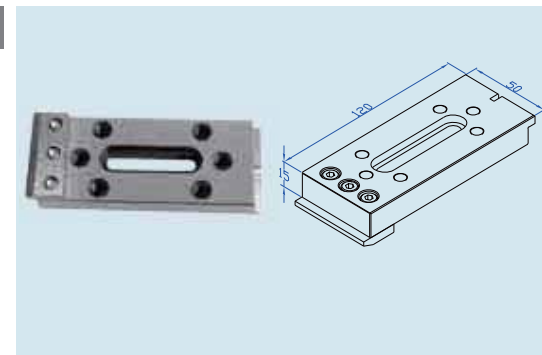
一目治具
A mesh fixture

适用于线切割机床装夹各类零件加工
推荐工件最大重量为 20kg

规格 120X50X15 150X50X15
180X50X15 120X60X15

For linear cutting machine to clamp all kinds of machining parts
Recommended maximum workpiece weight 20kg

Version 120X50X15 150X50X15
180X50X15 120X60X15



3A-210028

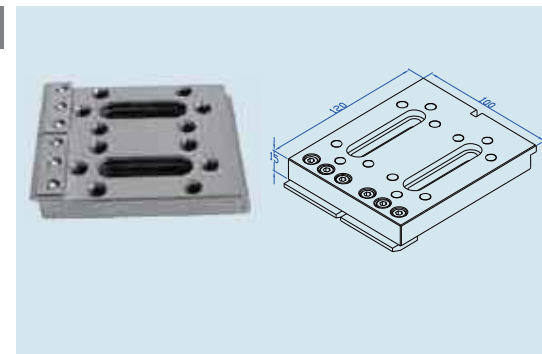
二目治具
Binary fixture

适用于线切割机床装夹各类零件加工
推荐工件最大重量为 20kg

规格 120X100X15

For linear cutting machine to clamp all kinds of machining parts
Recommended maximum workpiece weight 20kg

Version 120X100X15



3A-210029

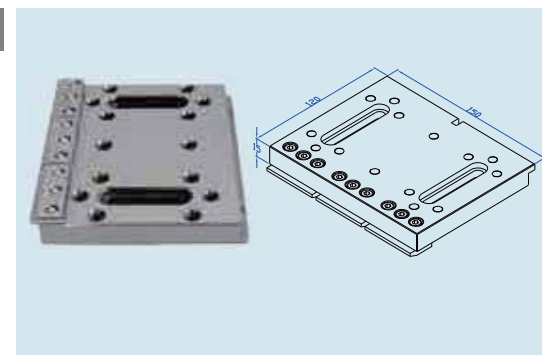
三目治具
The ternary fixture

适用于线切割机床装夹各类零件加工
推荐工件最大重量为 20kg

规格 120X150X15

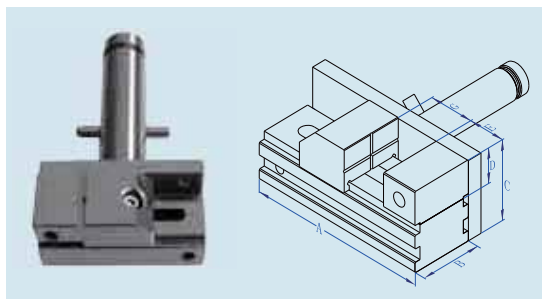
For linear cutting machine to clamp all kinds of machining parts
Recommended maximum workpiece weight 20kg

Version 120X150X15



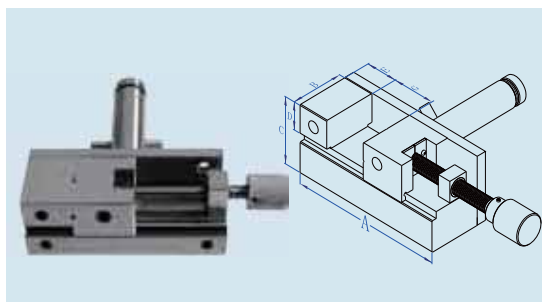
3A-210033 不锈钢电极万力
Electrode holder(stainless steel)

Model	1.0"	1.5"	2.0"
Size(mm)			
A	65	100	135
B	25	35	50
C	30	35	50
D	12	16	24
E	18	25	30
G(max)	20	45	60
weight(kg)	-	-	-
maximumload(kg)	-	-	-



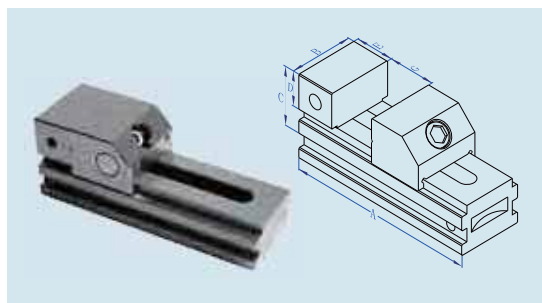
3A-210034 手动不锈钢电极万力
Electrode holder(stainless steel)

Model	1.5"	2.0"
Size(mm)		
A	100	135
B	35	50
C	35	50
D	16	24
E	25	30
G(max)	45	60
weight(kg)	-	-
maximumload(kg)	-	-



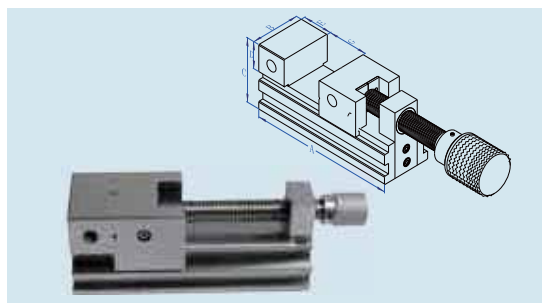
3A-210035 不锈钢工具万力
Tool maker vise(stainless steel)

Model	15	20	25	30	40
Size(mm)					
A	100	140	172	190	230
B	35	48	63	73	98
C	40	50	60	70	80
D	20	25	30	35	40
E	25	25	30	35	40
G(max)	45	75	90	100	125
weight(kg)	-	-	-	-	-
maximumload(kg)	-	-	-	-	-



3A-210036 手动不锈钢工具万力
Tool maker vise(stainless steel)

Model	20	25	30	40
Size(mm)				
A	140	100	180	230
B	48	65	73	98
C	55	69	78	92
D	25	30	35	45
E	25	30	35	40
G(max)	-	-	-	-
weight(kg)	-	-	-	-
maximumload(kg)	-	-	-	-



3A-210037 慢走丝工作台
WEDM-LS table

材料为马氏体不锈钢，热处理：调质 HB225-245，是线切割机床最主要的组成部分之一按要求定制

Material of martensitic stainless steel, heat treated, quenched HB225-245. It is one of the most important parts of WEDM. Customized according to requirements



3A-210038 慢走丝工作台
WEDM-LS table

材料为马氏体不锈钢，热处理：调质 HB225-245，是线切割机床最主要的组成部分之一按要求定制

Material of martensitic stainless steel, heat treated, quenched HB225-245. It is one of the most important parts of WEDM. Customized according to requirements



3A-210039 夹紧支承千斤顶
Clamping jack

适用于 WEDM 慢走丝线切割机床
针对加工零件的厚度不同，夹紧支承千斤顶可以灵活调节高度，方便稳定可靠

For WEDM machine tool
Height of clamping bearing jack can be adjusted in terms of different thickness of machined parts, which is convenient and reliable



3A-210040 夹紧架高螺丝
Clamping screw

适用于 WEDM 慢走丝线切割机床
针对加工零件的厚度不同，架高螺丝可以灵活调节高度，方便稳定可靠

For WEDM machine tool
Height of clamping overhead screw can be adjusted in terms of different thickness of machined parts, which is convenient and reliable

