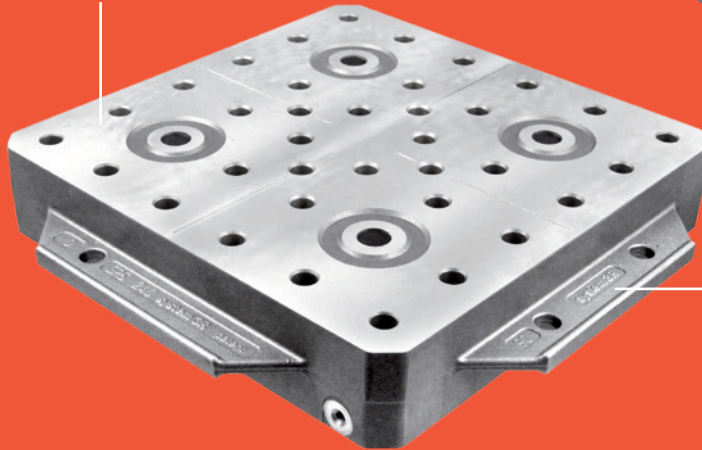
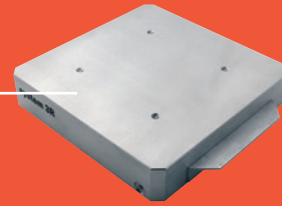


GPS 240 in detail

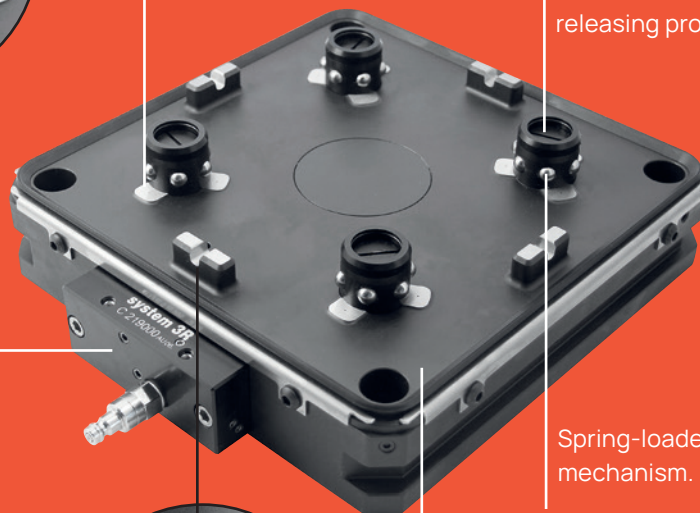
Die-cast aluminium pallets
(standardised hole pattern or
solid).



Pallet with handles for manual
handling or automated pallet
changing by robot.



Z-references are cleaned by air
blasted through the chuck's Z-
reference nozzles.

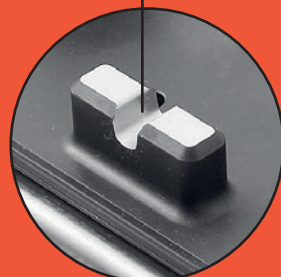


When loading heavy workpieces, a lifting
mechanism that operates on clamping/
releasing protects the references.

Connection block.

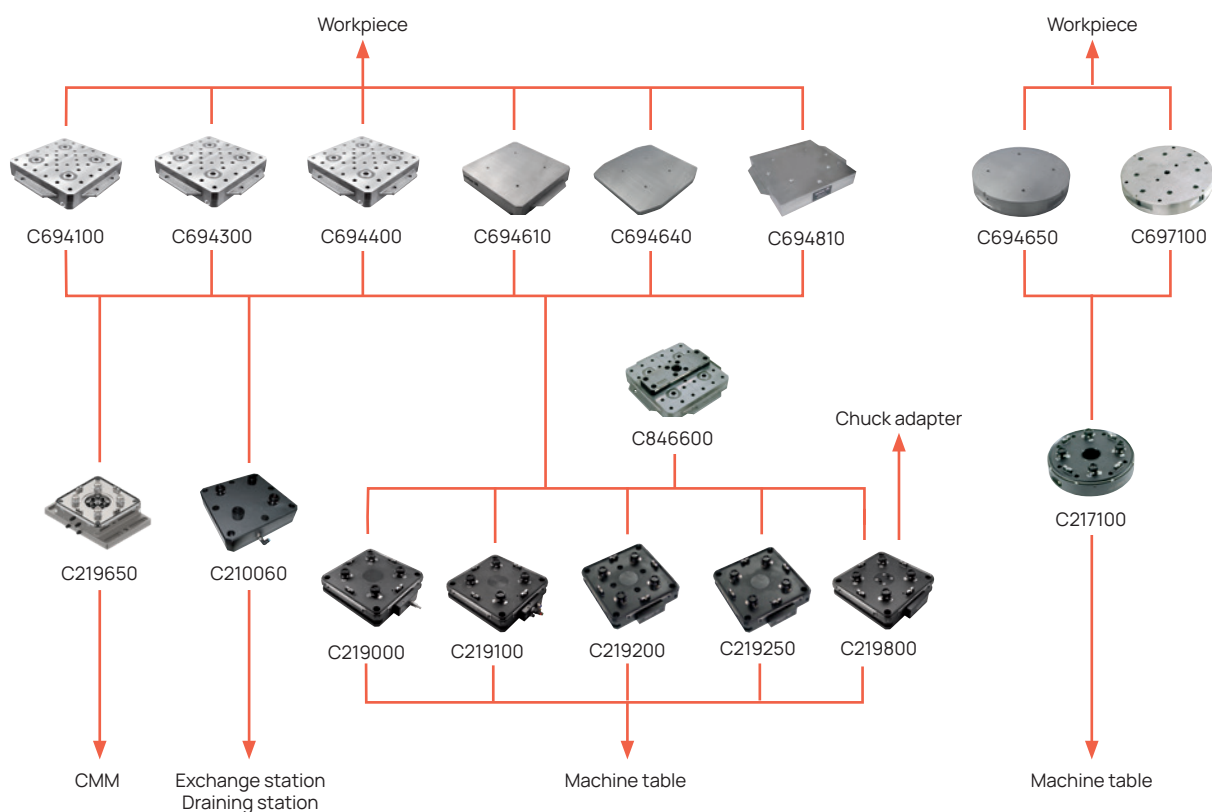
Spring-loaded, air-released clamping
mechanism.

Hardened, one-piece
(for maximum stabil-
ity) chuck body with
prisms for X and Y
centring. Has 4x90°
indexing.



Chuck-pallet interface com-
pletely sealed against dirt
and swarf penetration.

GPS 240 – Chucks & pallets



Square chucks	Article number	Feature
Pneumatic manual	C219000	for manual machining operations
Pneumatic automatic/manual	C219100	for manual and automatic machining operations
Pneumatic automatic/manual	C219200	connection from below
Pneumatic automatic/manual	C219250	connection from below
Pneumatic automatic/manual	C219650	built-in pneumatic Macro chuck
Pneumatic automatic/manual	C219800	connection from below, air dock 2-fold
Pneumatic automatic/manual	C210060	dummy chuck

Round chucks	Article number	Feature
Pneumatic manual	C217100	through hole Ø54 mm

Square pallets	Article number	Feature	Size (mm)
Cast aluminium	C694100		240x240
Cast aluminium	C694300	ground	240x240
Cast aluminium	C694400		240x240
Solid aluminium	C694610		240x240
Solid aluminium	C694640		300x300
Solid aluminium	C694810	ground	240x240

Round pallets	Article number	Feature	Size (mm)
Cast aluminium	C694650	ground	Ø256
Solid aluminium	C697100	ground	Ø256

/// Pallet with coined cams

⊙ Pallet with spring-loaded pin

⌒ Pallet with springy hardened cams

GPS 240 – Chucks

GPS 240 Chucks

- Built-up height 52 mm
- Required air pressure 6 bar
- Air-blast cleaning of the references
- Weight 17 kg.

C219000

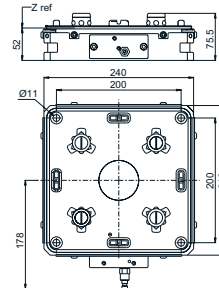
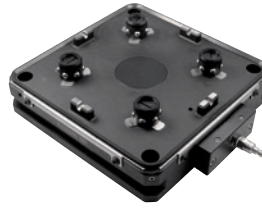
For manual machining operations.

- One air connection
- Clamping force 25.000 N
- Recommended actuator C810820 or C810710.

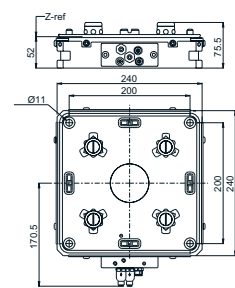
C219100

For manual and automatic machining operations.

- 5 air connections
- Clamping force 25.000 N/50.000 N
- Recommended actuator C810830.



C219000

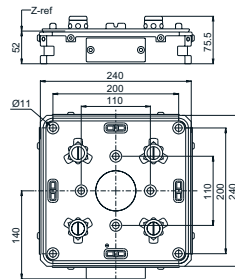
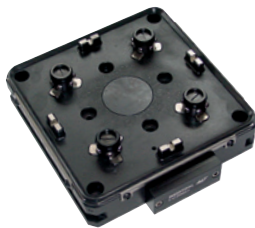


C219100

GPS240 Chuck automatic, C219200

For manual and automatic machining operations.

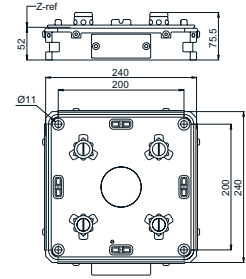
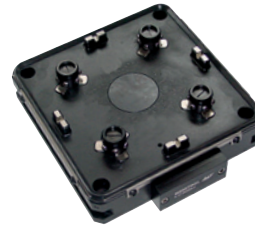
- Built-up height 52 mm
- Fixation holepattern 110x110mm for small rotary tables and 200x200 mm for larger machine tables
- Air connections positioned centrally on the bottom – prism – air-blast cleaning of Z-references – clamping/ releasing – Turbo/ventilation
- Clamping force 25.000 N/50.000 N
- Weight 17 kg.



GPS240 Chuck automatic, C219250

For manual and automatic machining operations.

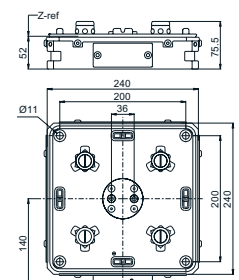
- Built-up height 52 mm
- Fixation holepattern 200x200 mm only
- Air connections positioned centrally on the bottom – prism – air-blast cleaning of Z-references – clamping/ releasing – Turbo/ventilation
- Clamping force 25.000 N/50.000 N
- Weight 17 kg.



GPS 240 Chuck automatic with air dock, C219800

For manual and automatic machining operations.

- Built-up height 52 mm
- Air connections positioned centrally on the underside – prism – air-blast cleaning of Z-references – clamping/ releasing – Turbo/ventilation
- Air dock: 2-fold, pneumatic 6 bar.
- Clamping force 25.000 N/50.000 N
- Weight 17 kg.

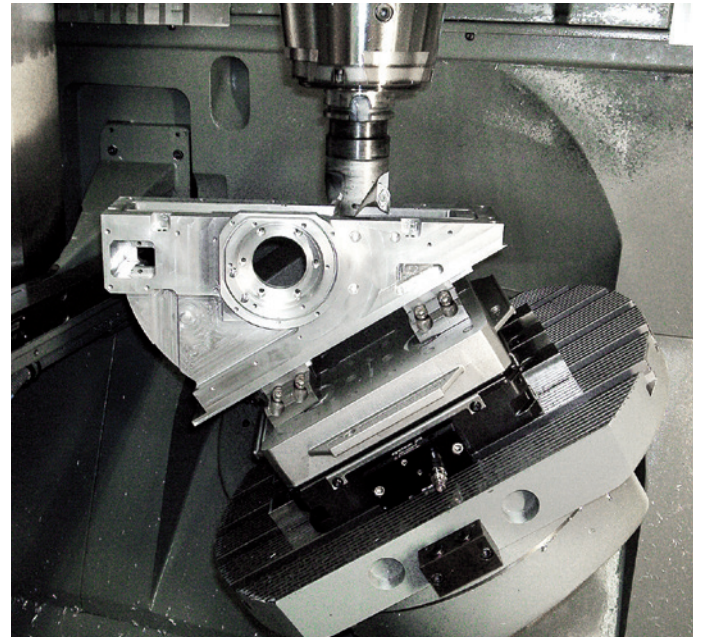
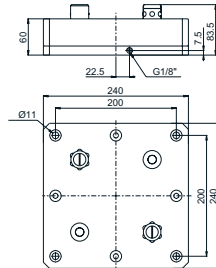


GPS 240 – Chucks

GPS 240 Dummy chuck, C210060

Dummy chuck for clamping a GPS 240 pallet on a exchange or draining station.

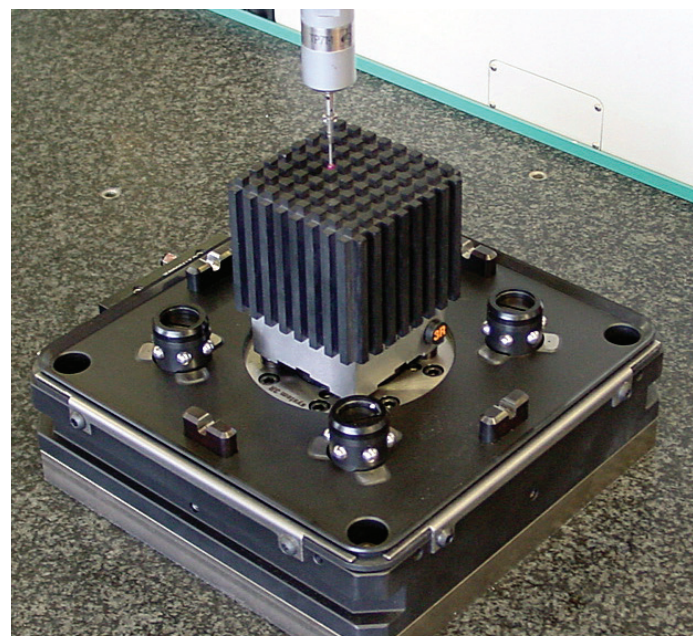
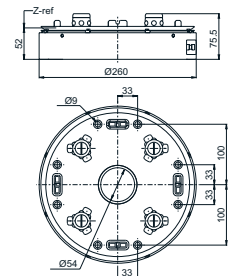
- Required air pressure 6 bars (± 1)
- Weight 9.5 kg.



GPS 240 Chuck manual round with hole Ø54 mm, C217100

Pneumatic chuck for applications in lathes and milling machines.

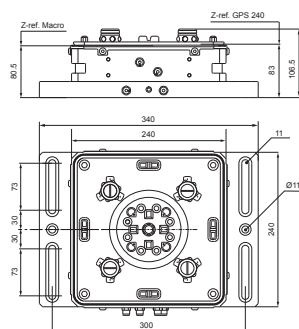
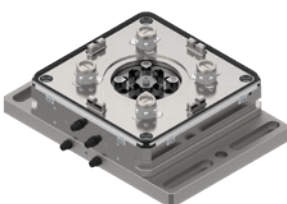
- Built-up height 52 mm
- Required air pressure 6 bars (± 1)
- Air-blast cleaning of Z-references
- Clamping force 25.000 N
- Recommended control unit C810820 or C810710
- Weight 16 kg.



GPS 240 Pneumatic chuck with built-in Macro chuck, C219650

Pneumatic chuck with built-in Macro chuck. Intended mainly for measuring machines. The following pallets can be mounted in GPS 240 by means of C219650 Macro 54x54 mm and Macro 70x70 mm.

- Required air pressure 6 bars (± 1)
- Air-blast cleaning of the references
- Weight 24 kg.

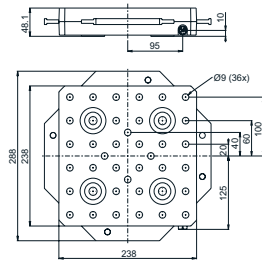
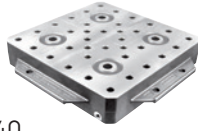


GPS 240 – Pallets

GPS 240 Pallet EDM/Grinding, C694100

Cast aluminium pallet.

- Construction height 48.1 ± 0.01 mm
- X/Y-centring with spring-loaded pin
- Adapted for automatic changing
- Ready for code carrier fixture C960740
- Supplied with C531500 sealing plugs.
- Recommended workpiece weight 150 kg.
- Weight 4.8 kg.



S500090

- C694100 supplied in sets of 4 pcs.

S500100

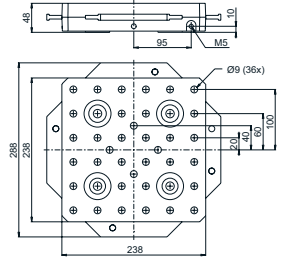
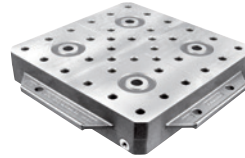
- C694100 supplied in sets of 10 pcs.



GPS 240 Pallet 'Adaption', C694300

Ground cast aluminium pallet. Suitable for fixtures.

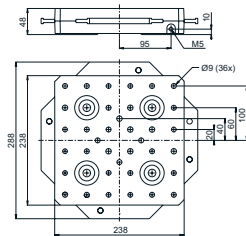
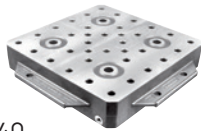
- Construction height 48.0 ± 0.005 mm
- X/Y-centring with spring-loaded pin
- Adapted for automatic changing
- Ready for code carrier fixture C960740
- Supplied with C531500 sealing plugs.
- Recommended workpiece weight 150 kg.
- Weight 4.8 kg.



GPS 240 Pallet 'Production', C694400

Cast aluminium pallet. Suitable for high-speed milling and arduous milling operations.

- Construction height 48.0 ± 0.01 mm
- X/Y-centring with coined cam
- Adapted for automatic changing
- Ready for code carrier fixture C960740
- Recommended workpiece weight 150 kg.
- Supplied with C531500 sealing plugs.
- Weight 4.8 kg.



S500160

- C694400 supplied in sets of 4 pcs.

S500170

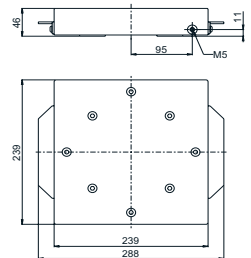
- C694400 supplied in sets of 10 pcs.



GPS 240 Pallet, C694810

Ground solid aluminium pallet. Suitable for fixtures.

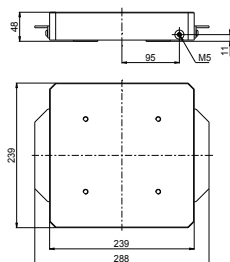
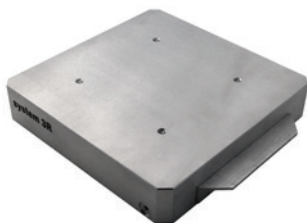
- Construction height 46 ± 0.005 mm
- X/Y-centring with springy cams, hardened, stainless
- Adapted for automatic changing
- Ready for code carrier fixture C960740
- Recommended workpiece weight 150 kg.
- Weight 7.2 kg.



GPS 240 Pallet 240x240 mm, C694610

Solid aluminium pallet. Suitable for fixtures and accessories.

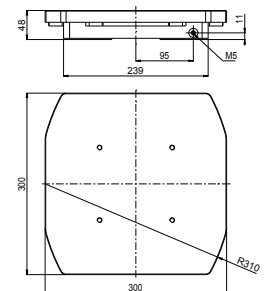
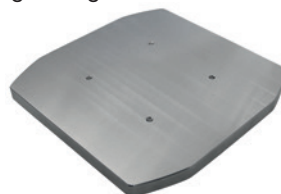
- Construction height 48.0 ± 0.01 mm
- X/Y-centring with coined cam
- Prepared for automation
- Flatness 0.01 mm
- Ready for code carrier fixture C960740
- Recommended workpiece weight 150 kg.
- Weight 7.4 kg.



GPS 240 Pallet 300x300 mm, C694640

Solid aluminium pallet. Suitable for fixtures and accessories.

- Construction height 48.0 ± 0.01 mm
- X/Y-centring with coined cam
- Flatness 0.02 mm
- Prepared for automation
- Ready for code carrier fixture C960740
- Recommended workpiece weight 150 kg.
- Weight 9 kg.



/// Pallet with coined cams.

⊙ Pallet with spring-loaded pin.

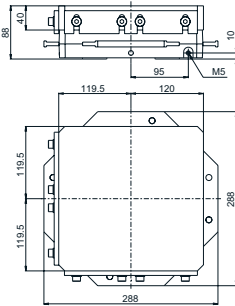
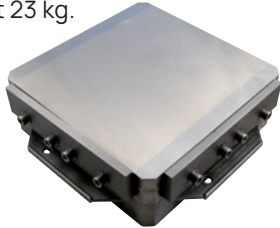
⌒ Pallet with springy cams, hardened, stainless.

GPS 240 – Pallets

GPS 240 Magnetic table, C694260

High-precision magnetic plate for grinding work and for erode.

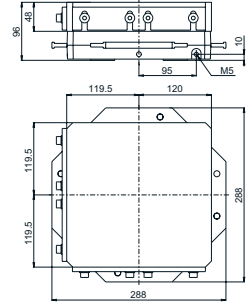
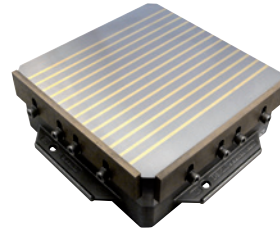
- Magnetic field height 5 mm
- Holding force 100 N/cm²
- Dimensions 240x240x88 mm
- X/Y-centring with spring-loaded pin
- Adapted for automatic changing
- Ready for code carrier fixture C960740
- Weight 23 kg.



GPS 240 Magnetic table, C694270

Strong magnetic plate for milling.

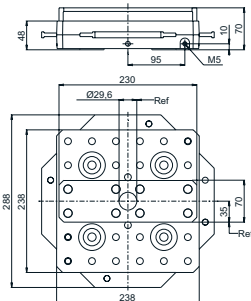
- Magnetic field height 10 mm
- Holding force 150 N/cm²
- Dimensions 240x240x96 mm
- X/Y-centring with spring-loaded pin
- Adapted for automatic changing
- Ready for code carrier fixture C960740
- Weight 27.1 kg.



GPS 240 Master pallet, C846600

The pallet has a ground reference ruler and a ground indication hole for alignment of the references.

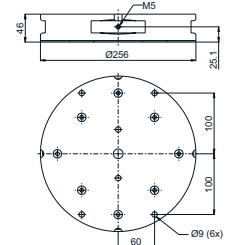
- X/Y-centring: with spring-loaded pin
- Adapted for automatic changing
- Ready for code carrier fixture C960740
- Weight 7.4 kg.



GPS 240 Pallets round, C697100

Ground solid aluminium pallet. Suitable for fixtures.

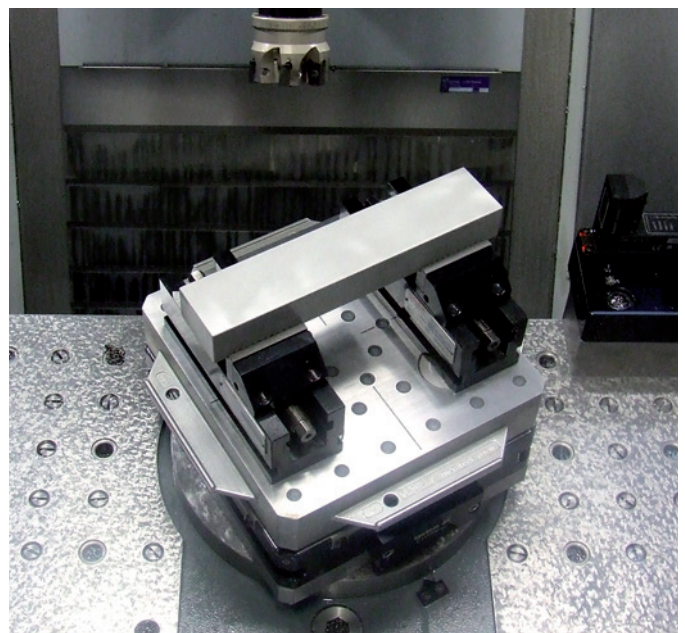
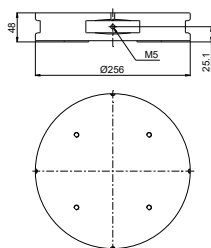
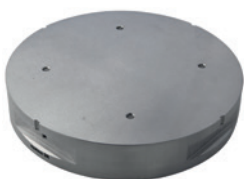
- Construction height 46 ±0.005 mm
- X/Y-centring: with springy cams, hardened, stainless
- Adapted for automatic changing
- Ready for code carrier fixture C960740
- Recommended workpiece weight 150 kg.
- Weight 6.2 kg.



GPS 240 pallet round, C694650

Solid aluminium pallet. Suitable for fixtures.

- Construction height 48.0 ±0.01 mm
- X/Y-centring with coined cam
- Adapted for automatic changing
- Ready for code carrier fixture C960740
- Recommended workpiece weight 150 kg.
- Weight 6.5 kg.



 Pallet with coined cams.

Ⓢ Pallet with spring-loaded pin.

 Pallet with springy cams, hardened, stainless.

GPS 240 – Chuck adapters

Chuck adapter HP, GPS 240-GPS 120, C522800

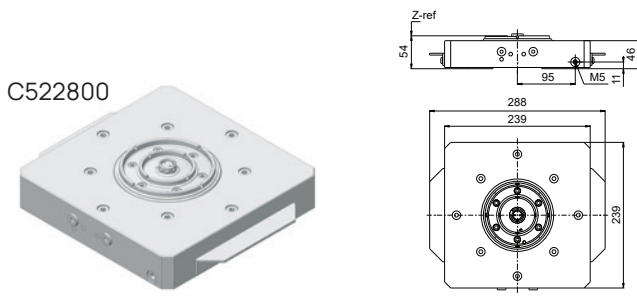
Chuck adapter with built-in pneumatic GPS 120 chuck for mounting in:

- C219800 for automated pallet change GPS 120
- C219000, C219100, C219110, C219200 for manual pallet change GPS 120; Open/Close GPS 120 with air gun.
- Built-up height 54 mm
- X/Y-centering with springy cams, hardened, stainless steel
- Simple retrofit from version „automation“ to version „manual“ by the operator
- Weight 7.9 kg.

Chuck adapter Std, GPS 240-GPS 120, C522850

Chuck adapter with built-in pneumatic GPS 120 chuck.

- Built-up height 54 mm
- X/Y-centering with coined aluminium cams
- Other specifications as C522800.



Chuck adapter HP, GPS 240-GPS 70, C522810

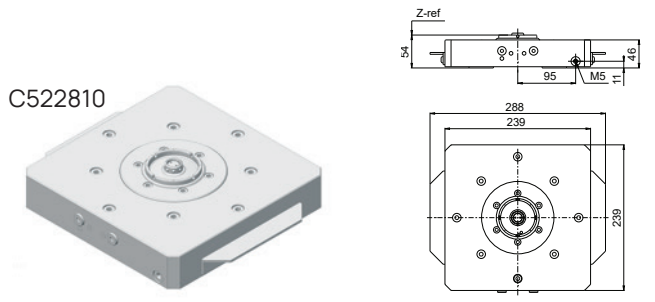
Chuck adapter with built-in pneumatic GPS 70 chuck for mounting in:

- C219800 for automated pallet change GPS 70
- C219000, C219100, C219110, C219200 for manual pallet change GPS 70; Open/Close GPS 70 with air gun.
- Built-up height 54 mm
- X/Y-centering with springy cams, hardened, stainless steel
- Simple retrofit from version „automation“ to version „manual“ by the operator
- Weight 7.9 kg.

Chuck adapter Std, GPS 240-GPS 70, C522860

Chuck adapter with built-in pneumatic GPS 70 chuck.

- Built-up height 54 mm
- X/Y-centering with coined aluminium cams
- Other specifications as C522810.



Chuck adapter HP, GPS 240-GPS 120, C522820

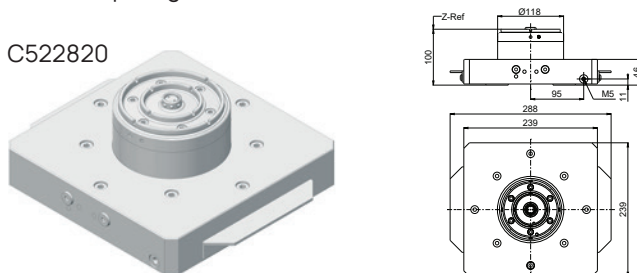
Chuck adapter with built-in pneumatic GPS 120 chuck for mounting in:

- C219800 for automated pallet change GPS 120
- C219000, C219100, C219110, C219200 for manual pallet change GPS 120; Open/Close GPS 120 with air gun.
- Built-up height 100 mm
- X/Y-centering with springy cams, hardened, stainless steel
- Simple retrofit from version „automation“ to version „manual“ by the operator
- Weight 8.9 kg.

Chuck adapter Std, GPS 240-GPS 120, C522870

Chuck adapter with built-in pneumatic GPS 120 chuck.

- X/Y-centering with coined aluminium cams
- Other specifications as C522820.
- Built-up height 100 mm.



Chuck adapter HP, GPS 240-GPS 70, C522830

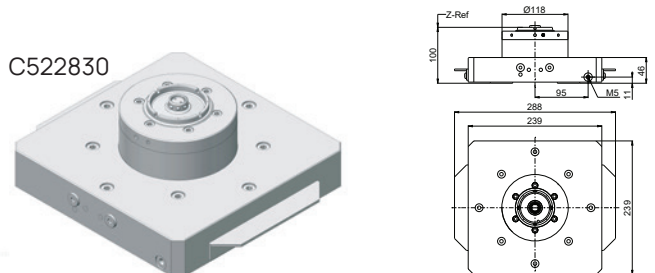
Chuck adapter with built-in pneumatic GPS 70 chuck for mounting in:

- C219800 for automated pallet change GPS 70
- C219000, C219100, C219110, C219200 for manual pallet change GPS 70; Open/Close GPS 70 with air gun.
- Built-up height 100 mm
- X/Y-centering with springy cams, hardened, stainless steel
- Simple retrofit from version „automation“ to version „manual“ by the operator
- Weight 8.9 kg.

Chuck adapter Std, GPS 240-GPS 70, C522880

Chuck adapter with built-in pneumatic GPS 70 chuck.

- X/Y-centering with coined aluminium cams
- Other specifications as C522830.
- Built-up height 100 mm.



/// Pallet with coined cams.

☛ Pallet with springy cams, hardened, stainless.

GPS 240 – Chuck adapters & accessories

Chuck adapter HP, GPS 240-Macro, C522520

Chuck adapter with built-in pneumatic Macro chuck.
3R-24460 for mounting in:

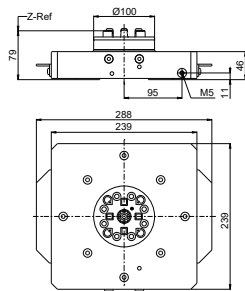
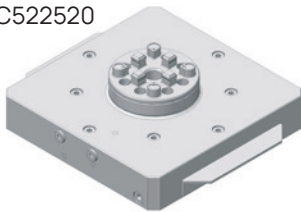
- C219800 for automated pallet change Macro
- C219000, C219100, C219110, C219200 for manual pallet change Macro; Open/Close/Turbo Macro with air gun.
- Built-up height 79 mm
- X/Y-centering with springy cams, hardened, stainless steel
- Drawbar 3R-605.1
- Simple retrofit from version „automation“ to version „manual“ by the operator
- Weight 8.5 kg.

Chuck adapter Std, GPS 240-Macro, C522530

Chuck adapter with built-in pneumatic Macro chuck.

- Built-up height 79 mm
- X/Y-centering with coined aluminium cams
- Other specifications as C522520.

C522520



Chuck adapter HP, GPS 240-MacroMagnum, C522540

Chuck adapter with built-in pneumatic MacroMagnum chuck 3R-90809.03 for mounting in:

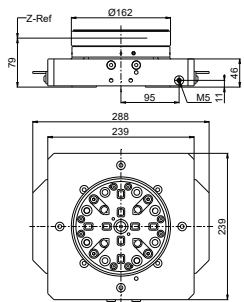
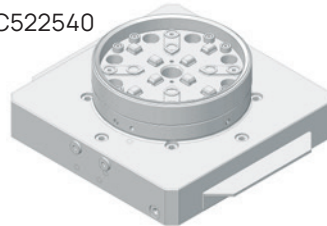
- C219800 for automated pallet change MacroMagnum
- C219000, C219100, C219110, C219200 for manual pallet change MacroMagnum; Open/Close/Turbo MacroMagnum with air gun.
- Built-up height 79 mm
- X/Y-centering with springy cams, hardened, stainless steel
- Drawbar 3R-605.1
- Simple retrofit from version „automation“ to version „manual“ by the operator
- Weight 11.7 kg.

Chuck adapter Std, GPS 240-MacroMagnum, C522550

Chuck adapter with built-in pneumatic MacroMagnum chuck.

- Built-up height 79 mm
- X/Y-centering with coined aluminium cams
- Other specifications as C522540.

C522540



GPS 240 Controllers

C810820

Unit for controlling pneumatic chucks C217100 and C219000.

- 1 connection (clamping/releasing).



C810830

Unit for controlling pneumatic chucks C219100.

- 4 connections - prism - air-blast cleaning of Z-references - clamping/releasing - Turbo/ventilation.



Hand gate valve, C810710

For controlling pneumatic chucks C217100 and C219000.

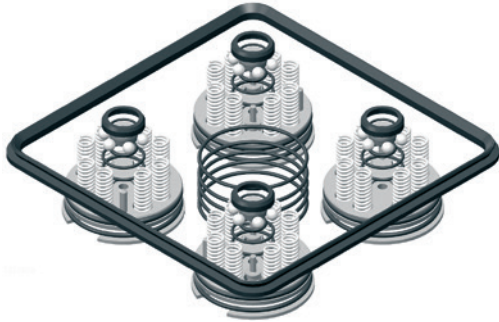


GPS 240 – Accessories

GPS 240 Spare parts set, S220000

Contains all elements for a normal service.

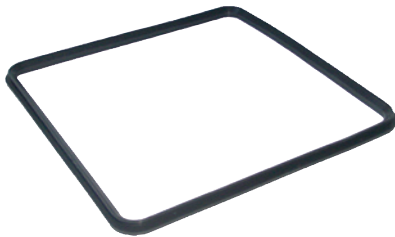
- Suitable for all square chucks, apart from C219400
- Recommendation: every 2 years if used manually and annually if used in the automation system.



Sealing, C219007

The chuck seal is a wear part which should be replaced every three to six months.

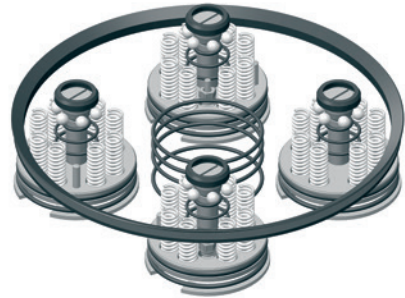
- Material Viton.



GPS 240 Spare parts set, S220400

Contains all elements for a normal service.

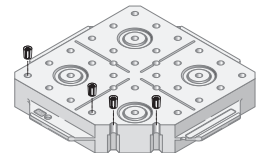
- Suitable for C217100
- Recommendation, every 2 years in manual use.



Sealing plugs, C531500

Plugs for sealing GPS 240 pallets.

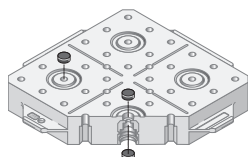
- Supplied in sets of 40.



Seals, C531250

To seal the holes in the four clamping elements of the pallet.

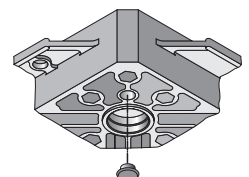
- Material elastomer
- Supplied in sets of 20.



Reference protectors, C531210

To protect the Z-reference of the pallet.

- Supplied in sets of 20.



GPS 240 – Accessories & user kits

Code carriers, 3R-863.01

With pre-programmed unique identity, designed for GPS 240 pallets.

3R-863.01-10

- Supplied in sets of 10.



Code carrier, fixture, C960740

Fixture for code carrier 3R-863.01-10.

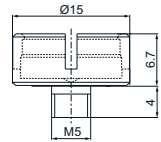
The code carrier can be clicked into position. Includes spacer for code carrier 2-3 mm thickness.

S960740

- Supplied in sets of 10.

S960745

- Supplied in sets of 50.



GPS 240 Clamp strip kit, C810880-XX*

C810881 undrilled clamp strip (x2)

E010144 washer M10 (x4)

E010143 washer M8 (x4)

E000428 Allen screw M10x45 (x4)

E000354 Allen screw M8x45 (x4)

12 E040030 T-slot nut M10x12 (x4)

14 E040031 T-slot nut M10x14 (x4)



Clamping force meter with GPS 240 insert, C288200 & C288220

The clamping force meter can be combined with different inserts. It will be used to check the different clamping systems, also called chucks. The unit clamped onto a chuck indicates the actual clamping force value. If the measured value is lower than the needed clamping force, a maintenance on the chuck is needed.

- Basic unit, C288200
- Insert for GPS 240, C288220

* When ordering, state the required dimension of the T-slot nut.