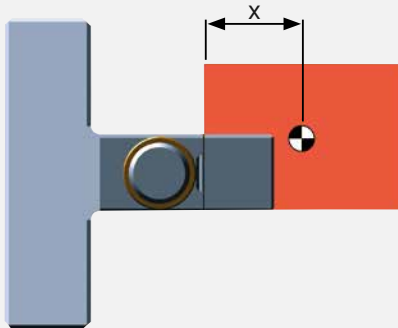
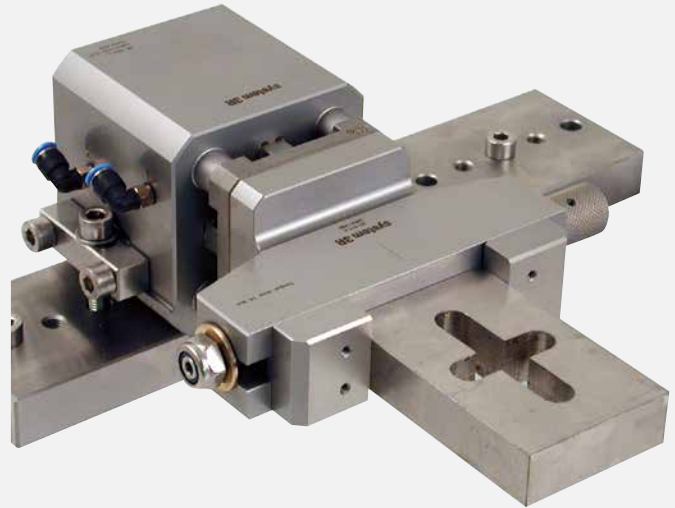


Holders for mounting in chuck adapters

These holders have been adapted for modern machines with high flushing pressures. They are primarily designed for clamping small to medium-sized workpieces on the machine's zero line.

One example of their use is the manufacture of die-sinking EDM electrodes. Each electrode is manufactured on its holder in the wire EDM machine. Without intervening mounting operations and adjustments, the electrode on its holder is then ready for immediate use in the die-sinking EDM machine operations and adjustments.



Article number	Recommended maximum torque	Maximum Workpiece weight X*=50mm	Maximum Workpiece weight X*=100mm
3R-613.4	3 Nm	6 kg	3 kg
3R-232.8	12.5 Nm	25 kg	12.5 kg
3R-613.6	12.5 Nm	25 kg	12.5 kg
3R-213.4	3 Nm	6 kg	3 kg

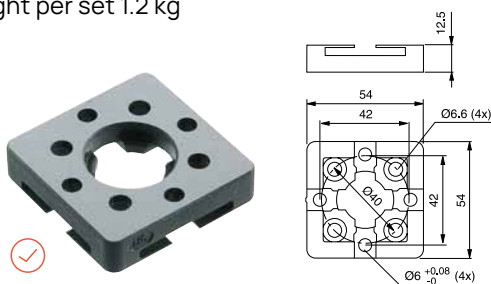
*Centre of gravity of the workpiece with X mm overhang.

Reference element 54x54 mm, Macro, 3R-651.7E-P

Hardened and precision-cast; has clearance holes for four fixing screws.

NOTE: Must be mounted on the workpiece/fixture before it is locked in a chuck.

- Parallel-ground top and bottom faces
- Fixed index positions 4x90°
- Supplied in sets of 8
- Weight per set 1.2 kg

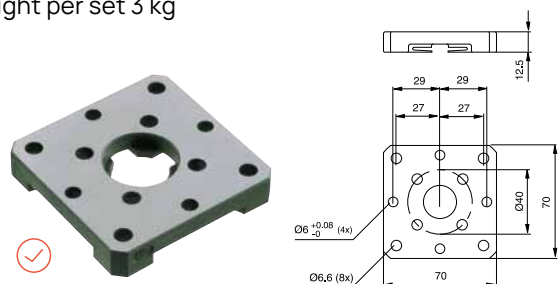


Reference element 70x70 mm, Macro, 3R-601.7E-P

Hardened and precision-cast, with clearance holes for eight fixing screws.

NOTE: Must be mounted on the workpiece/fixture before it is locked in a chuck.

- Parallel-ground top and bottom faces
- Fixed index positions 4x90°
- Supplied in sets of 5
- Weight per set 3 kg



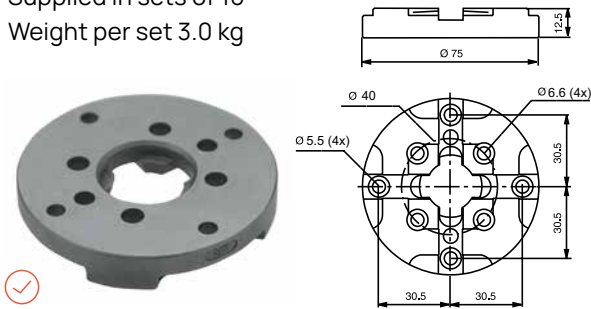
Holders for mounting in chuck adapters

Reference element Ø75 mm, Macro, 3R-651.75E-P

Hardened X, Y & Z-references. Clearance holes for fixing screws.

NOTE: Must be mounted on the workpiece/fixture before it is locked in a chuck.

- Parallel-ground top and bottom faces
- Fixed index positions 4x90°
- Supplied in sets of 10
- Weight per set 3.0 kg

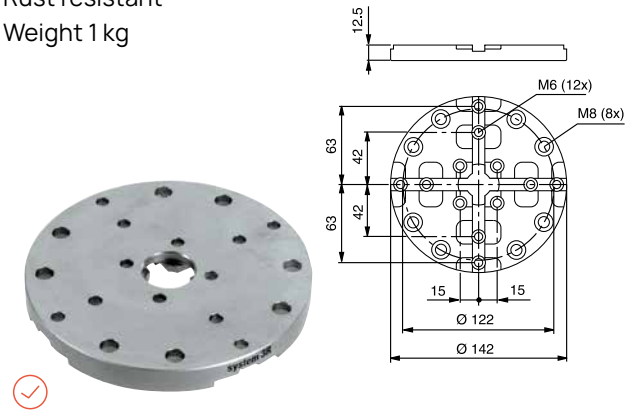


Reference element Ø142 mm, Macro, 3R-681.71

Hardened pallet with clearance holes for fixing screws.

NOTE: Must be mounted on the workpiece/fixture before it is locked in a chuck.

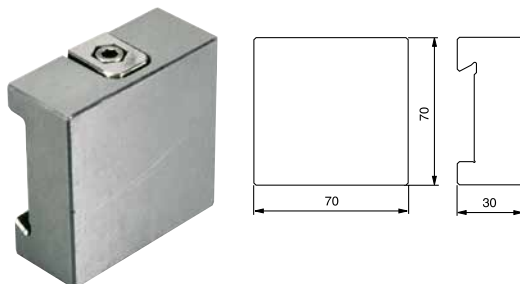
- Rust resistant
- Weight 1 kg



Pallet WEDM, 3R-205.2

Unhardened holder for mounting in the WEDM system.

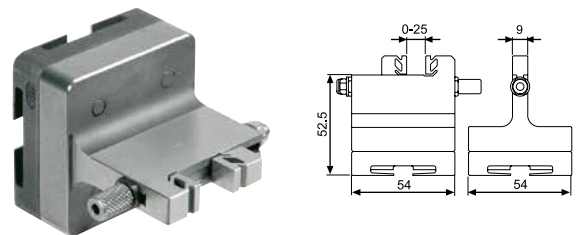
- Recommended maximum workpiece weight 7 kg
- Weight 1 kg



SuperVice, Macro, 3R-613.4

Vice for mounting rectangular workpieces 0-25 mm in the Macro system.

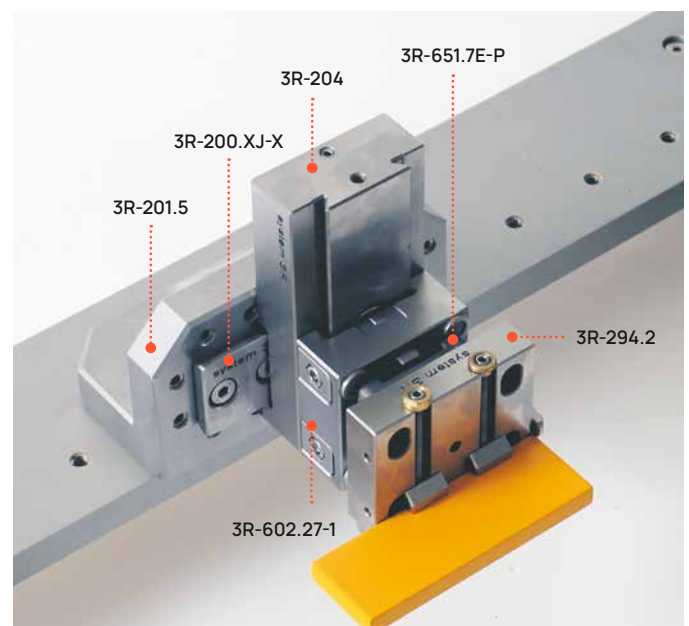
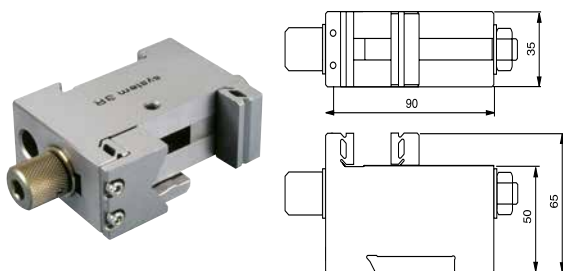
- Tightening torque 3 Nm
- Weight 0.6 kg



SuperVice WEDM, 3R-232.8

Vice for mounting rectangular (< 60 mm) and round (8-45 mm) workpieces in the WEDM system.

- Tightening torque 15 Nm
- Weight 1.5 kg

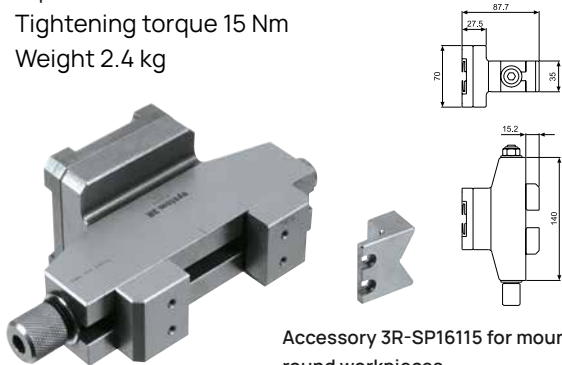


Holders for mounting in chuck adapters

Vice, Macro, 3R-613.6

Vice for mounting rectangular workpieces 0-80 mm in the Macro system. Movable jaws for centred mounting. Can be supplemented with insert 16115-00 for mounting round workpieces 15-55 mm.

- Tightening torque 15 Nm
- Weight 2.4 kg

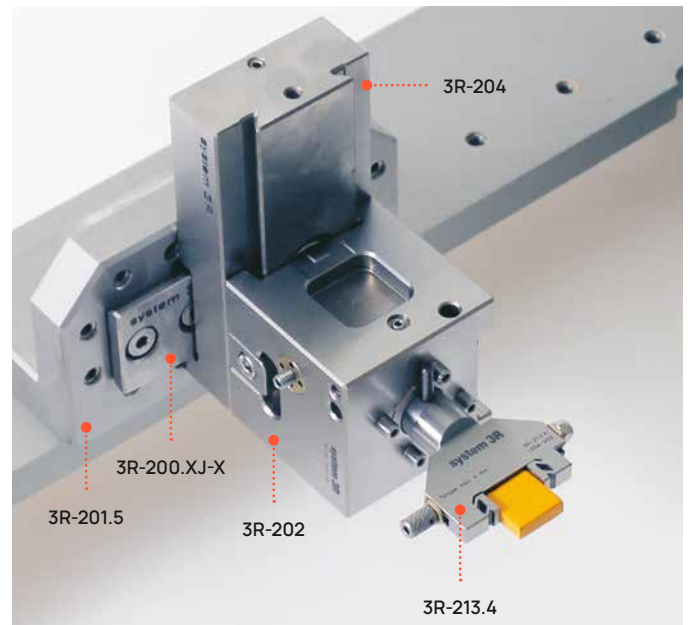
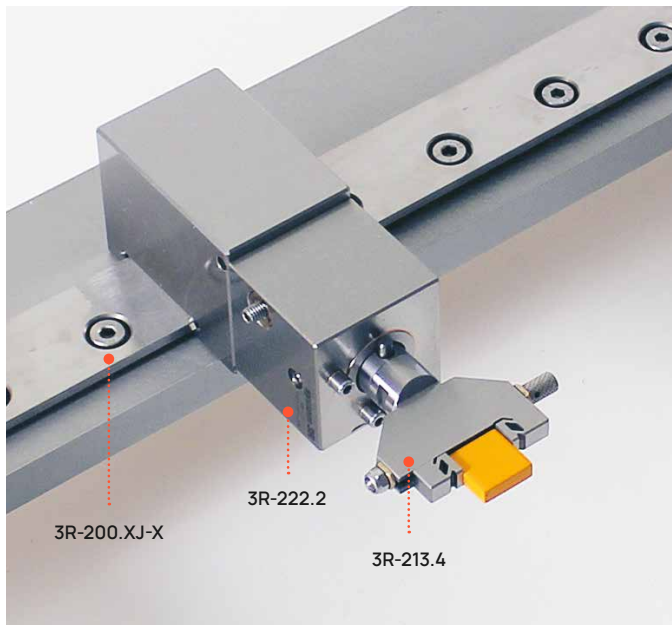
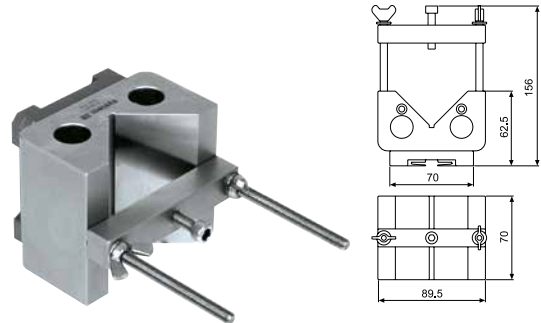


Accessory 3R-SP16115 for mounting round workpieces

V-holder, Macro, 3R-207.6

For clamping round workpieces 8-70 mm, or rectangular workpieces 10-52 mm in the Macro system.

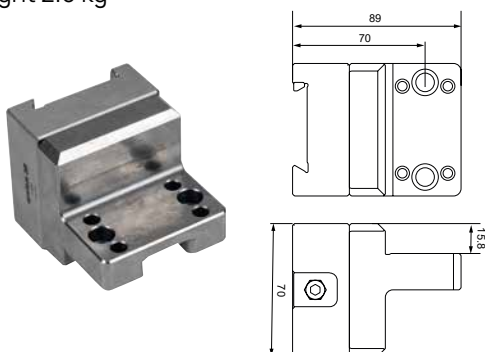
- Recommended maximum workpiece weight 8 kg
- Weight 2 kg



Fixed head, WEDM tooling, D-30263

To align workpiece prior to machining, adjustable in one axis. To enable vertical sliding, can be used with D-30225 or 3R-204.

- Tightening torque 5 Nm
- Weight 2.0 kg



Holders for mounting in chuck adapters

Collet chucks

3R-659.16-P

- For collets ER16
- Workpiece size 0.5-10 mm
- Flushing duct
- Building-in height 62 mm
- Weight 0.8 kg



3R-659.32-P

- For collets ER32
- Workpiece size 2-20 mm
- Flushing duct
- Building-in height 94 mm
- Weight 1.2 kg



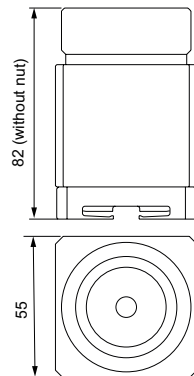
3R-659.20-P

- For collets ER20
- Workpiece size 1-13 mm
- Flushing duct
- Building-in height 69 mm
- Weight 1.2 kg



Collet chuck, 90123.02

- For collets ER40
- Building-in height 96 mm
- Weight 1.5 kg



3Ready-to-Run, 3R-494-XXX

Blanks mounted on MacroJunior holders for the manufacture of electrodes. The stock range is matched to local preferences and ways of working. This applies to electrode materials, different grades of graphite and copper and to dimensions. Contact your local 3R representative for further information.

The Vällingby factory can supply holders with factory-mounted copper blanks in sets of ten (see table).

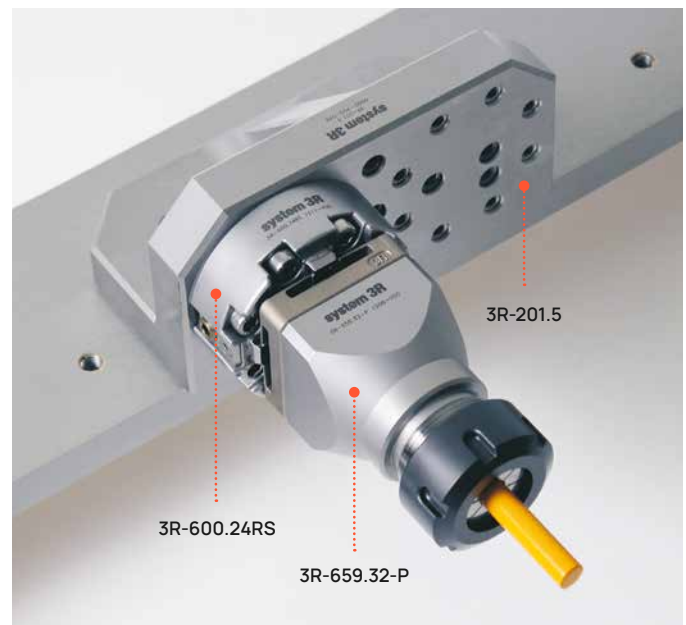
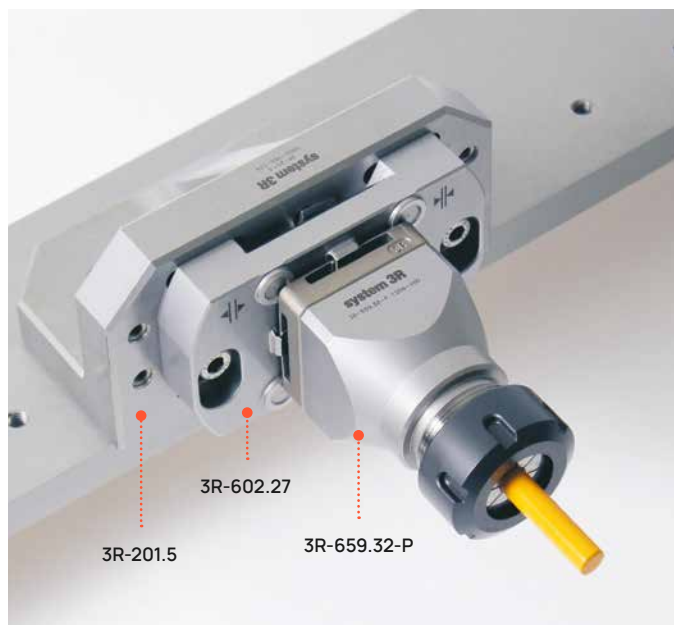
Article number

3R-494-D10x50*
 3R-494-D12x50*
 3R-494-D16x50*
 3R-494-D22x50*
 3R-494-D26x50*
 3R-494-D32x50*
 3R-494-D40x50*
 3R-494-D50x50*
 3R-494-S12x50*
 3R-494-S22x50*
 3R-494-S26x50*
 3R-494-S32x50*
 3R-494-S40x50
 3R-494-32x22x50
 3R-494-40x22x50

Dimensions

Round blank Ø10x50 mm
 Round blank Ø12x50 mm
 Round blank Ø16x50 mm
 Round blank Ø22x50 mm
 Round blank Ø26x50 mm
 Round blank Ø32x50 mm
 Round blank Ø40x50 mm
 Round blank Ø50x50 mm
 Square blank 12x12x50 mm
 Square blank 22x22x50 mm
 Square blank 26x26x50 mm
 Square blank 32x32x50 mm
 Square blank 40x40x50 mm
 Square blank 32x22x50 mm
 Square blank 40x22x50 mm

* =



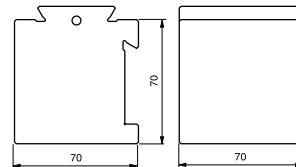
Adapter elements

Adapter elements facilitate machining of complex geometries, even if the machine is not the very latest model. The range includes products for: swivelling or height adjustment; and, plain spacer elements.

Adapter 90°, WEDM, 3R-201J

Basic element for 3D accessories.

- Fits on all System 3R basic elements.
- Tightening torque 7 Nm
- Weight 2.7 kg

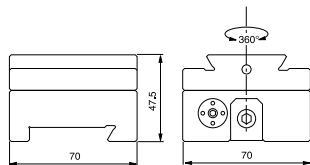


Swivelling element 360°, WEDM, 3R-203

Hydraulic locking of set position.

NOTE: For angle setting, 3R-216 is recommended.

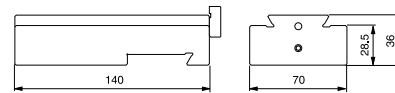
- Can be mounted on 3R-204 or directly on 3R-201J
- Tightening torque 7 Nm
- Weight 1.5 kg



Height adapter, WEDM, 3R-204

Can be turned upwards or downwards when mounting on 3R-201J.

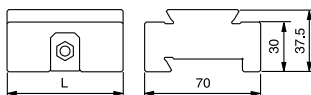
- Height adjustment ± 65 mm
- Tightening torque 7 Nm
- Weight 1.9 kg



Spacer element 30 mm, WEDM

Used where vertical or horizontal displacement of work-piece or accessory is necessary.

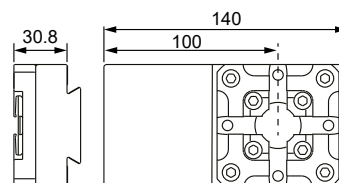
- Tightening torque 7 Nm



Height adapter, Macro, D-30225

Can be turned upwards or downwards when mounting on Macro chucks.

- Height adjustment ± 70 mm
- Weight 2.2 kg



3R-223

- Length 70 mm

3R-223.3

- Length 140 mm

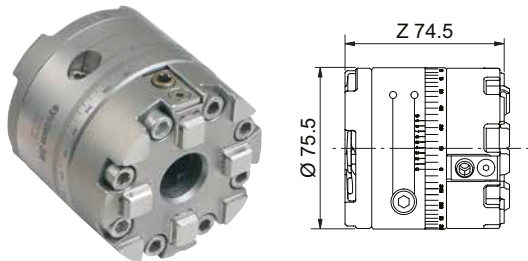
Adapter elements

Swivelling element 360°, Macro, 3R-203.66

Swivelling element with manual Macro chuck for mounting on Macro chucks. Mechanical locking of the set position. Vernier scale for quick setting in 0.1-degree steps.

NOTE: For angle setting, sine ruler 3R-216.6 and gauge block are recommended.

- Maximal hanging torque 8 Nm
- Required drawbar 3R-605.2RS
- Weight 2 kg



Swivelling element 360°, Macro, 90937

Swivelling element with manual Macro chuck for mounting on leveling heads. Mechanical locking of the set position. Vernier scale for quick setting in 0.1-degree steps.

NOTE: For angle setting sine, ruler 3R-216.6 and gauge block are recommended.

- Maximal hanging torque 8 Nm
- Required drawbar 3R-605.2RS
- Weight 3.1 kg



Swivelling element 360° with encoder, D-30232

Swivelling element with manual Macro chuck. Display included.

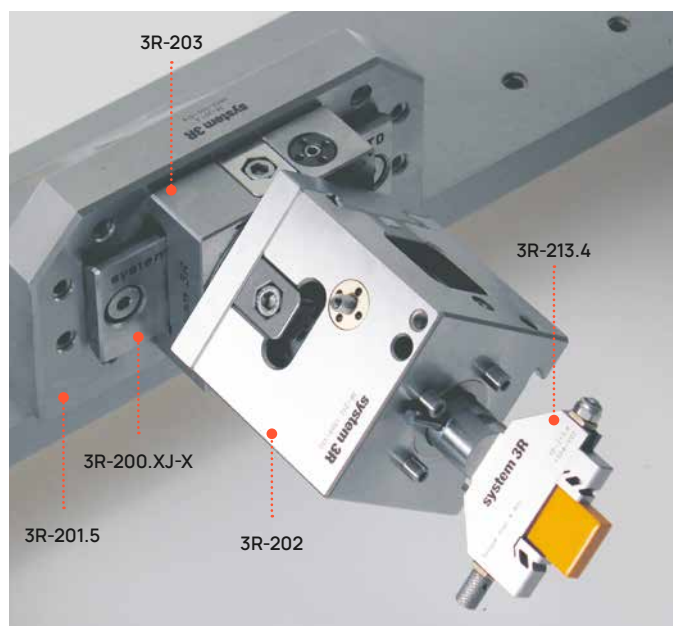
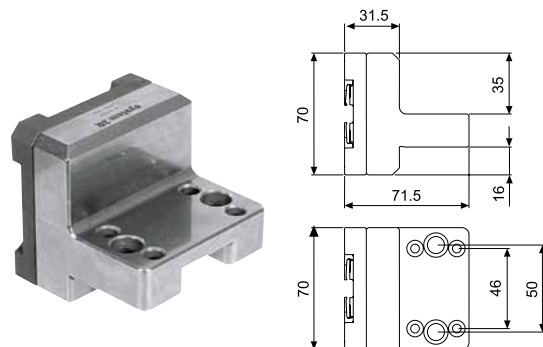
- Maximal hanging torque 8 Nm
- Locking of chuck 6 Nm
- Locking of swivel 6 Nm
- Required drawbar 3R-605.2RS
- Weight 2.2 kg



Vertical fixed adapter, Macro, 3R-226.6

For clamping SuperVice and holders horizontally in vertical Macro chucks.

- Weight 1.4 kg



Vertical levelling adapter, Macro, 3R-262.6

For clamping SuperVice and holders horizontally in vertical Macro chucks.

- Adjustable in three axes
- Weight 1.5 kg

