

# Presetting & inspection

## MAKE EFFICIENT USE OF MACHINE TIME

Which is better, using a machine to produce or to set-up equipment?

To optimise capacity, why not preset in a presetting station? This means you can keep your machines producing. Simply lift the preset "package" (e.g. levelling adapter, holder and workpiece) out of the station, secure it in the machine (a few easy manual operations are all that is required), hit the button and continue producing. We call this One Minute set-up.

System 3R's presetting stations are constructed on a modular basis. The customer chooses a suitable set of prepared "measuring stones", and the necessary chuck/reference elements that match, for example, the installation on the wire EDM machine table. If required, a pneumatic control unit can also be chosen.



Pneumatic chuck for Macro  
3R-602.10-1



Manual chuck for Macro  
3R-602.27



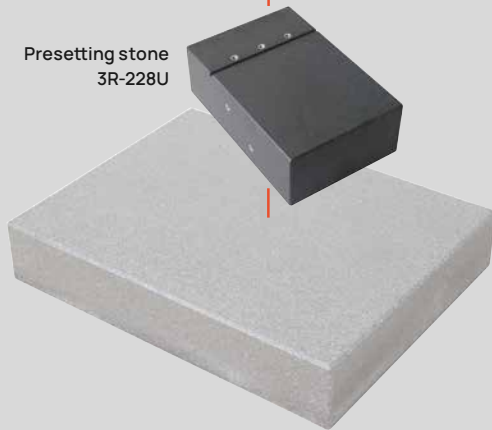
Reference element  
3R-200.1J-U



Pneumatic chuck for MacroTwin  
3R-602.12-1



Presetting stone  
3R-228U



Presetting station  
3R-228.1



Actuator  
3R-611.4



1.



2.



3.



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### Presetting stone, 3R-228J

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

- Dimensions 150x110x80 mm
- Weight 5.4 kg



### Presetting stone, 3R-228U

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

- Dimensions 300x200x100 mm



### Presetting station, 3R-228.1

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

- Dimensions 500x300 mm



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

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

**NOTE:** 3R-228EI comes with a dial indicator that has inch measurements.

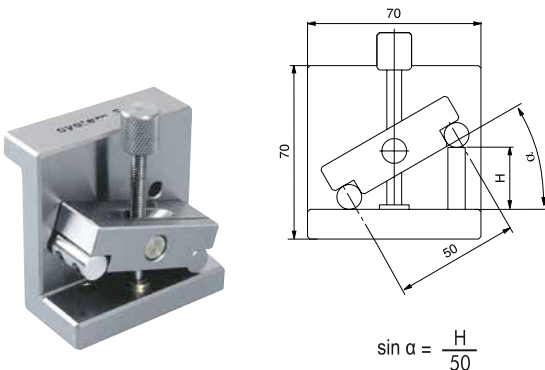
- Dimensions 300x200x100 mm
- Presetting stone
- Measuring stand
- Dial indicator (mm measurements)



### Sine ruler, 3R-216

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

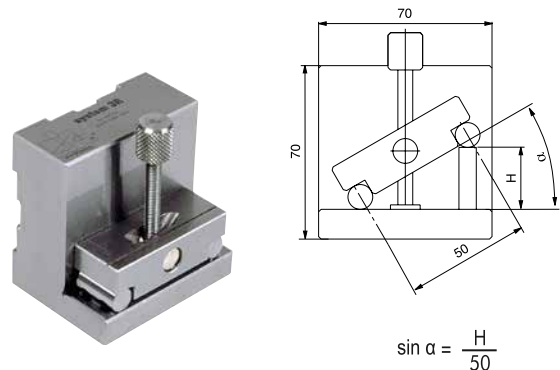
- Measuring length 50 mm
- Weight 1.2 kg



### Sine ruler, Macro, 3R-216.6

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

- Measuring length 50 mm
- Weight 1.4 kg

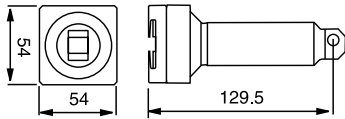


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### Master, 3R-606.2

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

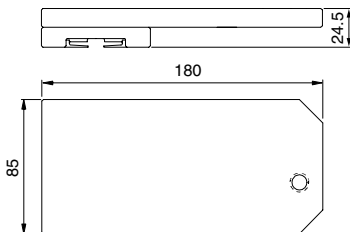
- Drawbar not included



### Master, 3R-206.10

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

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



### Wire alignment unit, 3R-220.3

Unit with double-insulated reference contacts for wire alignment.

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

