Basic equipment – Macro

With a Macro chuck as basic equipment on the machine table, you can interconnect all your machines to create a single system. Move the workpiece from the wire EDM machine to the grinding machine or the die-sinking machine without subsequent alignment – quickly and precisely.

If you choose a pneumatic Macro chuck, you can operate round-the-clock production if you wish.

+ Allows fully automated production
+ Links all your machines together
+ Z-references with automatic air-blast cleaning
+ X and Y references of cemented carbide
+ Repetition accuracy:
  Macro 0.002 mm
  MacroNano 0.001 mm
+ Turbo locking – enhanced clamping force.

Note: The pneumatic chucks require an air pressure of 6±1 bar.

### Recommendations for loading in Macro chucks

**Table chucks with horizontal mounting of the workpiece**

<table>
<thead>
<tr>
<th>Article number</th>
<th>Max torque</th>
<th>Capacity (X=150 mm)</th>
</tr>
</thead>
<tbody>
<tr>
<td>3R-600.24RS</td>
<td>6 Nm</td>
<td>4 kg</td>
</tr>
<tr>
<td>3R-600.24-4RS</td>
<td>8 Nm</td>
<td>5 kg</td>
</tr>
<tr>
<td>3R-602.10</td>
<td>22.5 Nm</td>
<td>15 kg</td>
</tr>
<tr>
<td>3R-602.10-1</td>
<td>30 Nm</td>
<td>20 kg</td>
</tr>
<tr>
<td>3R-602.12-1</td>
<td>45 Nm</td>
<td>30 kg</td>
</tr>
<tr>
<td>3R-602.26</td>
<td>30 Nm</td>
<td>20 kg</td>
</tr>
<tr>
<td>3R-602.27</td>
<td>30 Nm</td>
<td>20 kg</td>
</tr>
<tr>
<td>3R-602.27-1</td>
<td>18 Nm</td>
<td>12 kg</td>
</tr>
<tr>
<td>3R-602.81RS</td>
<td>30 Nm</td>
<td>20 kg</td>
</tr>
</tbody>
</table>

**Table chucks with vertical mounting of the workpiece**

<table>
<thead>
<tr>
<th>Article number</th>
<th>Max torque</th>
<th>Capacity (X=100 mm)</th>
</tr>
</thead>
<tbody>
<tr>
<td>3R-600.24RS</td>
<td>6 Nm</td>
<td>6 kg</td>
</tr>
<tr>
<td>3R-600.24-4RS</td>
<td>8 Nm</td>
<td>7-8 kg</td>
</tr>
<tr>
<td>3R-602.12-1</td>
<td>8 Nm</td>
<td>7-8 kg</td>
</tr>
<tr>
<td>3R-602.27-1</td>
<td>8 Nm</td>
<td>7-8 kg</td>
</tr>
<tr>
<td>3R-60.360-X</td>
<td>8 Nm</td>
<td>7-8 kg</td>
</tr>
</tbody>
</table>
Basic equipment – Macro

Overview of the Macro system with horizontal mounting
Basic equipment on the machine table

Overview of the Macro system with vertical mounting
Basic equipment on the machine table
Basic equipment – Macro

**Pneumatic chuck, Macro, 3R-602.10-1**
Pneumatic chuck for Macro holders.
- Clamping force 6.7 kN
- Fixed index positions 4x90°
- Supplied with drawbar 3R-605.10
- Air-blast cleaning of Z-references
- Protective cover.
- Weight 1.0 kg.

**Pneumatic chuck, MacroNano, 3R-602.10-1N**
Pneumatic chuck for Macro holders.
- Clamping force 6.7 kN
- Fixed index positions 4x90°
- Supplied with drawbar 3R-605.10
- Air-blast cleaning of Z-references
- Protective cover.
- Weight 1.0 kg.

**Pneumatic chuck, MacroTwin, 3R-602.12-1**
Pneumatic chuck for Macro or MacroTwin. Horizontal mounting on the machine table.
Note: On automatic changing with WorkPal – MacroTwin holders only.
- Clamping force 2x6.7 kN
- Fixed index positions 4x90°
- Supplied with drawbars 3R-605.10
- Air-blast cleaning of the Z-references
- Protective covers
- Weight 1.5 kg.

**Manual chuck, Macro, 3R-600.24RS**
- Clamping force 6 kN
- Fixed index positions 4x90°
- Required drawbar 3R-605.2RS
- Tightening torque 6 Nm
- Weight 0.7 kg.

**Manual chuck, Macro, 3R-600.23RS**
Manual chuck with mounting flange for Macro holder. Designed for permanent mounting.
- Clamping force 6 kN
- Fixed index positions 4x90°
- Required drawbar 3R-605.2RS
- Tightening torque 6 Nm
- Weight 0.7 kg.

**Manual chuck, Macro, 3R-602.27**
Manual chuck with lever for Macro holder.
- Clamping force 6 kN
- Fixed index positions 4x90°
- Supplied with drawbar 3R-605.27RS
- Built-in latch function
- Weight 1.1 kg.
Basic equipment – Macro

Manual chuck, Macro, 3R-602.26
Manual chuck for Macro holder.
- Clamping force 6 kN
- Fixed index positions 4x90º
- Supplied with drawbar 3R-605.26
- Tightening torque 6 Nm
- Weight 1.1 kg.

Pneumatic chuck, Macro, 3R-602.81RS
Pneumatic chuck, low-profile, for Macro holder.
- Clamping force 6 kN
- Fixed index positions 4x90º
- Required drawbar 3R-605.10
- Air-blast cleaning of Z-references
- Weight 4.1 kg.

Manual chuck, Macro, 3R-600.24-4RS
Manual chuck for Macro holder. Mounts on a suitable fixture.
- Clamping force 6 kN
- Fixed index positions 4x90º
- Required drawbar 3R-605.2RS
- Tightening torque 6 Nm
- Ground front edge
- Weight 1 kg.

Pneumatic chuck, Macro, 3R-602.4.1
Pneumatic chuck for Macro holder.
- Clamping force 6 kN
- Fixed index positions 4x90º
- Required drawbar 3R-605.1RS
- Air-blast cleaning of Z-references
- Weight 4.1 kg.

Pneumatic chuck, MacroHP, 3R-600.10-3RS
Pneumatic chuck locked/opened with air gun.
- Clamping force 6 kN
- Fixed index positions 4x90º
- Required drawbar 3R-605.1RS
- Air-blast cleaning of the Z-references
- Carbide XY-References
- Weight 4.4 kg.
Basic equipment – Macro

**Pneumatic chuck, Macro, 3R-600.15-3**

Pneumatic chuck for permanent mounting on the machine table.
- Clamping force 4.5 kN
- Fixed index positions 4x90°
- Supplied with drawbar 3R-605.2RS
- Weight 0.8 kg.

**Pneumatic built-in chuck, Macro, 3R-SP26771-RS**

Chuck for Macro holder. For permanent mounting on the machine spindle or fixture.
- Clamping force 6 kN
- Fixed index positions 4x90°
- Required drawbar 3R-605.1RS
- Weight 2 kg.

**Manual chuck (low profile), MacroMagnum, 90809.02**

Chuck for MacroMagnum holder. For permanent mounting on the machine spindle or table.
Note: Master 3R-606.1 or 3R-686.1-HD required at installation.
- Clamping force – Macro at 5 kN: 6 kN, MacroMagnum at 12 kN: 16 kN
- Fixed index positions 4x90°
- Required drawbar 3R-605.2RS
- Tightening torque Macro 4 Nm, MacroMagnum 10 Nm
- Weight 5 kg.

**Pneumatic chuck (low profile), Macro, 90945.01**

Pneumatic chuck for permanent mounting on the machine table.
- Clamping force 6.2 kN
- Required drawbar 3R-605.2RS
- Fixed index positions 4x90°
- Weight 2 kg.

**Angle Tool, Macro, D-30215**

Angle tool, Macro with vernier scale -90° to 0 to +90°.
Note: Macro chuck is required on the machine table for clamping.
- Clamping force 6 kN
- Required drawbar 3R-605.2RS
- Tightening torque 6 Nm
- Weight 3.5 kg.

**Angle Swivel Tool, Macro, 90937.20**

2-axes angle Swivel Tool, Macro with vernier scale -90° to 0 to +90° together with swivel in the front.
Note: Macro chuck is required on the machine table for clamping.
- Clamping force 6 kN
- Required drawbar 3R-605.2RS
- Tightening torque 6 Nm
- Maximum load 6 kg or 4 Nm.
- Weight 5 kg.
### Basic equipment – Macro

**3R-block, Macro, 3R-217-1**
Manual Macro chuck. For vertical or horizontal mounting on the machine table, or alternatively the WEDM system with the aid of 3R-SP6435.
- Clamping force 6 kN
- Fixed index positions 24x15°
- Required drawbar 3R-605.2RS
- Tightening torque 6 Nm
- Vernier scale
- Weight 5.4 kg.

![3R-block, Macro, 3R-217-1](image)

**Adapter, 3R-SP6435**
Adapter element for mounting 3R-217-1 in the WEDM system.

![Adapter, 3R-SP6435](image)

**Angle shelf, 3R-201.5**
Mounts directly on the machine table. For vertical mounting of a Macro chuck or short reference element in the machine.
- Weight 4.2 kg.

![Angle shelf, 3R-201.5](image)