Presetting & inspection

**Make efficient use of machine time.**

Machine can be used either for active machining or for non-productive setting-up operations on an idle machine.

You can optimise machine capacity by presetting away from the machine in a presetting station, while the machine is actively working on another workpiece.

So – preset away from the machine, lift in the preset package, secure it with a few simple manual operations, press the start button and the wire EDM machine is working again – One Minute Set-up.

System 3R’s presetting stations are constructed on a modular system, where the customer chooses a suitable packet of prepared “measuring stones”, for which the customer chooses the necessary chuck/reference elements in order to match the installation on the wire EDM machine table, as well as a pneumatic control unit if required.
Presetting & inspection

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 presetting tool for a modest outlay.
- 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, a mounting stone with bushings and holes for mounting a chuck/reference element and 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 delivers with dial indicator measuring inch.
- Dimensions 300x200x100 mm
- Presetting stone
- Measuring stand
- Dial indicator [measures in mm].

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.
Presetting & inspection

**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
- Four wires in the cable
- Weight 2.2 kg.