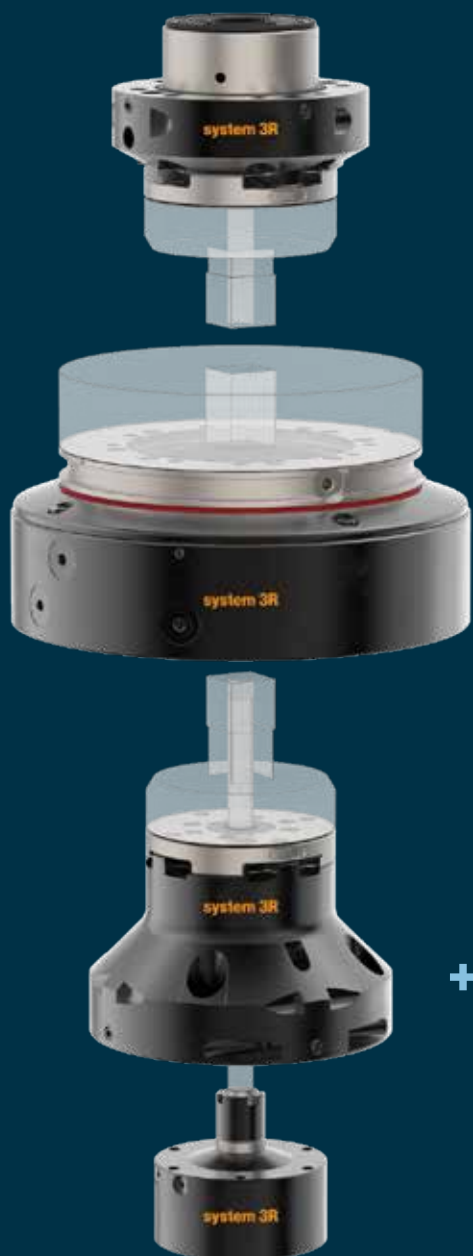


System 3R – Tooling

Powder Compacting Technology



System 3R

When all you need is everything, it's good to know that there is one company that you can count on to deliver complete solutions and services. System 3R equips world-class electrical discharge machines (EDM), Laser texturing and Additive Manufacturing through to first-class Milling by Tooling, Automation and software systems — all backed by unrivalled customer service and support — we, help you raise your game and increase your competitive edge.

Swedish design and quality



Contents

4	System 3R applied in the Toolshop
6	Examples of configurations
9	Maintain flexibility in Press
10	Tooling top down choice by size
20	How to make a configuration
22	Aligning equipment
23	Other tooling

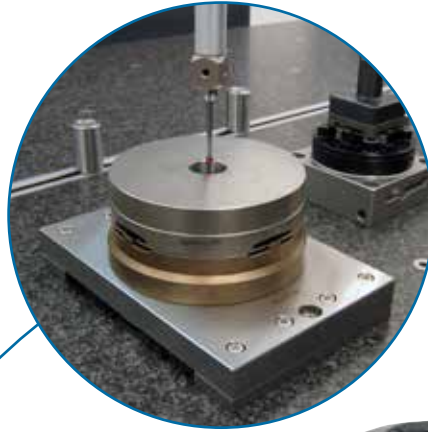
System 3R applied in the Toolshop

Use System 3R tooling when producing punches and dies

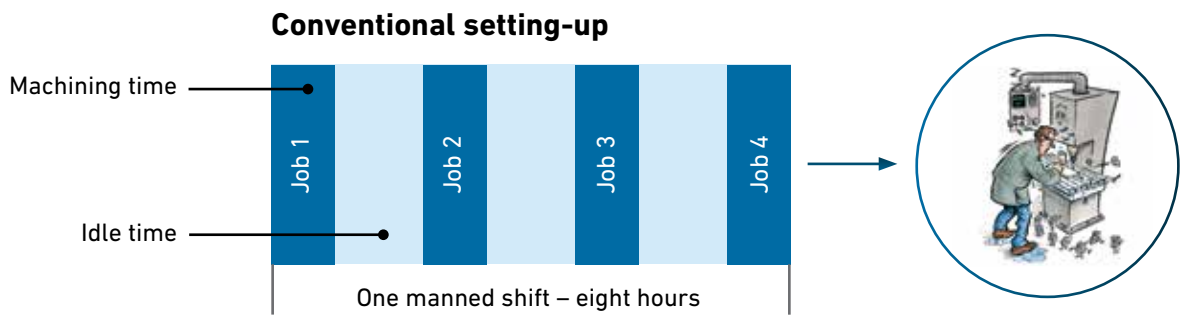
Gives an increased productivity in the Tool shop by a reduction of the set-up times, improved accuracy & quality and reduced number of rejections.

Use System 3R tooling also for Powder Compacting

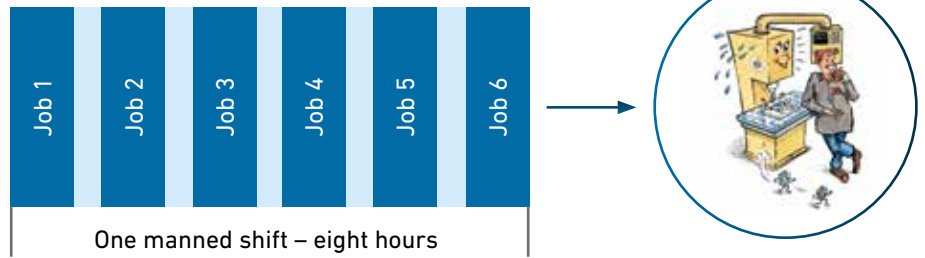
Reduces the set-up times in the press and gives an improved accuracy & quality and less repairs.



Fitting the machines with the same reference system means that electrodes and workpieces can be moved between the machines without subsequent alignment and checking – **One Minute Set-up.**

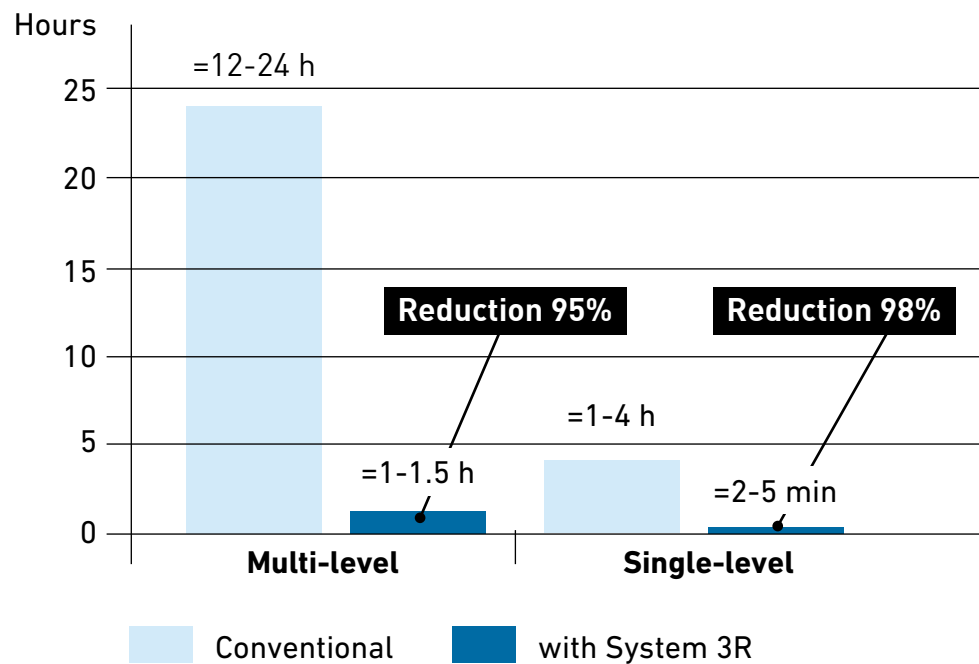


Pallet system



One Minute Set-up

Set-up time: change & alignment



A reference system minimises setup times

Every minute that can be converted from internal to external setting time increases the spindle time of the machine and with it the productivity of the business.

Big earnings are within your reach

The machine generates revenue when its spindle is turning – and only then. Work smarter, not harder.

Examples of configurations

Single levels

Manual configuration
Mechanical operated



Upper punch,
Macro



Die,
3Refix



Lower punch and core pin,
Macro

Automatic configuration
Pneumatic operated



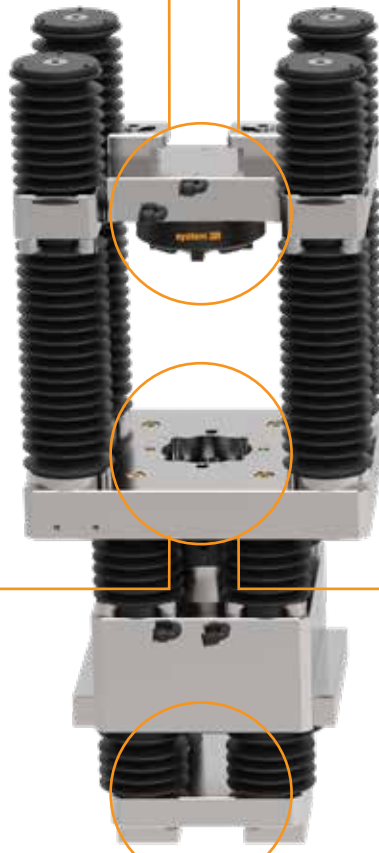
Upper punch,
Macro



Die,
Matrix



Lower punch and core pin,
Macro



Single levels

Manual configuration Mechanical operated



Upper punch,
Matrix



Die,
3Refix



Lower punch and core pin,
Matrix

Automatic configuration Pneumatic operated



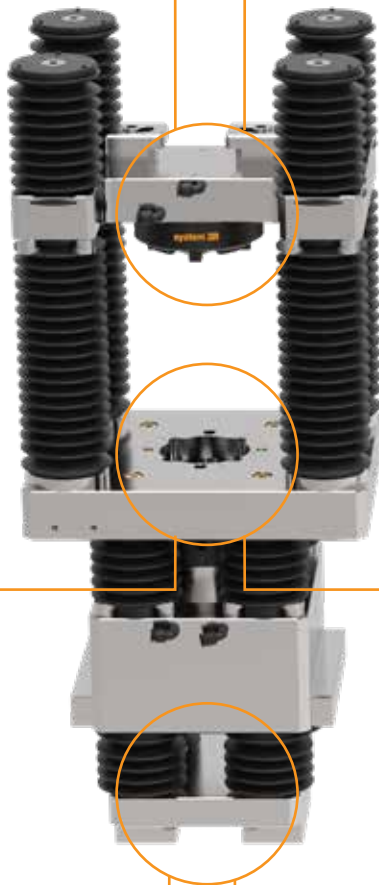
Upper punch,
Matrix



Die,
Matrix

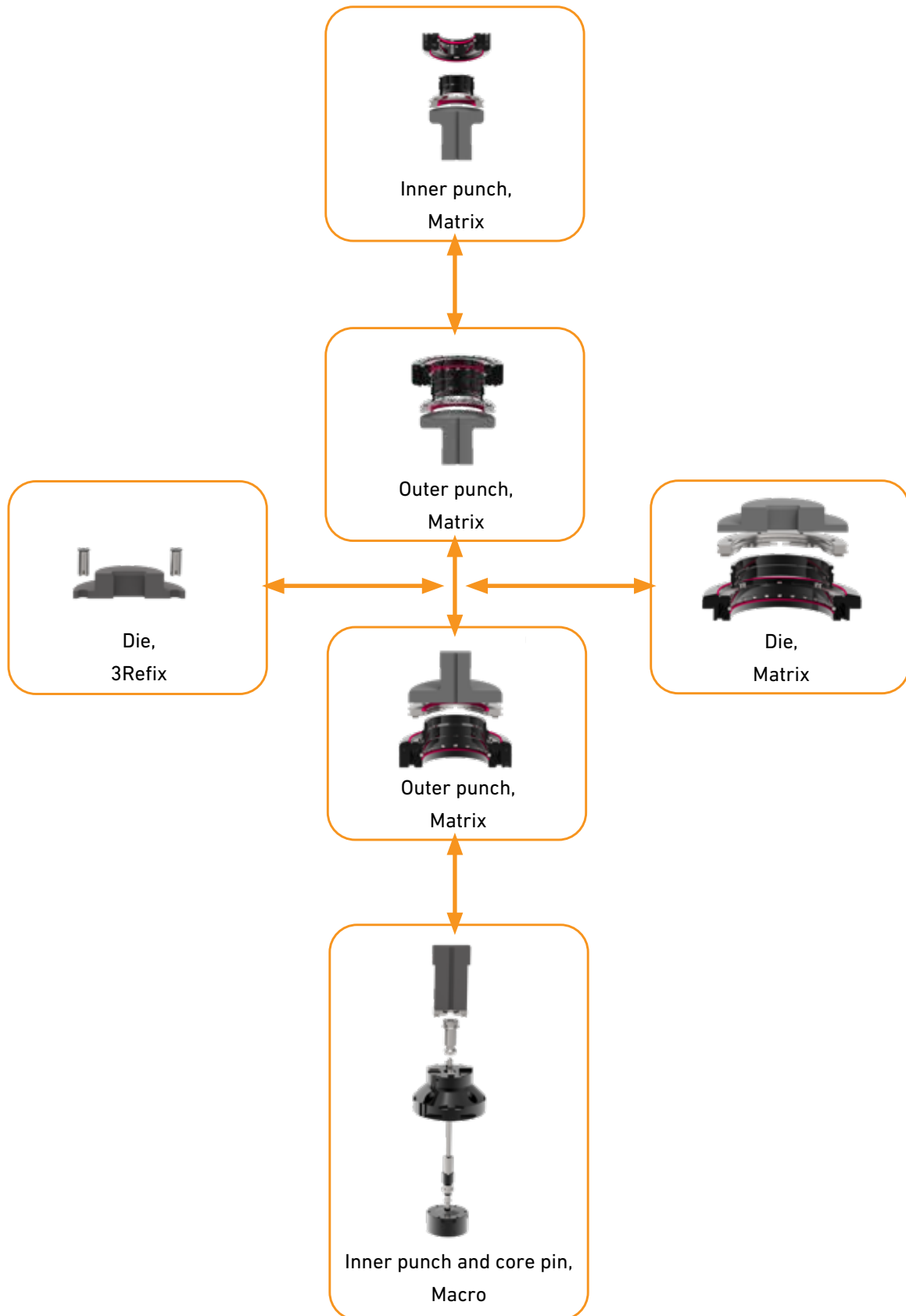


Lower punch and core pin,
Matrix



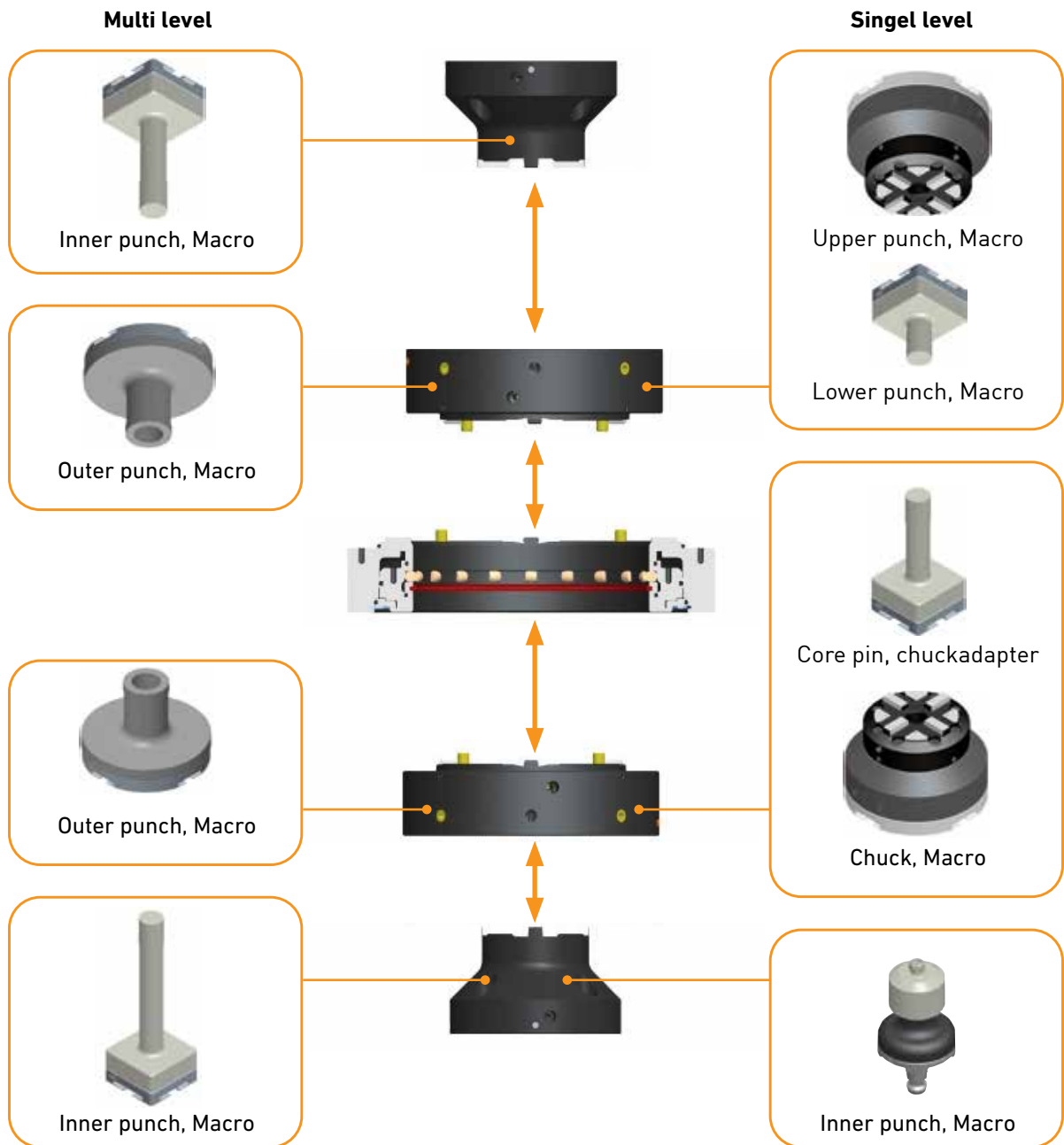
Examples of configurations

Multi level



Maintain flexibility in Press

Convert Multi to single level



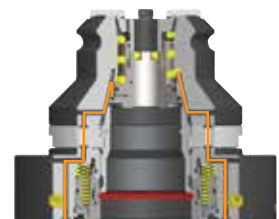
2. Load chuck adapter for single punch

1. Load chuck adapter for shorter core rod.



Connectors for Pneumatic chuck, Matrix 142

Chuck adaptor connectors



Unclamp

Turbo/Airblast cleaning

Tooling – Top down choice by size

Chucks

3Refix PM mandrels, 3R-901-10PM-TX, Ø10 mm

- + Recommended tightening torque 4 Nm.
- + Weight 0.02 kg.

3R-901-20PM-TX, Ø20 mm

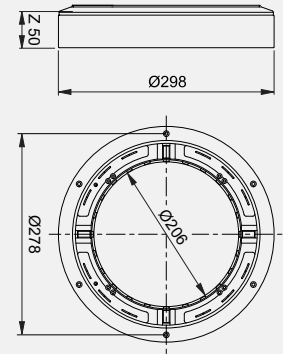
- + Recommended tightening torque 10 Nm.
- + Weight 0.1 kg.



Pneumatic chuck, Matrix 260, 3R-690.1-260

Chuck for permanent mounting into a PM press.

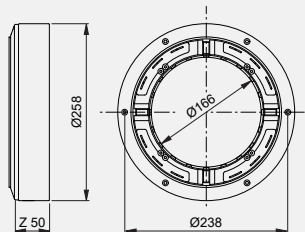
- + Built in height 50 mm
- + Max pressure 200 ton.
- + Required drawbar 3R-695.2-260
- + Hardened references
- + Weight 13 kg.



Pneumatic chuck, Matrix 220, 3R-690.1-220

Chuck for permanent mounting into a PM press.

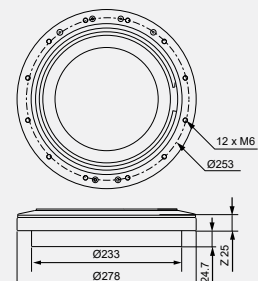
- + Built in height 50 mm
- + Max pressure 150 ton.
- + Required drawbar 3R-695.2-220
- + Weight 11 kg.



Pneumatic chuck, built in, Matrix 220, 3R-SP28340

Chuck for permanent mounting into a PM press.

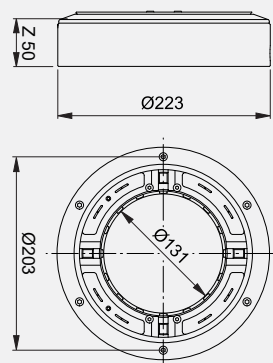
- + Built in height 25 mm
- + Max pressure 150 ton.
- + Required drawbar 3R-695.2-220
- + Weight 10.6 kg.



Pneumatic chuck, Matrix 185, 3R-690.1-185

Chuck for permanent mounting into a PM press.

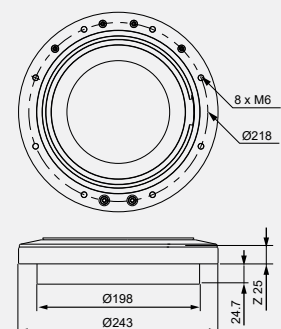
- + Built in height 50 mm
- + Max pressure 100 ton.
- + Required drawbar 3R-695.2-185
- + Weight 9 kg.



Pneumatic chuck, built in, Matrix 185, 3R-SP28268

Chuck for permanent mounting into a PM press.

- + Built in height 25 mm
- + Max pressure 100 ton.
- + Required drawbar 3R-695.2-185
- + Weight 10.6 kg.



Chucks

Pneumatic chuck, Matrix 142, 3R-690.1-142HD

Chuck for permanent mounting into a PM press.

- + Air sensor separated from Turbo.
- + Built in height 50 mm
- + Max pressure 50 ton
- + Required drawbar 3R-695.2-142
- + Weight 7 kg.



Pneumatic chuck, Matrix 142, 3R-690.1-142

Chuck for permanent mounting into a PM press.

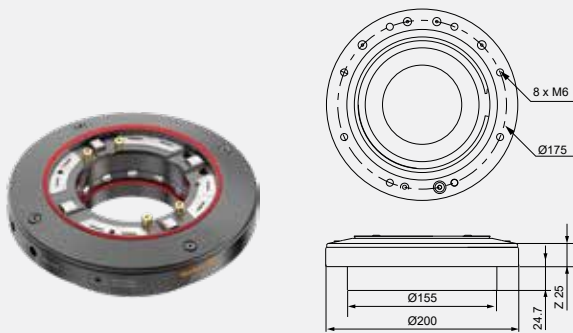
- + Built in height 50 mm
- + Max pressure 50 ton.
- + Required drawbar 3R-695.2-142
- + Weight 7 kg.



Pneumatic chuck, Built in, Matrix 142, 3R-SP28395

Chuck for permanent mounting into a PM press.

- + Built in height 17.5 mm
- + Max pressure 50 ton.
- + Required drawbar 3R-695.2-142
- + Weight 2.7 kg.



Pneumatic chuck, Matrix 110, 3R-690.1-110HD

Chuck for permanent mounting into a PM press.

- + Air sensor separated from Turbo.
- + Built in height 35 mm
- + Max pressure 25 ton
- + Required drawbar 3R-695.2-110
- + Weight 2.5 kg.



Pneumatic chuck, Matrix 110, 3R-690.1-110

Chuck for permanent mounting into a PM press.

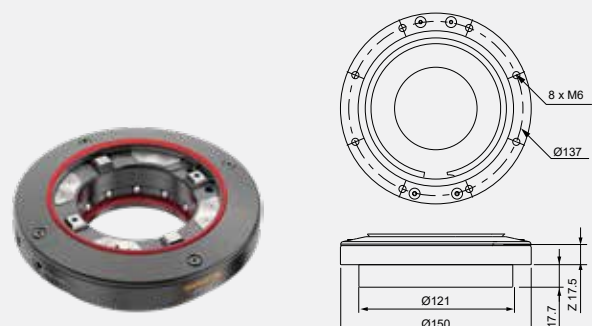
- + Built in height 35 mm
- + Max pressure 25 ton.
- + Required drawbar 3R-695.2-110
- + Weight 2.5 kg.



Pneumatic chuck, Built in, Matrix 110, 3R-SP28219

Chuck for permanent mounting into a PM press.

- + Built in height 25 mm
- + Max pressure 25 ton.
- + Required drawbar 3R-695.2-110
- + Weight 2.5 kg.

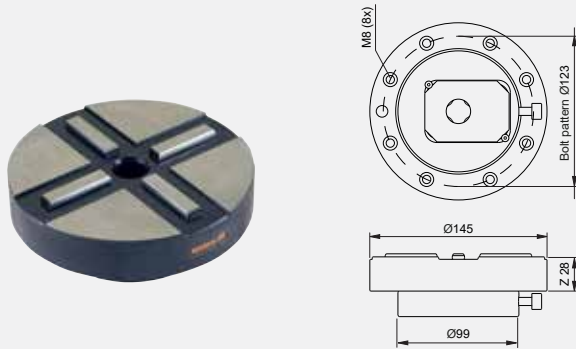


Tooling – Top down choice by size

Chucks

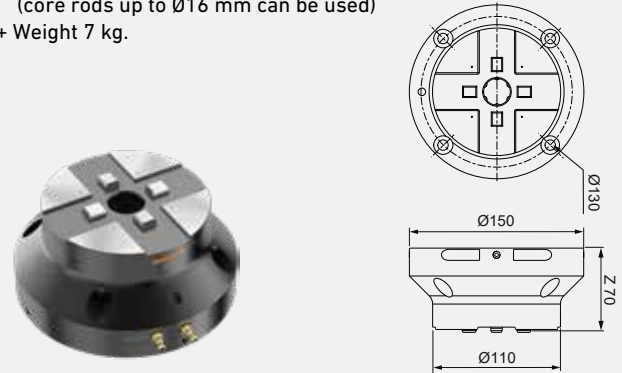
Manual chuck, MacroMagnum, 3R-680.27-150

- + Built in height 28 mm
- + Max pressure 150 ton.
- + Required drawbar 3R-605.11
- + Weight 4.7 kg.



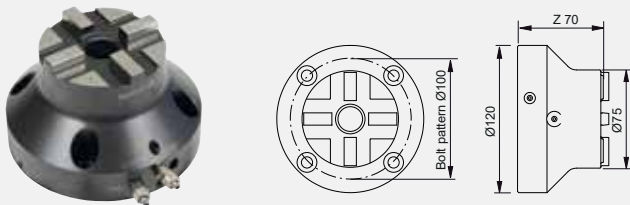
Pneumatic chuck, Macro PM, 90803.60

- + Built in height 70 mm
- + Max pressure 100 ton.
- + Required drawbar 90840.55 (core rods up to Ø16 mm can be used)
- + Weight 7 kg.



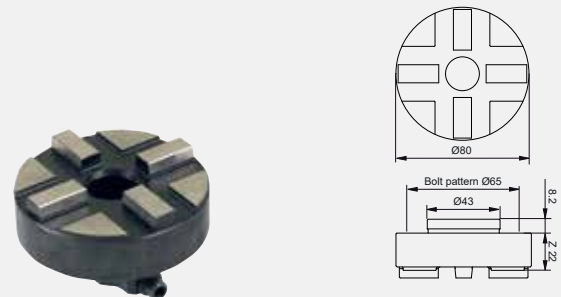
Pneumatic chuck, Macro PM, 3R-600.17-60

- + Air sensor separated from Turbo.
- + Built in height 70 mm
- + Max pressure 64 ton
- + Required drawbar 3R-605.11
- + Weight 3.5 kg.



Manual chuck (built-in) Ø80, Macro PM, 3R-600.27-60

- + Built in height 22 mm
- + Max pressure 64 ton
- + Required drawbar 3R-605.11
- + Torque 6 Nm
- + Weight 1 kg.

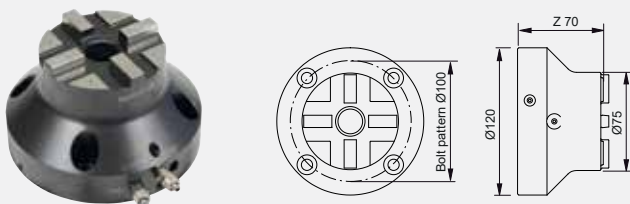


Pneumatic chuck, Macro PM, 3R-600.17-30

- + Air sensor separated from Turbo.
- + Built in height 70 mm
- + Max pressure 32 ton
- + Required drawbar 3R-605.11
- + Weight 3.5 kg

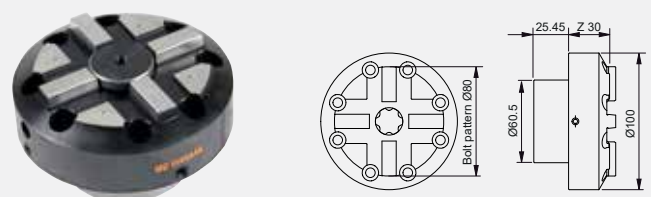
Pneumatic chuck, Macro PM, 90803.50

- + Built in height 70 mm
- + Max pressure 64 ton.
- + Required drawbar 90840.55 (core rods up to Ø16 mm can be used).



Built in chuck, Pneumatic, Macro PM, 3R-600.17-32

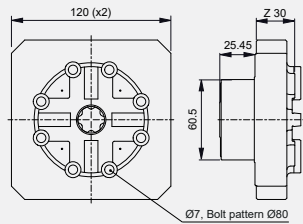
- + Built in height 30 mm
- + Max pressure 32 ton.
- + Required drawbar 3R-605.11
- + Weight 2 kg.



Chucks

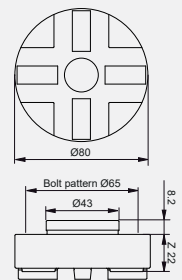
Built in chuck, Pneumatic, Macro PM, 3R-600.17-34

- + Built in height 30 mm
- + Max pressure 32 ton.
- + Required drawbar 3R-605.11
- + Weight 2.9 kg.



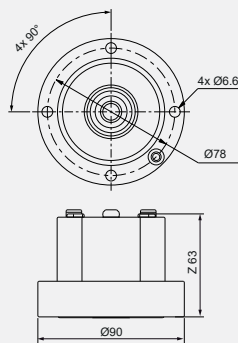
Manual chuck (built-in) Ø80, Macro PM, 3R-600.27-30

- + Built in height 22 mm
- + Maximal pressure 32 ton.
- + Required drawbar 3R-605.11
- + Torque 6 Nm.
- + Weight 1 kg.



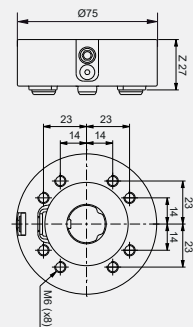
Pneumatic chuck, Macro PM, 3R-600.17-16

- + Built in height 63 mm
- + Max pressure 16 ton
- + Required drawbar 3R-605.11
- + Weight 1.6 kg,



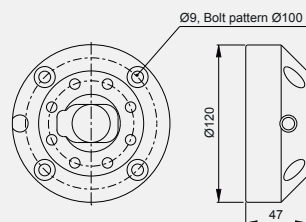
Manual chuck, Macro, D-20173

- + Built in height 27 mm
- + Max pressure 16 ton.
- + Required drawbar 90958
- + Weight 1 kg.



Distance block, Macro PM, 3R-A34249

- For manual Macro chuck, i.e. 3R-600.27-XX.
- + Built in height 47 mm.
- + Weight 2.8 kg.

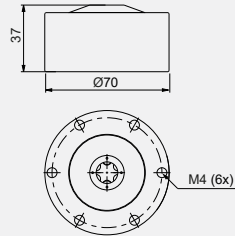


Tooling

Pallets and accessories

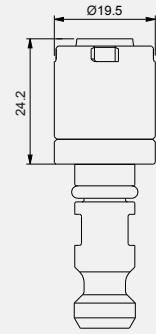
Pneumatic Core rod chuck, D-20175

For holder D-20175.10
+ Built in height 37 mm.



Holder, D-20175.10

Pallet for core rods (Ø10 mm).



Drawbar, Macro, 90840.55

Requires chuck 90803.50.
+ Through hole Ø16 mm
+ Weight 0.2 kg.



Drawbar, Macro, 3R-605.11

+ Through hole Ø10.2 mm
+ Weight 0.2 kg.



Drawbar, Macro, 90958

+ Through hole Ø10.2 mm
+ Weight 0.1 kg.



Note: With automation, the gripper has to grip on the pallet or change drawbar with gripper interface (i.e. 3R-605.1).

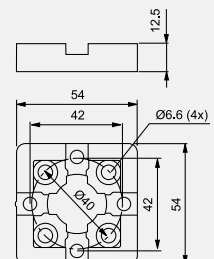
Locking ring key, 3R-605-GE

To lift the locking ring of the drawbars.
+ Supplied in sets of 2.



Pallet 54 mm, Macro, 3R-651.7E-P

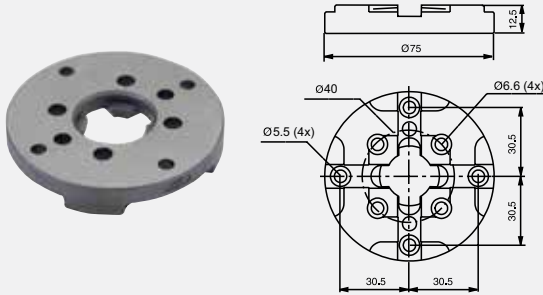
+ Max press force: 16 ton.
+ Supplied in set of 8 pcs
+ Rust resistant material
+ Size 54 x 54 x 12.5 mm
+ Weight 0.2 kg/pc.



Pallets

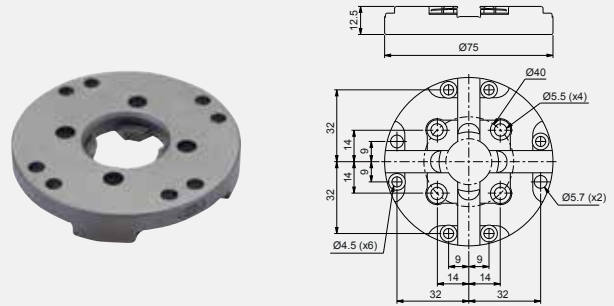
Pallet Ø75 mm, Macro, 3R-651.75E-P

- + Max press force: 32 ton.
- + Supplied in set of 10 pcs
- + Rust resistant material
- + Size Ø75 x 12.5 mm
- + Weight 0.3 kg/pc.



Pallet Ø75 mm, Macro, 3R-651.75-50E

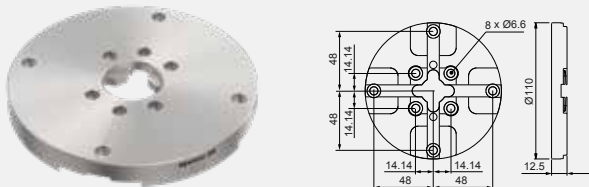
- + Max press force: 64 ton.
- + Supplied in sets of 10 pcs.
- + Rust resistant material
- + Size Ø75 x 12.5 mm
- + Weight 0.3 kg/pc.



Pallet Ø110 mm, Macro, 90506.06

Hardened pallet with clearance holes for fixing screws.

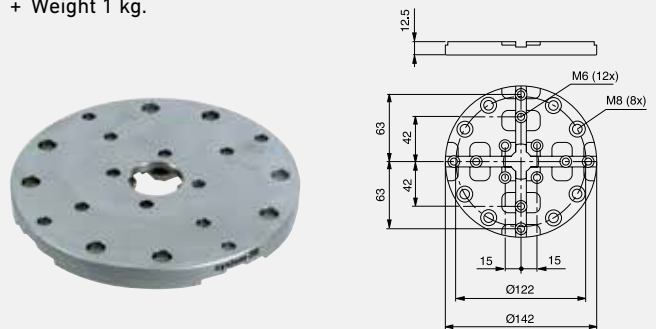
- + Max press force: 100 ton.
- + Rust resistant material
- + Size Ø110 x 12.5 mm
- + Weight 0.7 kg.



Pallet Ø142 mm, MacroMagnum, 3R-681.71

Hardened pallet with clearance holes for fixing screws.

- + Max press force: 150 ton.
- + Rust resistant material
- + Size Ø142 x 12.5 mm
- + Weight 1 kg.

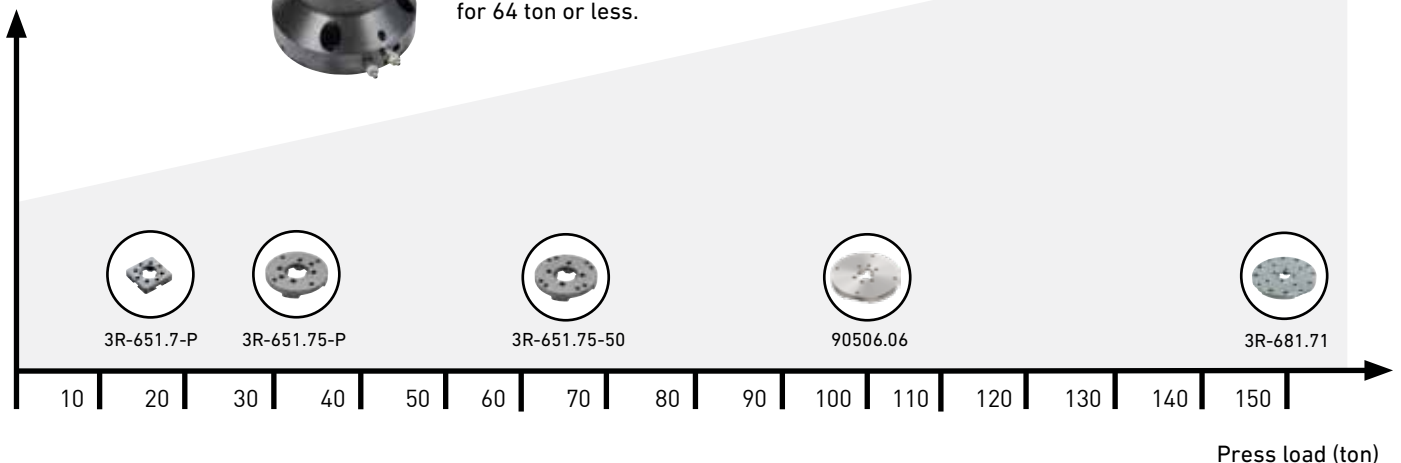


Choice of chuck, sets permissible max press load for punches

Price on consumables pallets



Example: MacroPM chuck, 3R-600.17-60
Max. Press force: 64 ton.
Alternate between pallets for 64 ton or less.

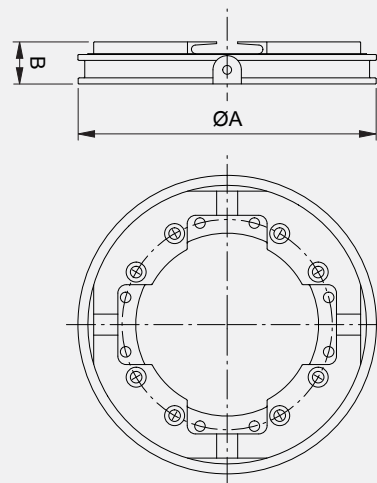


Pallets and accessories

Pallets, Matrix

- + Rust resistant material
- + Adapted for automatic changing.

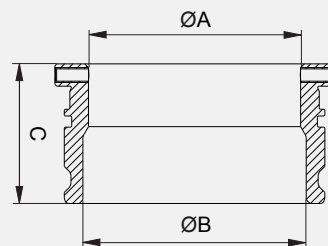
Note: Not self carrying, requires extra support.



Art. No	A (mm)	B (mm)	Press load (ton)	Drawbar	Weight (kg)
3R-691.1-110	110	20	25	3R-695.2-110	0.5
3R-691.1-142	142	20	50	3R-695.2-142	1.2
3R-691.1-185	185	20	100	3R-695.2-185	1.7
3R-691.1-220	220	25	150	3R-695.2-220	2.6
3R-691.1-260	260	25	200	3R-695.2-260	3.2

Drawbars, Matrix

Note: In automation the gripper has to grip on the pallet and not on the drawbar.



Art. No	A (mm)	B (mm)	C (mm)	Weight (kg)
3R-695.2-110	57	60	38	0.3
3R-695.2-142	67	76	45.5	0.5
3R-695.2-185	112	119	45.5	0.8
3R-695.2-220	147	149	45.5	1.3
3R-695.2-260	187	189	45.5	1.5

Torque wrench, 4 Nm, 3R-614-04

Intended for Ø10 mm 3Refix mandrels.

- + 4 Nm.

Torque wrench, 6 Nm, 3R-614-06

Intended for Macro manual chucks.

- + 6 Nm.



Torque wrench, 10 Nm, 3R-914-10

Intended for Ø20 mm 3Refix mandrels.

- + 10 Nm.



Air unit, 90125.25-05

Includes status indicators.

- + Weight 1 kg.

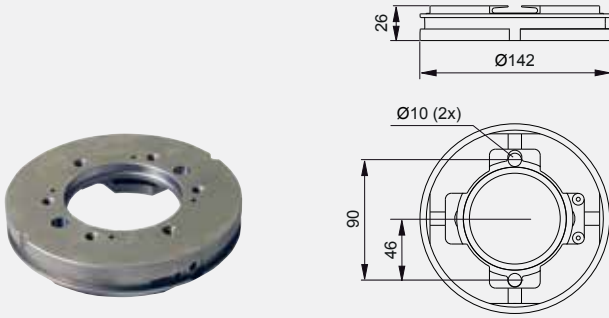


Pallets and accessories

Adapterpallet Matrix 142-3Refix Ø10, 3R-SP29388

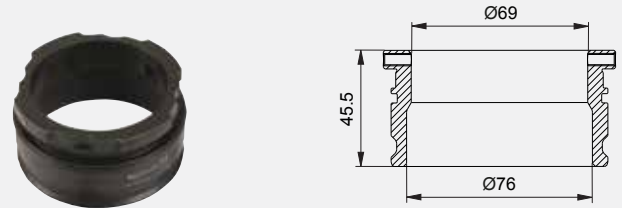
Adapterpallet Matrix 142 to 3Refix (44/46) for dies.

- + Required drawbar 3R-SP29403
- + Weight 1.6 kg.



Matrix 142-3Refix Drawbar, 3R-SP29403

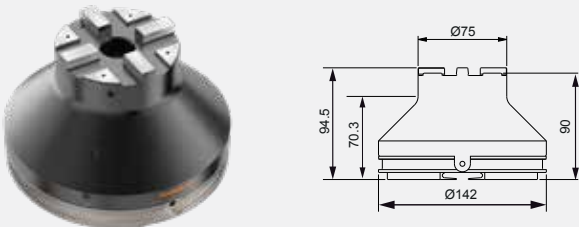
Special Matrix 142 drawbar for adapterpallet 3R-SP29388.



Chuck adapter, Matrix 142-Macro, 3R-SP33230

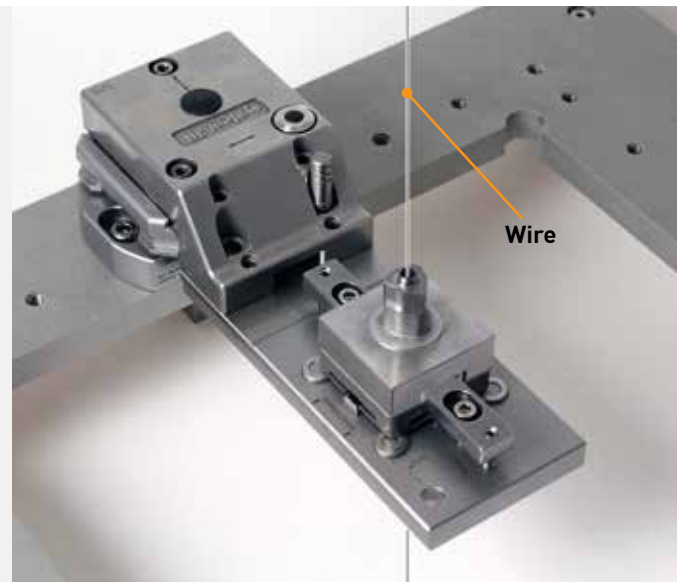
From Matrix 142 into Macro system. Chuck adapter with built-in Macro chuck.

- + Built in height 90 mm
- + Hardened references
- + Maximal pressure 50 ton.
- + Required drawbar 3R-605.11
- + Weight 7 kg.



Fixture for punch on Macro, 90238

Fixture for punch on Macro, in order to wire-cut a through hole within Ø20 mm.



Accessories

Force gauge press Ø72 mm, 3R-SSP122

Intended for checking clamping force of Matrix chucks and for those Macro chucks found in compacting machines (due to cramped and limited space inside machine). In order to check Matrix chucks, see additional converter kits 3R-SSP115-Matrix XXX enabling checking.



Force gauge regular, 3R-SSP115-BASE

Intended for checking clamping force of Matrix chucks and for those Macro chucks found in non-compacting machines. In order to check Matrix chucks, see additional converter kits 3R-SSP115 Matrix xxx enabling checking.

Converter kit, 3R-SSP115 Matrix 110

Added kit to enable checking Matrix 110 chucks.

Converter kit, 3R-SSP115 Matrix 142

Added kit to enable checking Matrix 142 chucks.

Converter kit, 3R-SSP115 Matrix 185

Added kit to enable checking Matrix 185 chucks.



Index blocker-pin, 3R-SP29196

To disable indexing feature on Matrix 110 chucks.
+ Delivered 1 pc.



Index blocker-pin, 3R-SP29533E

To disable indexing feature on Matrix 142 and 185 chucks.
+ Delivered 2 pcs.



Accessories

Index blocker-pin, 3R-SP29559E

To disable indexing feature on Matrix 220 and 260 chucks.

+ Delivered 4 pcs.



Handle, Matrix 110, 3R-692.7-110

Handle to circumvent pallet for easier lift off chuck.

Comes by different sizes.



Handle Matrix 142, 3R-692.7-142

Handle to circumvent pallet for easier lift off chuck.

Comes by different sizes.



Handle, Matrix 185, 3R-692.7-185

Handle to circumvent pallet for easier lift off chuck.

Comes by different sizes.



Handle Matrix 220, 3R-692.7-220

Handle to circumvent pallet for easier lift off chuck.

Comes by different sizes.



Lifting device, 3R-692.8-142

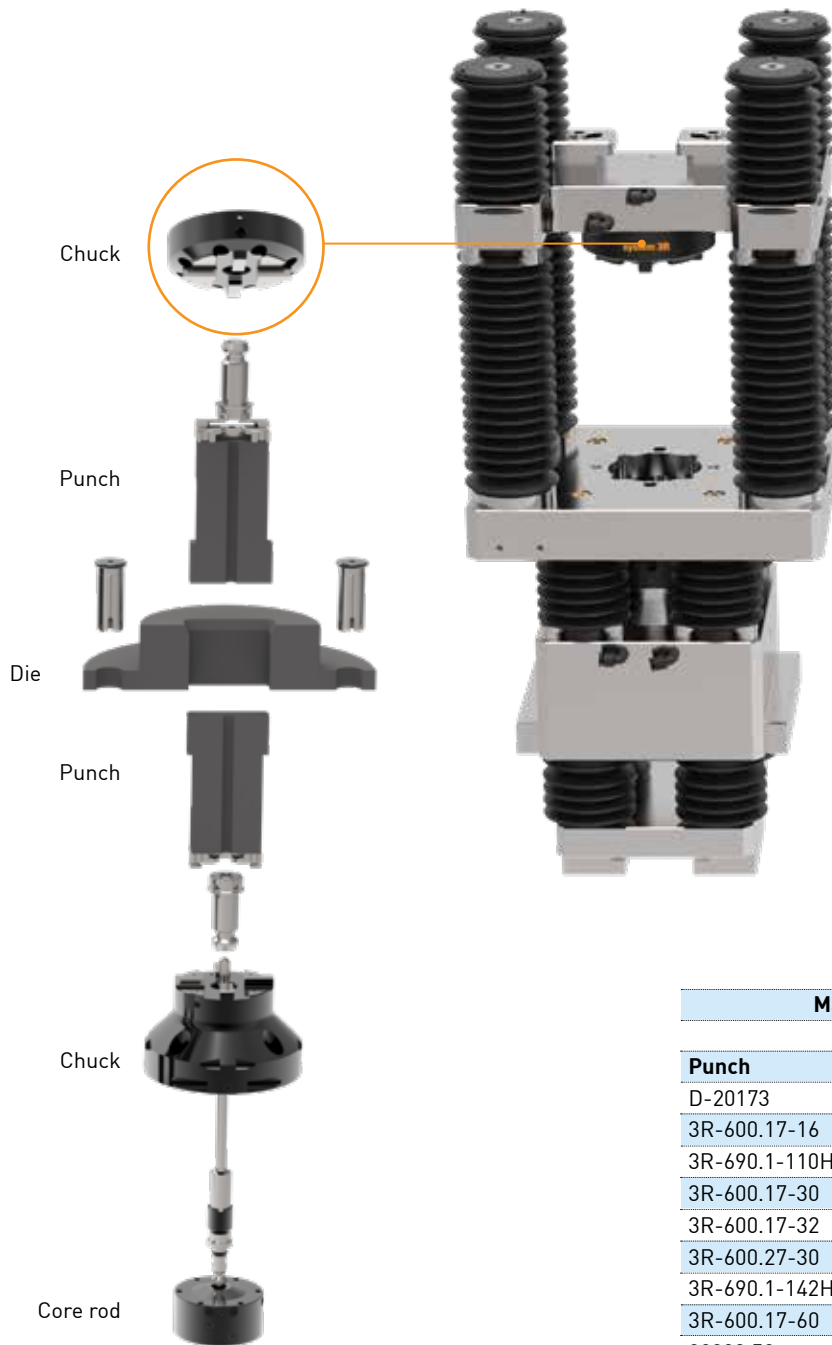
In combination with 3R-692.7-110 and 3R-692.7-142 to enable lift by crane.

Lifting device, 3R-692.8-220

In combination with 3R-692.7-185 and 3R-692.7-220 to enable lift by crane.



How to make a configuration



						Die									
		Manual or Pneumatic		M	M	P	P	P	P	P	P	P	P	P	P
		Build On or Build In		I	I	O	O	I	O	I	O	I	O	I	I
		Punch													
	D-20173	16	10	M	O	■	-	■	■	■	-	-	-	-	-
	3R-600.17-16	16	10	P	O	■	-	■	■	■	-	-	-	-	-
	3R-690.1-110HD	25	55	P	I	■	-	-	-	-	■	■	-	-	-
	3R-600.17-30	32	10	P	O	■	-	■	■	■	-	-	-	-	-
	3R-600.17-32	32	10	P	I	■	-	■	■	■	-	-	-	-	-
	3R-600.27-30	32	10	M	O	■	-	■	■	■	-	-	-	-	-
	3R-690.1-142HD	50	67	P	O	■	-	-	-	-	-	-	-	■	■
	3R-600.17-60	64	10	P	O	■	-	■	■	■	-	-	-	-	-
	90803.50	40	16	P	O	■	-	■	■	■	-	-	-	-	-
	3R-600.17-62	64	10	P	I	■	-	■	■	■	-	-	-	-	-
	3R-600.27-60	64	10	M	O	■	-	■	■	■	-	-	-	-	-
	90803.60	100	16	P	O	■	-	-	-	-	■	■	-	-	-
	3R-690.1-185	100	110	P	O	-	■	-	-	-	-	-	-	-	-
	3R-690.1-220	150	145	P	O	-	■	-	-	-	-	-	-	-	-
	3R-680.27-150	150	10	M	I	-	■	-	-	-	-	-	-	■	■
	Force (Ton)														
	Core rod (Ø mm)														
	Manual or Pneumatic														
	Build On or Build In														

Accessories

Punch alignment system, D-20158-BASE

This fixture enables adjustment of punches within metal powder compacting by Macro system. The fixture is a stand-alone unit. It is possible to replace the indicators with electrical sensors. Free access from underneath, to access fixation-screws for the pallets.

- + Linear probes, 3 pcs
- + Measuring accuracy for the probes
 - deviation: 0.2 μm
 - repetition error: 0.05 μm
 - applied pneumatic pressure: 1.1-1.5 bar

Accessory kits for (supplied separately):

- Macro 54
- Macro 75
- Matrix 110
- Matrix 142



Alignment tool & control Z-distance, Macro PM, 90909

Alignment and control tool for the Macro + 3Refix system in PM. Alignment is rough but helps reduce assembly time before final verification and alignment with verification tools. Also to be used to check parallelism between punch levels versus die-plate-level.

- + Dimensions: $\varnothing 115 \times 75$ mm
- + cc. 3Refix $\varnothing 10$ mm: 46+44 mm
- + Weight: 2.1 kg.



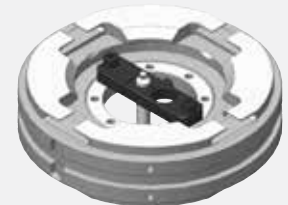
Die unit for Z-distance, Matrix 142, D-20198-DZxx

Requires computer etc by D-20189-BASE.

To be used in combination with punch unit D-20198-Zxx.

Punch unit for Z-distance, Macro, D-20198-Zxx

To be used in combination with die unit D-20198-DZxx.



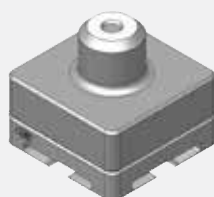
Tool for Z-distance, Macro, D-20198-ZXX

Tool to establish Z-distance in combination with either 3Refix or Matrix 142 pallet. This unit requires additional tool.

It is possible to apply electrical or mechanical indicators while measuring top surface.

Note: Linear probe is not included.

- + Built in height 50 mm
- + Requires drawbar 3R-605.11 or similar.



Aligning equipment for all chucks in the press – Verifying tool, HP



Software makes it easy to read and follow the steps.
Formal document is possible to print and/or store after alignment.

Verification set – High Performance

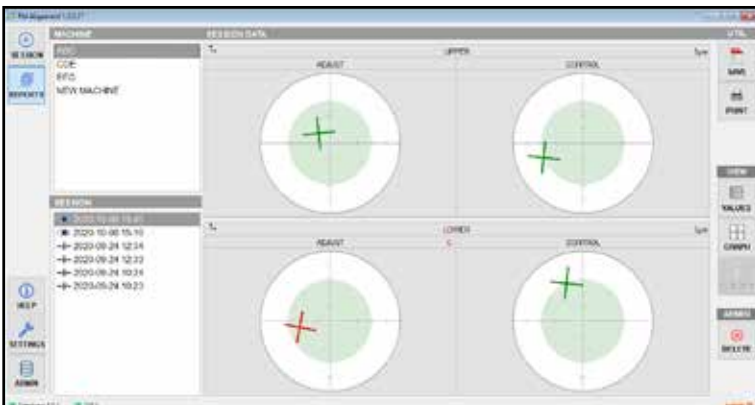
A set of probes with limited pressure point to measure location thus establish deviation by less than 0.1 μm within a second. Handheld computer allows operator to bring it inside the machine for better monitoring of exact location while checking alignment. After each chuck for punch has been aligned, values may be printed or stored. Sets for punches and die to be applied, are sold separately and made available by various tooling interfaces.

Contents:

Computer set for PM alignment, D-20189-BASE

- + Lap-top
- + Software
- + Signal converter
- + Pneumatic control unit
- + Pneumatically operated probes (3x)

Custom made and suitable tools are ordered separately. This goes for the die and punch(es) and includes required accessories.



PRESS ALIGNMENT PROTOCOL				Type		Measure date and time				
Machine	TST-001	ADJUST SESSION		2020-10-08 14:01:24			Operator			
Die serial no	1100	Die fixture pos	Y0	Die revision	1					
Punch serial no	1056	Punch revision	1							
Comment										
MEASURED VALUES										
CHUCK	POS	X	Y	C	R	A	B	LVL	H	dH
UPPER	ADJ	3.5	2.8	4.0	4.5	65	65.0	...
UPPER	CTRL	-1.3	1.2	2.0	1.8	2.0	6.0	145	145.0	80.0
LOWER	ADJ	-3.5	-5.2	-3.1	6.3	65	65.0	...
LOWER	CTRL	-1.0	-2.7	0.4	2.9	-5.0	-5.1	115	115.0	50.0
MEASURED POSITIONS										
UPPER				LOWER						
ADJUST		CONTROL		ADJUST		CONTROL				
ACCEPTED DEVIATIONS				UNITS						
X,Y	C	R	A,B	X,Y	C	R	A,B			
±5.5	±10.1	+7.0	±7.0	μm	$\mu\text{m}/100\text{mm}$	μm	$\mu\text{m}/100\text{mm}$			
PAGE 1/1										

Other Tooling – MacroNano and MatrixNano*

- + Extremely high accuracy.
- + High-precision machines are linked together in the production chain, without detracting from the extreme accuracy.
- + Feedback to the machine for supplementary machining after inspection is possible. This feedback is only meaningful if the pallet system is at least as accurate as the measuring machine.

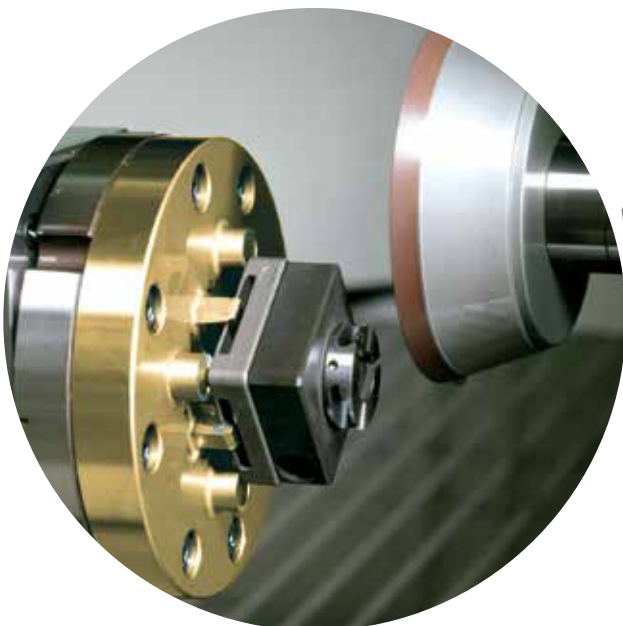
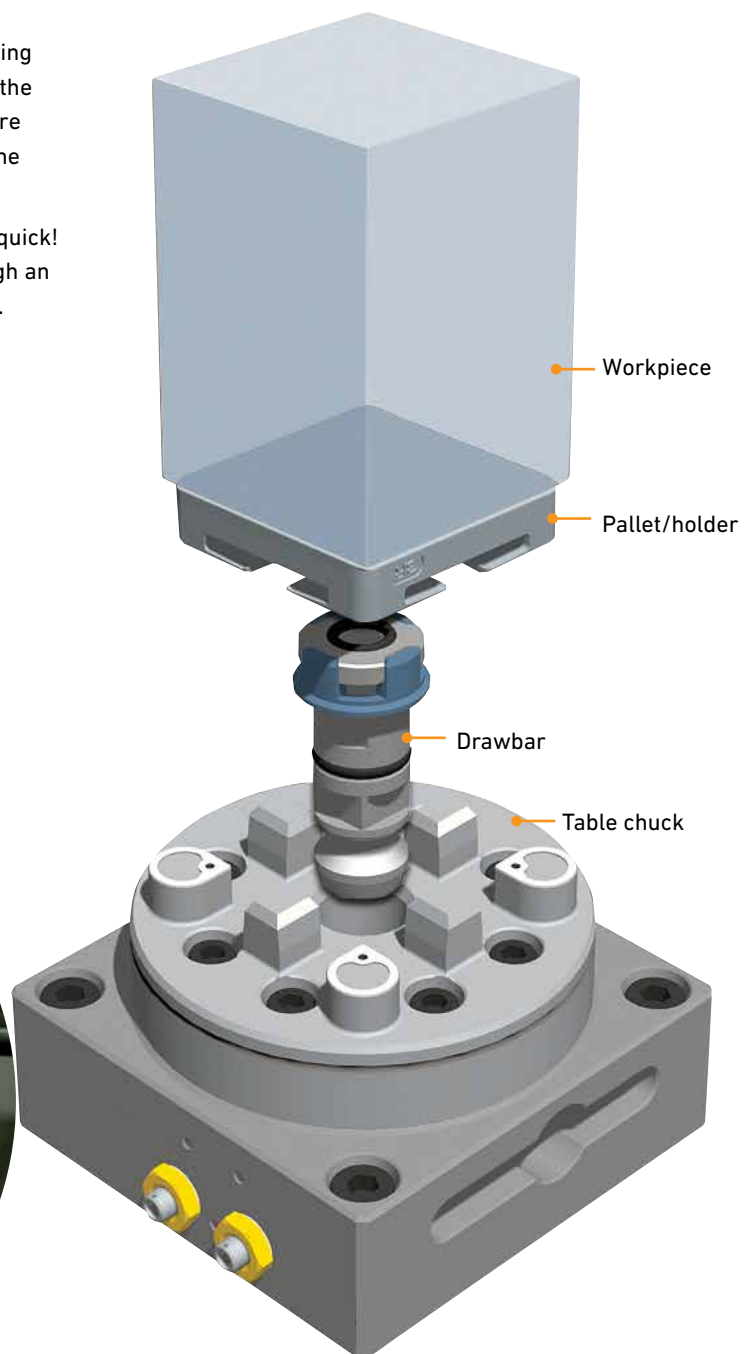
* Matrix 110 and Matrix 142

Workholding for Nano Precision

Nano-precision machining requires nano-precision referencing of workpieces and tools- a real challenge even with state of the art solutions available in the market. This becomes even more challenging when the references need to be established in the shortest possible time.

Nano system is best described in two words as precise and quick! The Nano clamping system links the production chain through an ultra-precision coupling both for workpiece and tool holding.

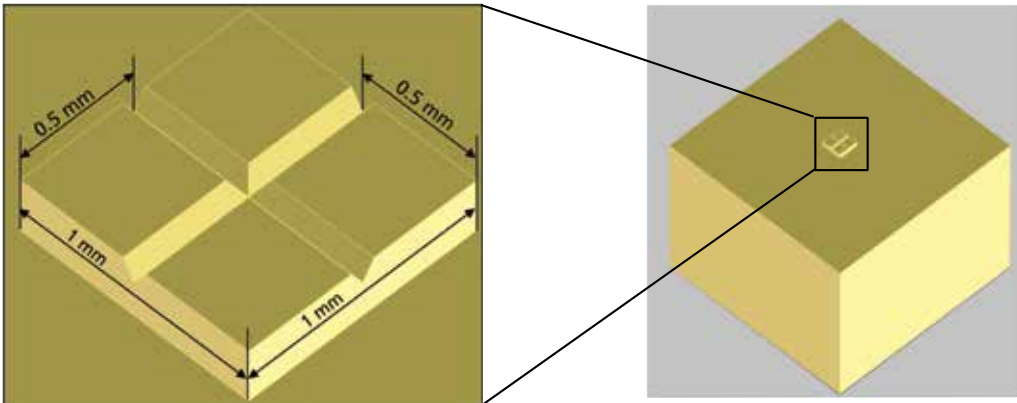
- + Repetition accuracy – within 0.001 mm
- + Fixed index positions 4x90°
- + Required air pressure, pneumatic chuck – 6±1 bar



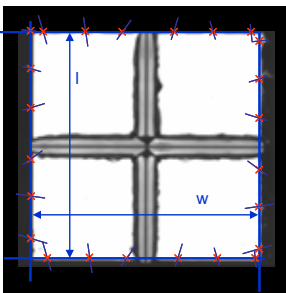
MacroNano

Application example: Microstructuring with Diamond Machining

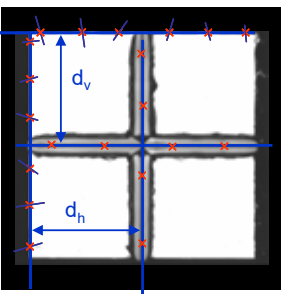
Micro features produced with nano precision



This micro structure is produced by Diamond Flycutting operations on two different machines, each equipped with a MacroNano chuck. The square in the middle of the workpiece (right picture) is produced by plane milling on 1st machine, making use of indexing feature of the MacroNano system. The pallet carrying the workpiece is then transferred to the chuck on 2nd machine to produce the micro-grooves, once again using the indexing feature. The zero reference was determined only once on the 1st machine and then carried through the whole process chain using both the indexing precision and the system precision of the MacroNano system; overall structure deviation is less than 0.5 micron.



Measurement of the cube dimensions

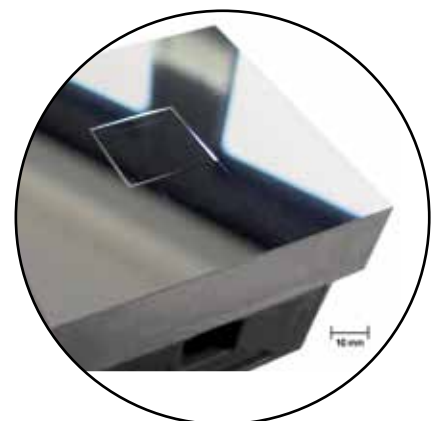
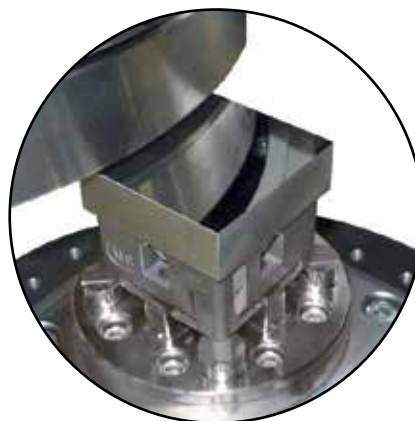


Measurement of groove positions

	Width (mm)	Length (mm)	Vertical dist. (mm)	Horizontal dist. (mm)
W_1	0.9996	l_1 0.9999	d_{v1} 0.4988	d_{h1} 0.5013
W_2	0.9996	l_2 0.9999	d_{v2} 0.4993	d_{h2} 0.4995
W_3	0.9996	l_3 0.9999	d_{v3} 0.4996	d_{h3} 0.5001
W_4	0.9997	l_4 0.9999	d_{v4} 0.4991	d_{h4} 0.4995
W_5	0.9996	l_5 0.9998	d_{v5} 0.5010	d_{h5} 0.5001
W_6	0.9996	l_6 0.9998	d_{v6} 0.5007	d_{h6} 0.5002
W_7	0.9997	l_7 0.9999	d_{v7} 0.4996	d_{h7} 0.5012
W_8	0.9996	l_8 0.9999	d_{v8} 0.4992	d_{h8} 0.5009
W_9	0.9997	l_9 0.9999	d_{v9} 0.4996	d_{h9} 0.5009
W_{10}	0.9996	l_{10} 0.9998	d_{v10} 0.4998	d_{h10} 0.5008
W	0.9996	l 0.9999	d_v 0.4997	d_h 0.5004

Mean values

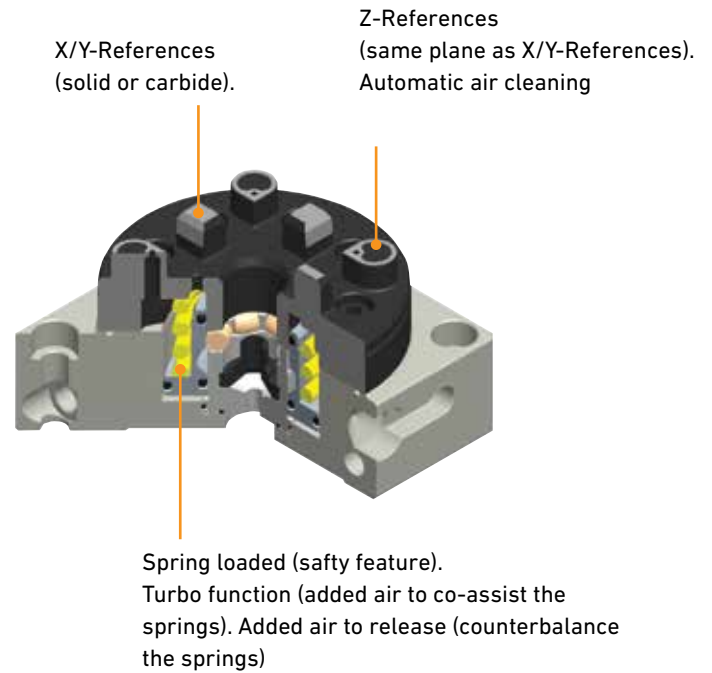
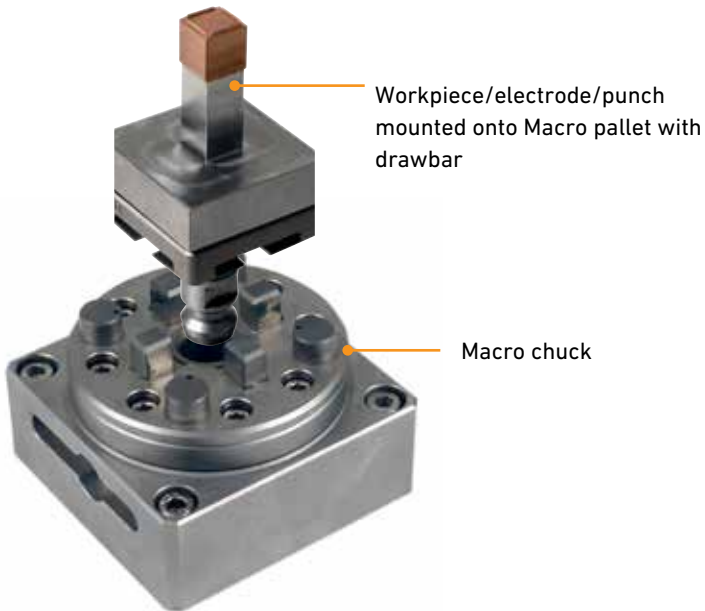
Overall structure deviation < 0.5 μ m



Tooling Technology

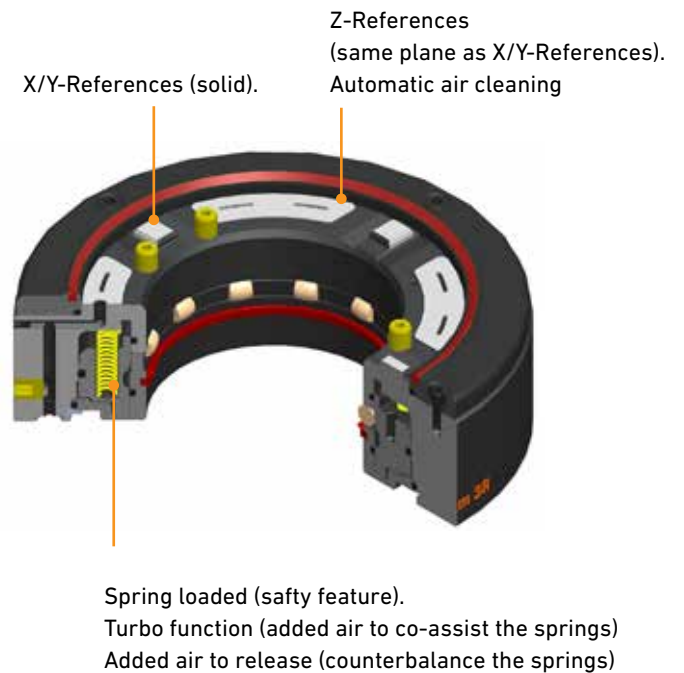
The Macro system for punches

Choice of reference element is determined by required pressing force.



Note: Recommended air pressure, pneumatic chuck 6 ± 1 bar.

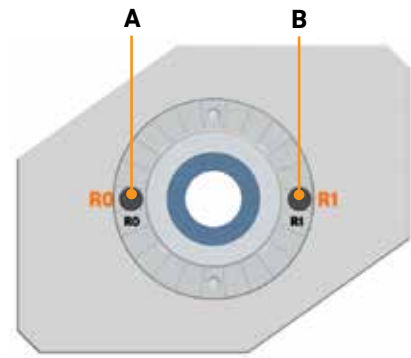
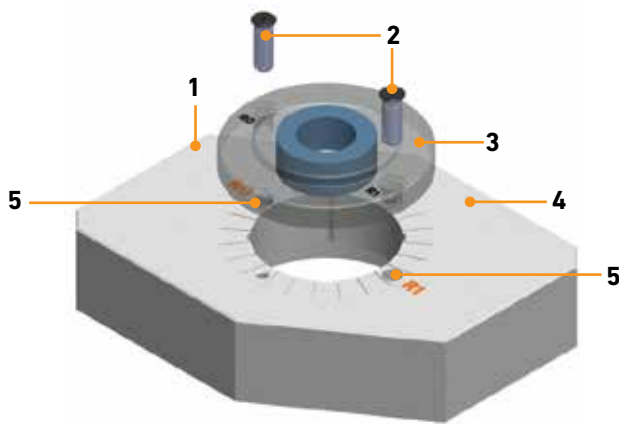
The Matrix system for dies and punches



Note: For the entire product range see www.system3r.com

3Refix for dies

3Refix is a cost effective solution. The 3Refix expanding mandrels (2 pcs) determines the position. First 3Refix mandrel is to determine X/Y-position and the second to determine the angle.



Description

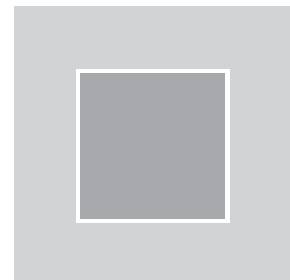
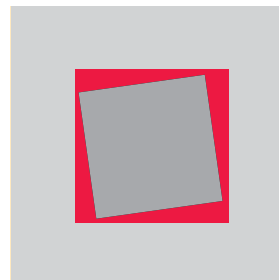
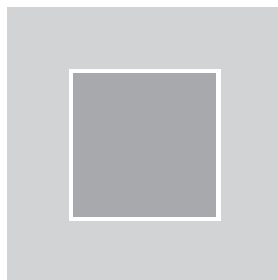
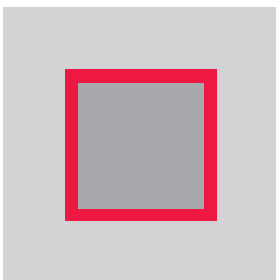
- 1 Z-reference surface
- 2 3Refix mandrels
- 3 Customer made die
- 4 Die plate (table)
- 5 Die plate only requires two holes for 3Refix mandrels

Procedure (always)

- A Tighten R0 (primary)
- B Tighten R1 (secondary)

Positioning accuracy
Improved positional accuracy.
Closer tolerances for finer grains.

Angular accuracy
Smaller angular deviations
Less wear and damage to punch and die.



Conventional setting-up

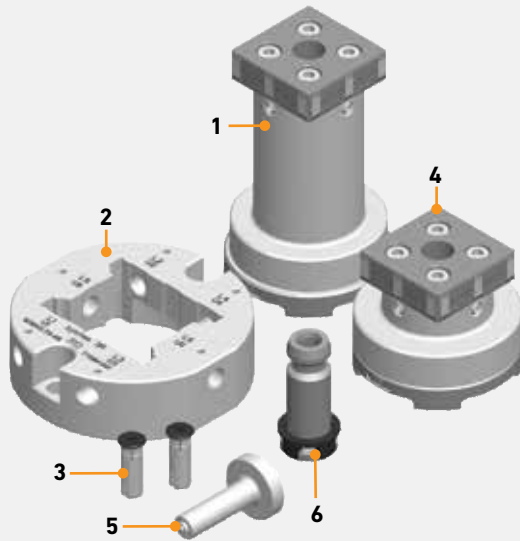
Setting-up with System 3R

Conventional setting-up

Setting-up with System 3R

Tooling Technology

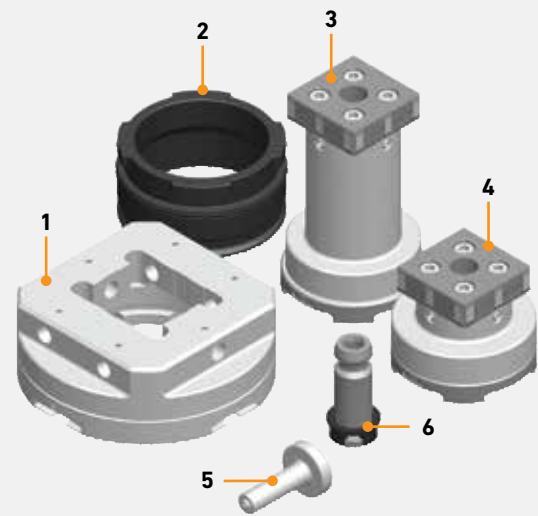
For Single-level press, 3Refix



- 1 Lower punch (Macro)
- 2 Die pallet to hold dial indicators
- 3 3Refix Ø10 mm
- 4 Upper punch (Macro)
- 5 Pre-set tool
- 6 Drawbar (Macro)

Note: Dial indicators are optional.

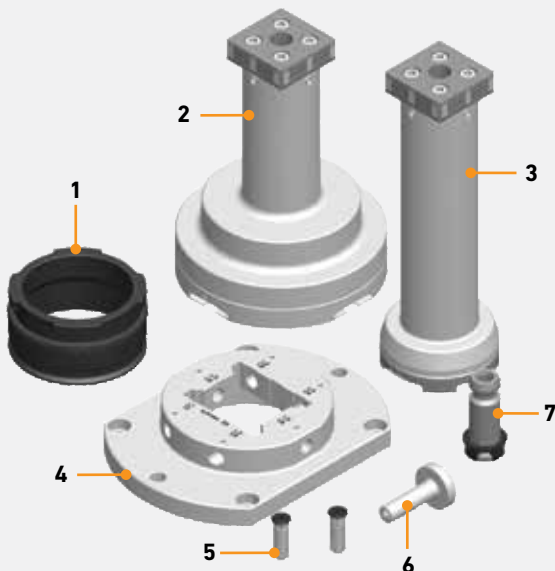
For Single-level press, Matrix 142



- 1 Die pallet to hold dial indicators (Matrix 142)
- 2 Drawbar (Matrix 142)
- 3 Lower punch (Macro)
- 4 Upper punch (Macro)
- 5 Pre-set tool
- 6 Drawbar (Macro)

Note: Dial indicators are optional.

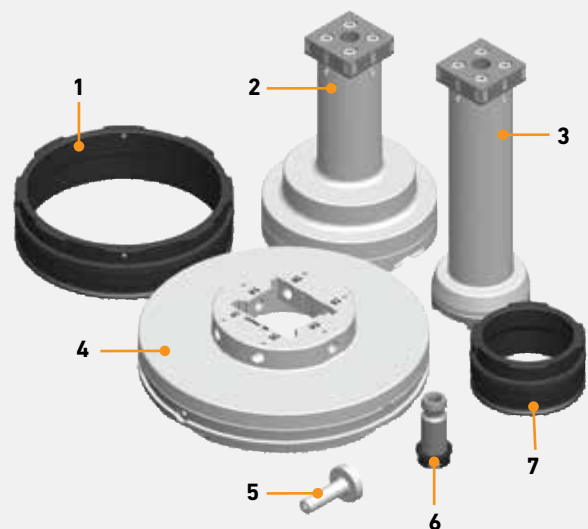
For Multi-level press, 3Refix



- 1 Drawbar (Matrix 142)
- 2 Outer punch (Matrix 142)
- 3 Inner punch (Macro)
- 4 Die pallet to hold dial indicators
- 5 3Refix Ø10 mm
- 6 Pre-set tool
- 7 Drawbar (Macro)

Note: Dial indicators are optional.

For Multi-level press, Matrix220



- 1 Drawbar (Matrix 220)
- 2 Outer punch (Matrix 142)
- 3 Inner punch (Macro)
- 4 Die pallet to hold dial indicators (Matrix 220)
- 5 Pre-set tool
- 6 Drawbar (Macro)
- 7 Drawbar (Matrix 142)

Note: Dial indicators are optional.

VDP (Vibration-Damped Palletisation)

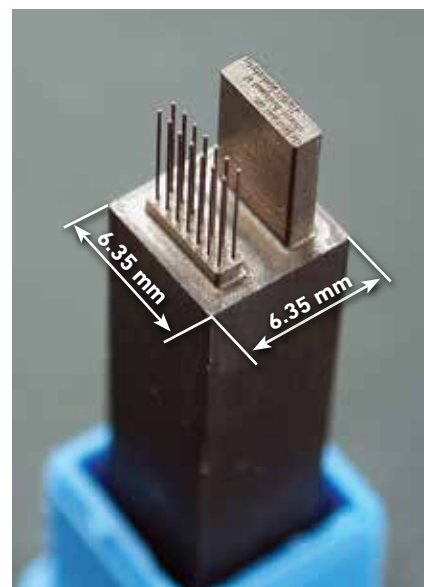
- + improve your surface finish.
- + reduces cutting forces by up to 25%. Lower cutting forces gives lower power consumption and less tool wear.
- + lengthens tool life tool wear by up to 30%, giving lower tool costs.
- + lengthens the life of the machine spindle. Less vibration in the machine spindle extends the life of the spindle by at least 30%.
- + gives shorter lead times. VDP allows machining with higher cutting data – better utilisation of the existing machine capacity. A 30 % capacity increase is within your reach.

With conventional chucks, vibrations of the workpiece caused by the dynamic forces due to the action and rotation of the cutting tool. Restrictions therefore have to be imposed on the rotation speed and feed rate of the cutting tool, to prevent instability and to achieve the necessary surface quality.

Advantages of a damped chuck

After intensive research into the dynamics of chuck systems, machine tool maker System 3R has developed and patented a chuck with vibration-damped palletisation (VDP). By reducing the vibrations of the workpiece and a considerable proportion of the vibrations of the cutting tool, the VDP technology improves the dynamics of the entire metal cutting process. This means that machine tools can be operated at higher speeds with greater accuracy and at the same time with less wear. Workpieces can usually be produced in a single operation within strict dimensional tolerances and with a surface quality in the micrometer range – a millionth of a metre.

- + Better surface finish reduces the need for finishing.
- + Higher material removal rate improves productivity.
- + Less tool wear extends the life of the cutting tools.
- + Less vibration in the machine spindle.
- + Better dimensional accuracy gives fewer rejects.
- + Greater scope for machining difficult materials and complex shapes.
- + Shorter lead times thanks to a higher material removal rate.
- + Lower noise level during machining.



Example Micro Milling:

VDP advantages: The electrode Aspect Ratio (L/ Ø) was doubled with VDP.

Dimensions: Ø 0.134 mm, length 4.8 mm

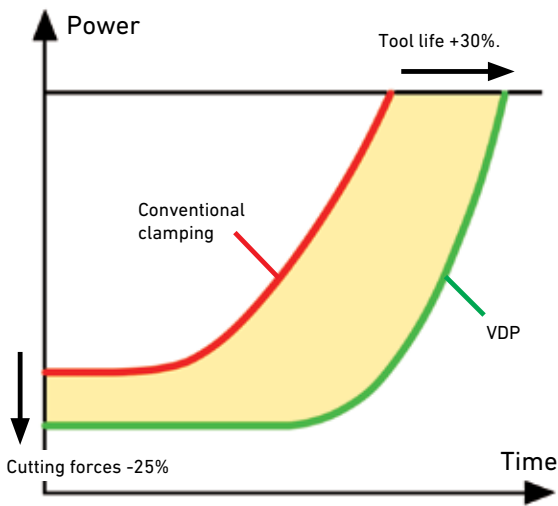
Increase your capacity with > +30%



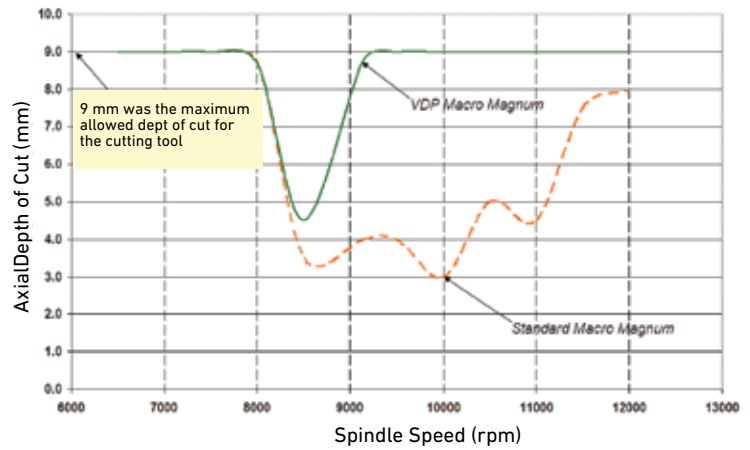
WITH



WITHOUT



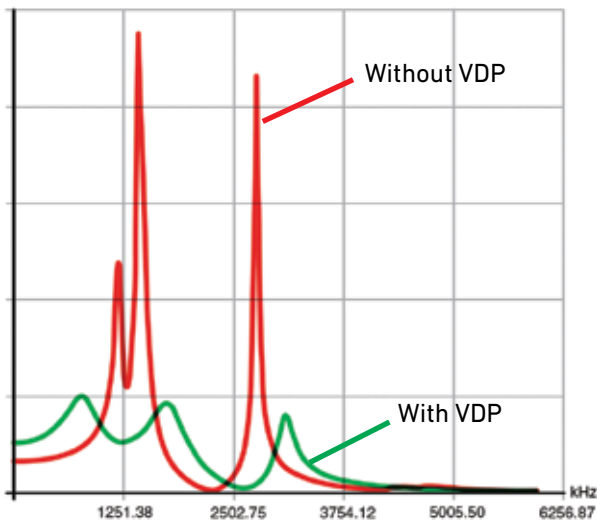
Less tool wear extends the life of the tools = increased revenue.



Process Stability Analysis (Swiss machine tool manufacturer)

Cutting Speed (RPM)	Axial Depth of Cut (mm)		Increase in removal rate due to VDP (%)
	Magnum Std	Magnum VDP	
8500	3.5	4.5	28.6
9000	4.0	9.0*	125
10000	3.0	9.0*	200

Depth of cut is limited by the cutting tool used for the tests and not by the VDP.



The diagram shows the effect on the oscillation amplitude when machining with the workpiece clamped conventionally and in a damped chuck.

Automation

Utilise every hour of the day and night!

An automatic production cell can generate revenue round the clock, seven days a week. Why be satisfied with 40 productive machine-hours a week when the same machine can achieve over 100 additional hours a week? Use every hour of the day and night for production!

WorkPal 1, WorkPartner 1+ and Transformer 6-axis robot - three "aces" which boost your productivity and sharpen your competitiveness.

And not least – they bring faster payback on the investments you made.



WorkPal 1

– modest demands, major benefits



WorkPartner 1+

– can serve two machines



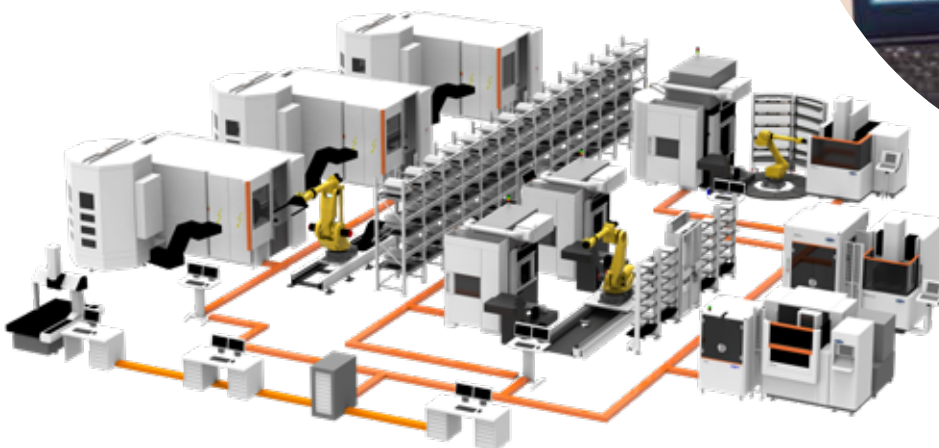
Automation – with 6-axis industrial robot

WSM – WorkShopManager

User-friendly Cell Management Software

Master workshop complexity and manage all control processes with our software. For manually controlled and automated processes.

- + Simplify the preparation of jobs
- + Easily execute the jobs in manual or automated machines
- + Monitor the process, change priorities and get utilization statistics
- + ID chip management to ensure highest process security.



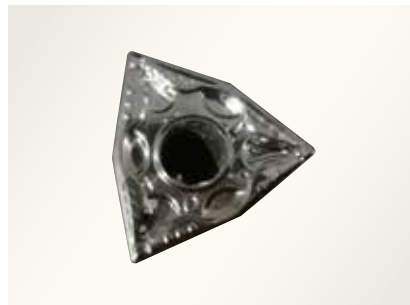
Productivity in effect

- + Simple, quick set-up
- + High accuracy
- + Low scrap rate
- + Maximal machine utilization
- + Increased productivity



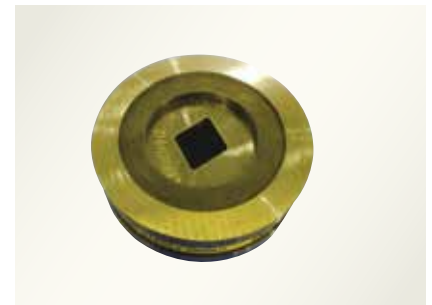
Punch Electrode

Materials: Tungsten copper carbide
Accuracy: $\pm 2 \mu\text{m}$
Surface quality: Ra 0.06 μm



Punch of carbide inserts

Materials: Cemented Carbide
Accuracy: $\pm 2 \mu\text{m}$
Surface quality: Ra 0.2 μm



Die of carbide inserts

Materials: Cemented Carbide
Accuracy: $\pm 2 \mu\text{m}$
Surface quality: Ra 0.1 μm



Powder Compacting Technology
– Produced details

Optimize the uptime of your equipment with our Customer Services

System 3R's Customer Services is uniquely positioned to help you maximize the availability, value, precision and productivity of your System 3R equipment. Our cost-effective, customer-centric and expert services put your success at the center, ramp up your productivity and ensure predictable, uninterrupted uptime. System 3R's service engineers are your expert partners for a wide range of success-triggering services.

For more info ask your local System 3R dealer.

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