Fixturing systems

Clamping sets for Mahr MarVision MM 500 & MM 500 CNC





dk
FIXIERSYSTEME

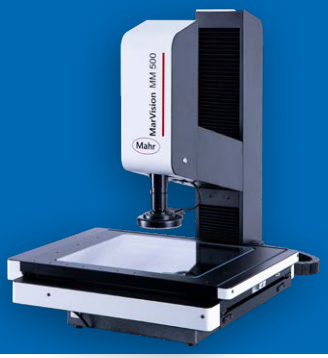
Clamping sets for Mahr MarVision MM 500 measuring microscopes



A basic rail configuration adapted to the respective equipment size and two universal fixating element sets form the basis for perfect alignment and fixation of many different parts. The MM 500 series fulfils various measuring tasks just as flexibly as the modular clamping system from dk solves the associated fixating requirements. The measuring device is suitable for measuring turned, milled, injection-moulded, punched and bent parts, and the basic equipment sets are also designed for this purpose.

Measuring close to production as supported by dk with the quick-change pallet: set-ups outside the metrology machine serve to achieve maximum performance as a result of minimising unproductive machine downtimes as well as simplifying the overall process.

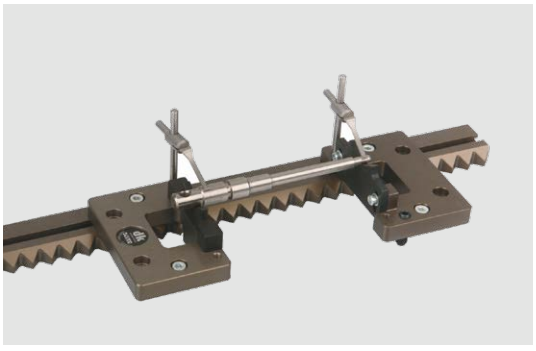
For special part geometries, many proven fixation elements that are 100% compatible with these basic sets can be found in the dk main catalogue with over 1,000 items. This means that the basic sets can be expanded indefinitely and adapted to any future requirements in terms of products and processes. Multi-clamping set-ups and special designs can also be realised without any problems.



Application examples

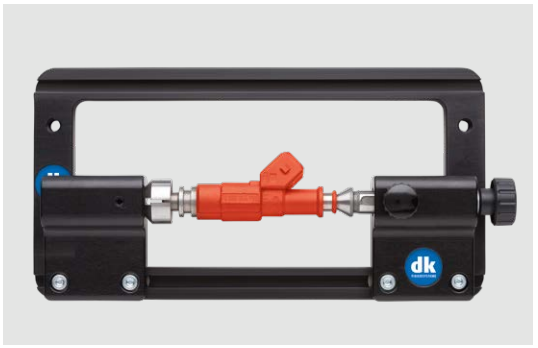












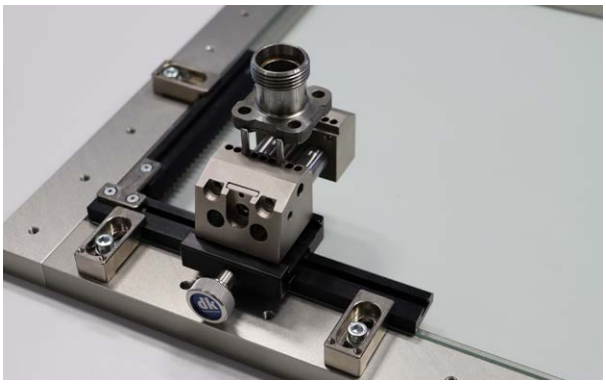
Fixation set for turned parts

Maximum modularity for optimum application flexibility

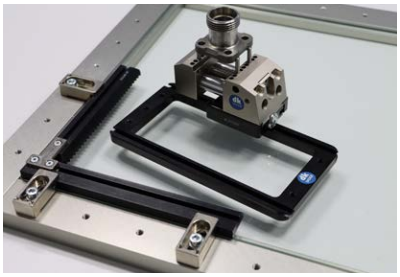
SCHIENENFIX – the fixating system for multi-sensorial metrology equipment

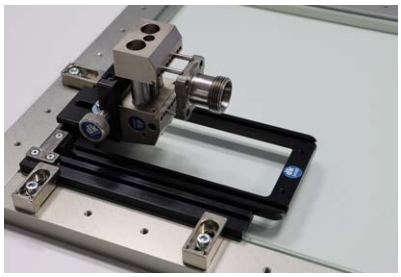
Versatile modular system for optical measuring machines, multi-sensorial devices, measuring projectors and measuring microscopes. The basis is a modular toothed rail system that accommodates the clamping elements directly or via a quick-change pallet system. Optionally available fixed or adjustable structural elements can be mounted in between to spatially position the test specimens optimally. The fine-toothed precision rails make objects with straight edges very easy to measure in transmitted light. The interchangeable pallets enable set-ups outside the measuring machine and zero point placement on the measuring device for a simple and rapid measuring process, especially advantageous for measuring adjacent to production.

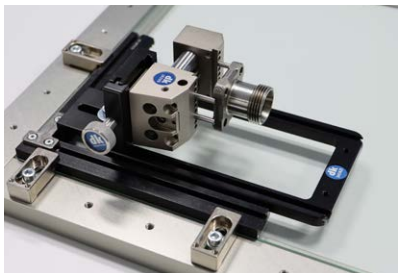
Application examples

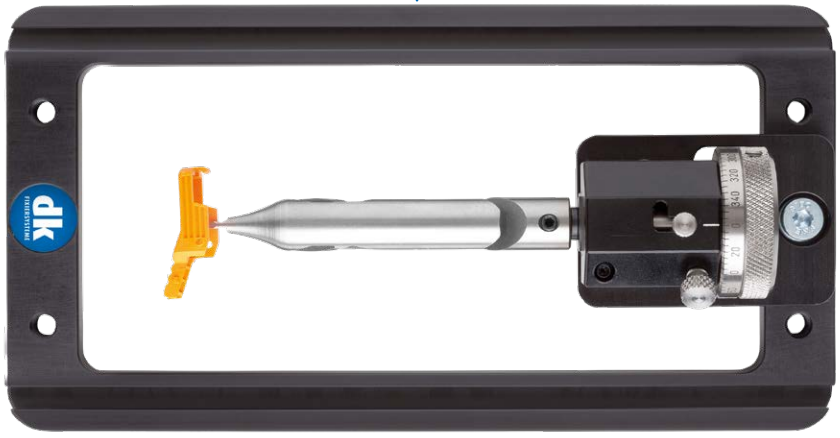










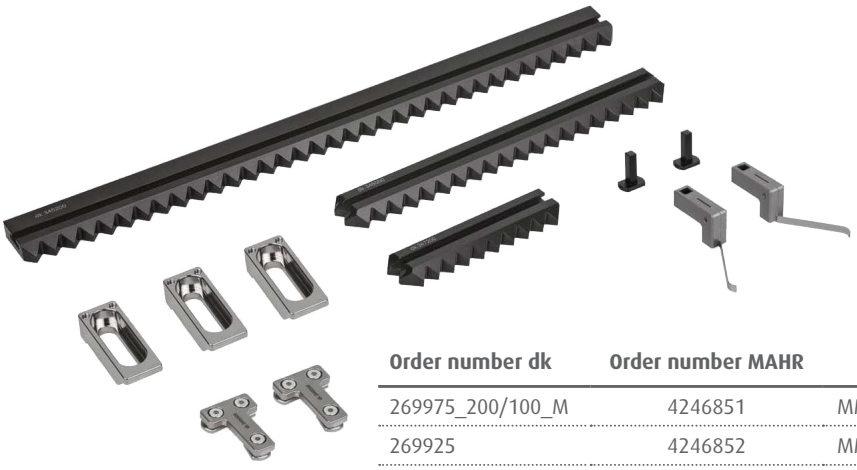


Fixation set for milled, bent, punched and injection moulded parts

SCHIENENFIX

Base rail sets for Mahr MarVision MM 500 and MM 500 CNC

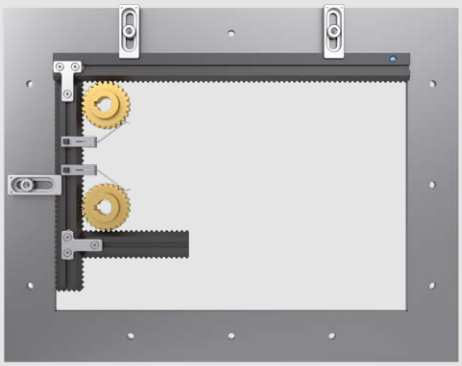
Description
Clamping set for optical measuring tasks. For constructing a simple frame that can be attached to the tapped holes / slots of the measuring equipment table using claw clamps. Includes 2 spring fingers for quick and easy holding of test parts.

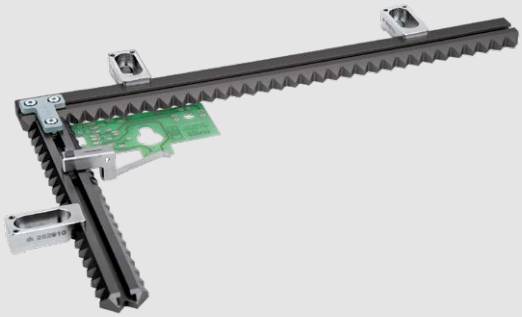


Order number dk	Order number MAHR	Metrology machine	Measuring window
269975_200/100_M	4246851	MM 500 and MM 500 CNC	200 x 100 mm
269925	4246852	MM 500 and MM 500 CNC	300 x 200 mm
269975_400/250_M	4246853	MM 500 and MM 500 CNC	400 x 250 mm

Fine-toothed slotted rails complete with fastenings and spring fingers

Application examples





Set contents for the various measuring window sizes

Order number	Description	200 x 100	300 x 200	400 x 250
345020	Base rail 250 mm / T 5	1	-	-
345220	Base rail 350 mm / T 5	-	1	-
345420	Base rail 450 mm / T 5	-	-	1
347220	Connecting rail 100 mm / T 5	1	1	1
346020	Connecting rail 200 mm / T 5	-	1	
346220	Connecting rail 250 mm / T 5	-	-	1
348000	Rail couplers	1	2	2
262915	Clamping claws 35 mm M 5	2	2	-
262925	Clamping claws 45 mm M 5	1	1	-
262945	Clamping claws 60 mm M 5	-	-	3
349100	Spring finger, left 34 mm	1	1	1
349200	Spring finger, right 34 mm	1	1	1
268500	Spring finger holder	2	2	2

Upgrade fixation set for turned parts

Order No: 269975-SD01

1 Quick-change pallet with 160 x 72 mm window

Description	Quantity	Order number
Basic pallet 195x100x10 mm with T-slot and M6 hole to accommodate various clamping elements. The pallet together with the mounted clamping elements can be positioned and fixated on the toothed rail	1	345821



2 Tailstock pair for T-slot in toothed rail and pallet

Infinite mounting with any spacing, with one fixed and one movable adapter, incl. Ø 12 / 60 mm centres which can be exchanged for other sizes and types	1	349600



3 V-block sets for T-slot in toothed rail and pallet

Infinite mounting with any spacing, one V-block is height adjustable for precise adjustment for stepped shafts; for Ø 8 to 28 mm, incl. columns and spring clamp	1	345100



4 120° V-block with spring clamp

120° V-block with spring clamp for fixating rotationally symmetrical parts via spring force; for vertical and horizontal positioning of test pieces	1	267900
Matching V-block bracket	1	267910



Upgrade fixation set for milled, bent, punched & injection moulded parts

Order No: 269975-SF01

1 Quick-change pallet with 160 x 72 mm window

Description	Quantity	Order number
Description - see turned part fixation set	1	345821



2 SWA39 quick-action clamp for T-slot in toothed rail and pallet

For infinite positioning in the T-slot of toothed rail and pallet	1	273320



3 SWA39 quick-action 90° clamping element

For mounting on the SWA39 quick-action clamp	1	283300



4 Precision vice 50 mm

With SWA39 interface. Incl. adjustable stop, clamping width extension from 35 to 75 mm and pins for raised part positioning	1	282100



5 Rotary unit with fine adjustment and indexing

Infinite rotation, incremental locking every 30° can be activated, interface for all clamping elements with SWA5 such as small part holder and small chuck	1	314900



6 Small parts clamp, offset

Securing small parts using spring fingers, SWA5 adapter	1	266100



TACTILE MEASURING

OPTICAL MEASURING

MACHINE VISION & SENSOR

CONTOUR & SURFACE MEASUREMENT

COMPUTED TOMOGRAPHY

3D LASER SCANNING

Available from

Mahr

metrology.mahr.com

The entire world of fixating, clamping and positioning

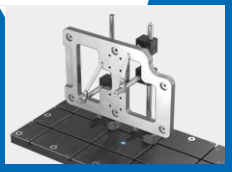
The comprehensive standard construction sets with around 1,000 parts by dk FIXIERSYSTEME for metrology technology offer the following advantages:

» Modular system that has grown and been tried and tested for decades
» Modularity across different lines
» Solutions for every positioning task
» Efficiency through synergetic effects through several industry solutions

SWA39



SPANNFIX PRO



SPANNFIX ECO



QUADERFIX



SCHIENENFIX



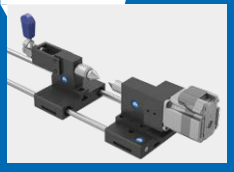
MICROFIX



SWA39CT



SPEZIALFIX



SWA39SURF



FAST
REASSEMBLY
LIFELONG

ARTICULATED SYSTEMS



MACHINE VISION



The basic principle of all dk fixation systems!

Our fixtures have a modular design, may be dismantled at any time and reassembled to their initial state. The compatibility of the dk fixating systems ensures perfect utility value.

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