

# Elemente folosite pentru sistemul de prindere modulară “Batiu IAR80”

## Element de supra înălțare

In cazul supraînălțării am folosit două dimensiuni de elemente pentru supraînălțare : T50205 & T5021

Insert Inserta Pliers, or Inserta Clamps into any of the CNC machined holes for horizontal or vertical clamping at any height.

Stack the Clamping Squares to brace tall workpieces. Use the top holes for mounting the Squares in a fixed location. The lower base is slotted for adjustable mounting. Use with 1/2-13 Shoulder Screw Part Nos. T831605 – T831612.



T50205



## Product Details

Dimension (in)	Weight (lb)	Part No.	CAD
2 x 5.5 x 4	2.3	T50205	<a href="#">Download</a>
2 x 5.5 x 8	3.1	T50210	<a href="#">Download</a>
2 x 5.5 x 12	4.2	T50215	<a href="#">Download</a>

## Şuruburi de prindere: T55010

An *essential* component in Modular Fixturing!

Ball Lock Bolts are a time-saving, efficient method of locating, and fastening fixture elements to the BuildPro® tabletop.

Insert the Ball Lock Bolt over the fixturing element and turn the knurled head with your hand for initial positioning. The Ball Lock Bolt consists of three locking steel balls in the bolt shank that move outward to lock against the bottom chamfer of the table plate, pulling the fixture components securely downward and tightening them in place. Once all the Bolts are positioned, tighten the socket head cap screw top of the Bolts with a hex wrench. Ball Lock Bolts release quickly from the Bolt top with a turn of your hex wrench.



T55010 - Fixed



### Product Details

Type	Description	Hex Wrench Size (in)	Weight (lb)	Part No.	CAD
Fixed	For connecting 2 accessories together. 0.94" capacity.	1/4	0.2	T55010	<a href="#">Download</a>
Fixed	For connecting an accessory to the tabletop. 1.1" capacity.	1/4	0.2	T55015	<a href="#">Download</a>
Flush	For connecting 2 accessories together. 0.94" capacity.	5/32	0.1	T55020	<a href="#">Download</a>

# Vincluri de Centrare: T54210

## Heavy Duty V-Blocks

Developed by customer demand, these Heavy Duty V-Blocks hold round stock from 3" – 8" in diameter at 120° – 150°.



T54210 - 90°



## Product Details

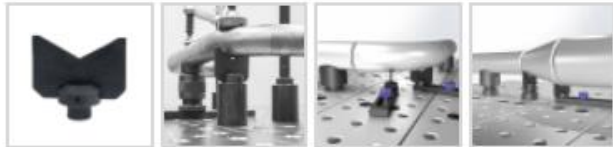
Type	Angle	Dimension (in)	Max. Tube Size (in)	Weight (lb)	Part No.	CAD
Standard	90°	1.6 Dia. x 1.3	2	0.33	T54210	<a href="#">Download</a>
Standard	120°	1.6 Dia. x 1.1	2.5	0.27	T54215	<a href="#">Download</a>
Aluminum	120°	1.6 Dia. x 0.9	2.5	0.05	T54216	-

## In cazul centrării bărilor de metal cu profil cilindric este de preferat folosirea vinclurilor de tipul “Bend Rests” :T54320

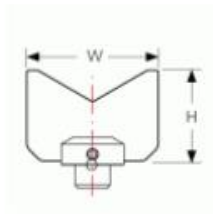
The low profile design allows use of multiple Bend Rests as needed to elevate stock, leaving ample space for clamping.

Place Bend Rests directly into any hole on the BuildPro® Tabletop, or use in combination with BuildPro® Rests to set at desired height to meet clearance or alignment requirements for each unique fixture:

Use with: [Adjustable Rest](#), [Fixed Rest](#) and [V-Block Spacer](#).



### Product Details



Angle	W x H (in)	Max. Tube Size (in)	Weight (lb)	Part No.
120°	2.4 x 1.2	2.5	0.3	T54320
120°	2.4 x 1.7	3	0.3	T54325
150°	3.2 x 1.3	8	0.3	T54330

## Elemente de Fixare: UEN5200

In acest caz am folosit 2 tipuri de elemente de fixare, unul cu cap care se poate schimba și inlocui cu element ce favorizează fixarea elementelor cu profil cilindric, iar cel de-al doilea este folosit pentru fixarea “Ferurii” din ansamblul 1. In plus de capul principal, am proiectat o margine cilindrica in jurul părții de contact plane, pentru a nu deforma “Ferura” in timpul procesului de fixare si sudare. Iar totodata pentru acest element am mai proiectat un element de fixare pe placă reglabila la anumit unghi pentru a respecta dimensiunile gaurii din placă.

Place the Inserta Clamps into the  $\frac{5}{8}$ " holes on the BuildPro® Tabletop, Riser Blocks, or Economy Stops and Clamping Squares for fast, easy clamping. Clamp in the vertical or horizontal position at any height.

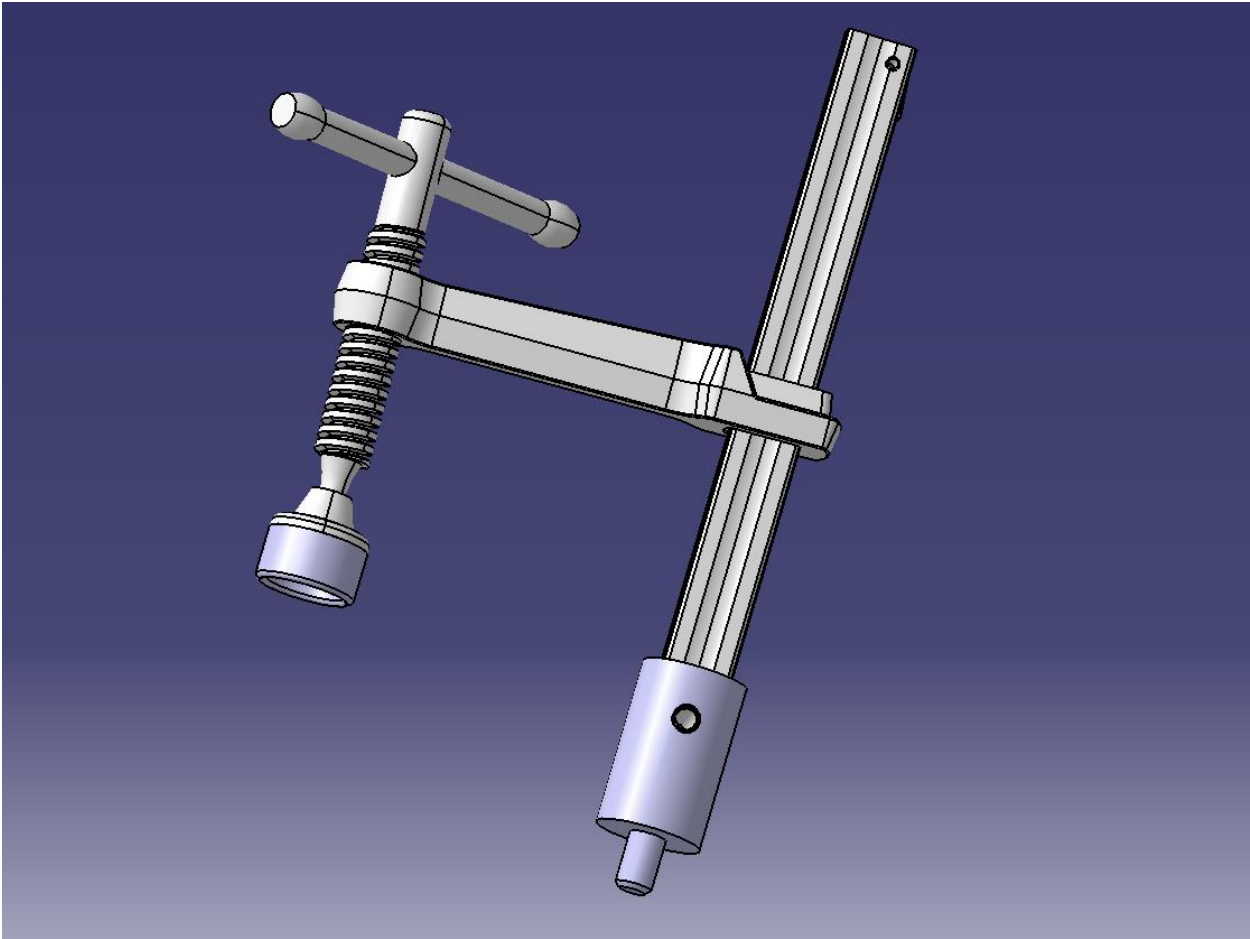
Clip the optional Top V-Pads onto the top spindle to clamp round or angled stock. Remove the clamp arm by depressing the spring stop, and slide the Sidekick attachment onto the clamp bar, followed by the clamp arm, for two point horizontal and vertical clamping force.

The Ratchet Handle Model is ideal for tight space clamping, and the ratchet mechanism ensures rapid, vibration and torsion resistant clamping.



### Product Details

Handle	Clamping Capacity (in)	Throat Depth (in)	Clamping Pressure (lb)	Rail Size (in)	Weight (lb)	Part No.	CAD
T-Handle	6-1/2	3-1/4	300	5/8 x 5/16	1.2	UDN5150	<a href="#">Download</a>
T-Handle	8-1/2	4	400	25/32 x 3/8	2.2	UEN5200	<a href="#">Download</a>
Ratchet Handle	8-1/2	4	400	25/32 x 3/8	2.2	UERN5200	<a href="#">Download</a>



# Element reglabil pentru suprafețe drepte: T50505

Long slots make these precision machined Straight Edge Stops infinitely adjustable in fixturing applications and squaring up parts.



T50505

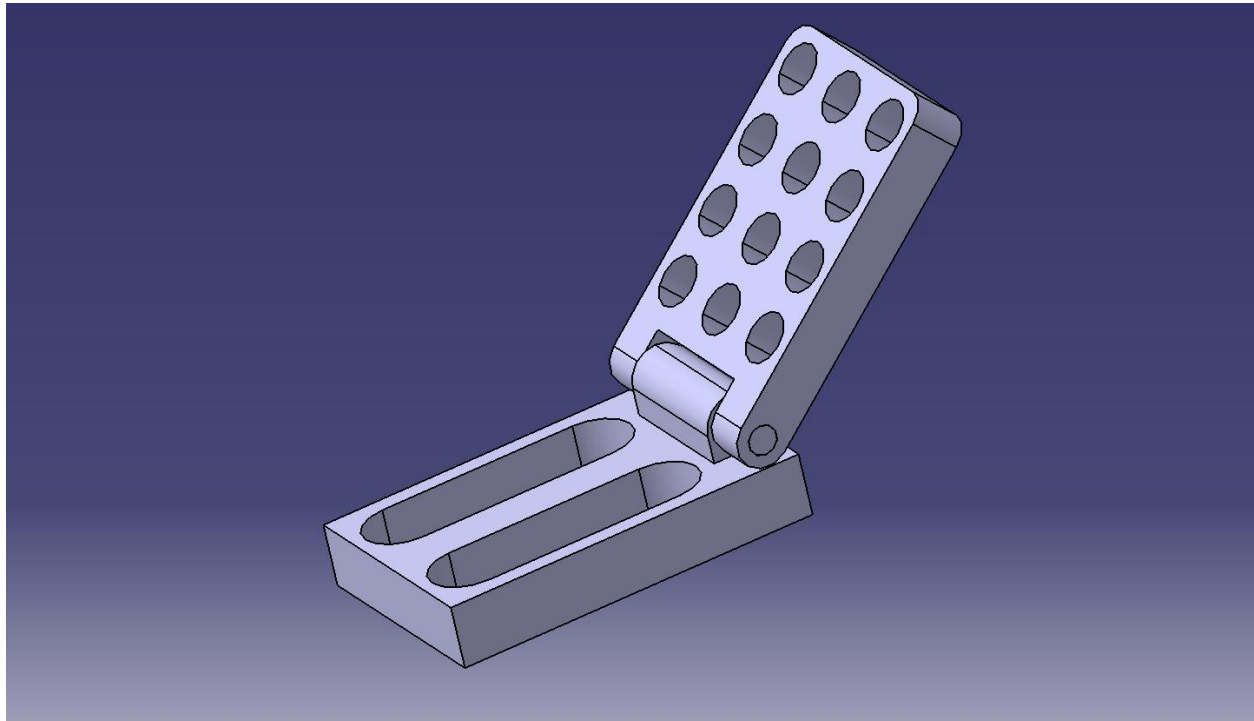


## Product Details

Dimension (in)	Slot Length (in)	Ø.625" Holes	Weight (lb)	Part No.	CAD
6 x 1.18 x 0.47	3.5	1	0.6	T50505	<a href="#">Download</a>
8 x 1.18 x 0.47	2	2	0.8	T50510	<a href="#">Download</a>
10 x 1.18 x 0.47	5	4	0.9	T50517	<a href="#">Download</a>

## Element Reglabil la Unghi “Custom Made”

Am proiectat acest element pentru a putea centra gaura “Ferurii” la unghiul potrivit.



### Adjustable angle plate R-PCA-135075-15-8 (jpg)

File size: 168 kB Language: [Language Independent](#) Dimensions: 1200 x 1200 px Part number: R-PCA-135075-15-8

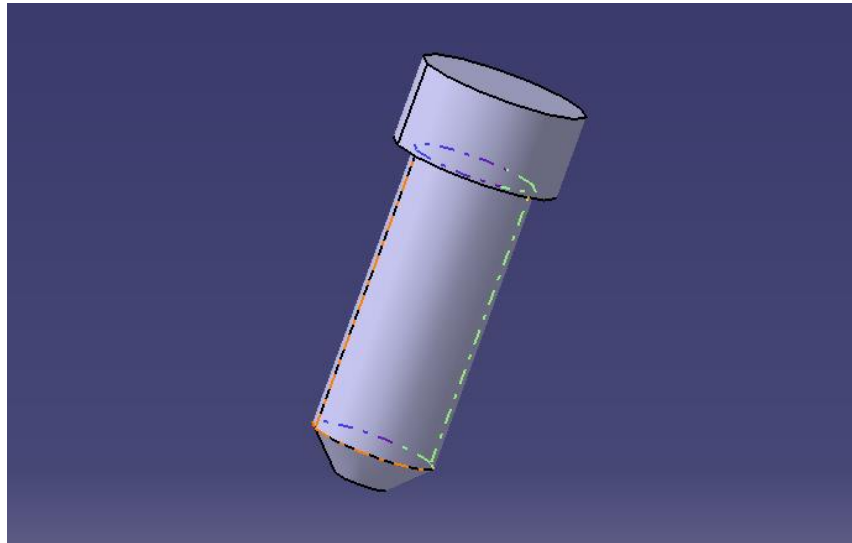


[Download file](#) >

Adjustable angle plate R-PCA-135075-15-8



## Șurub de prindere “Custom Made” pentru elementul de centrare al “Ferurii”.



## Element reglabil la unghi cu magneți pentru bările cilindrice sau bările cu profil drept



- Adjustable from 30° – 275° with two On/Off switches.
- Precision machined flat surfaces and nickel/chrome body.
- V-Groove surfaces securely hold round and square tubing, angle, and flat stock.

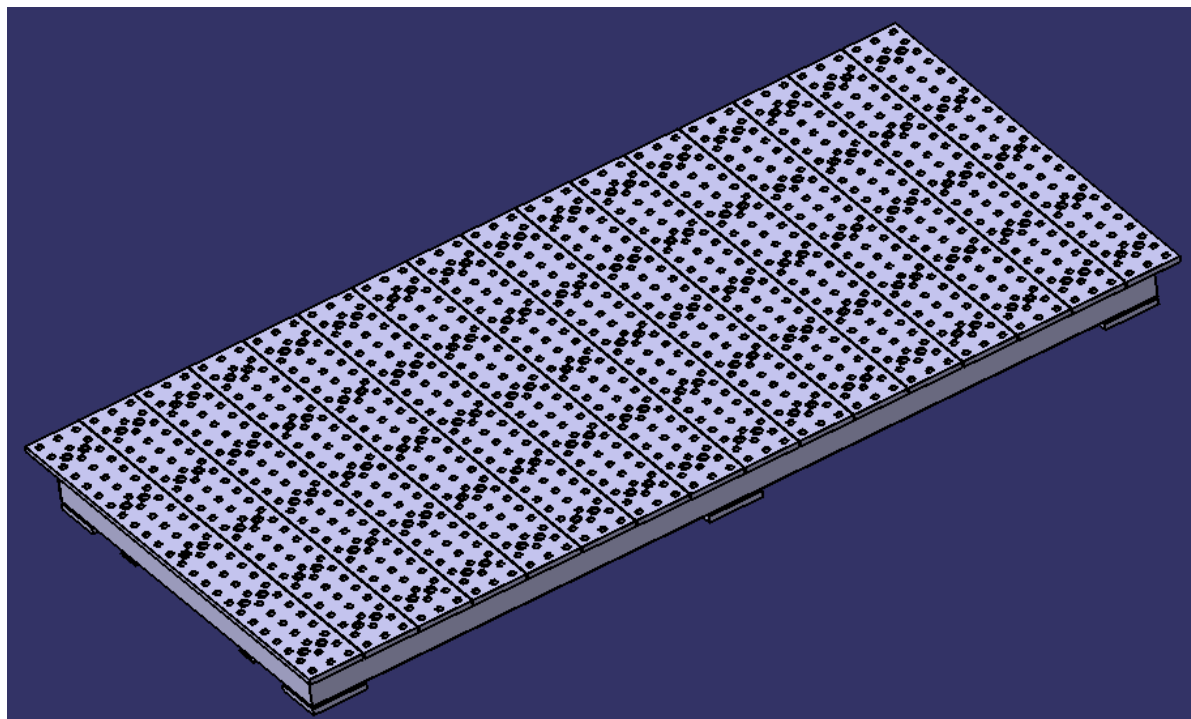
▲ *Must be used for tack welding only and removed before completing weld. Avoid prolonged exposure of magnetic products to heat sources of 175°F / 80°C and above.*



U.S. PAT. 7959140

Part No.	Max. Pull Force	Dimension	Weight
MAV120	110 LBS (50 kg)	7-3/4 x 7-3/4 x 3-3/4" (197 x 197 x 95 mm)	5.3 LBS (2.4 kg)

## Masă/placă de bază



Datele componentului ales sunt evidențiate cu chenar roșu, iar în link-ul atașat sunt toate informațiile necesare.

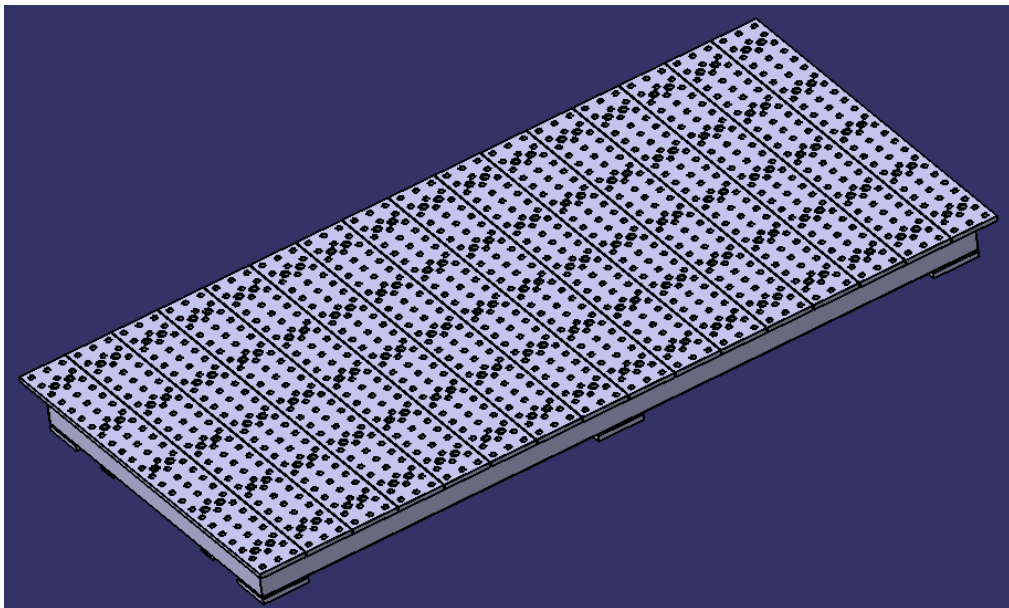
### MAX

Finish	Dimension (ft)	Dimension (in)	Weight (lb)	Part No.	CAD
Standard	8 x 4	96 x 48	1,270	TM59648V	<a href="#">Download</a>
Standard	6 x 4	72 x 48	970	TM57248V	-
Standard	5 x 3	60 x 36	628	TM56036V	-
Standard	4 x 4	48 x 48	661	TM54848V	<a href="#">Download</a>
Nitrided	8 x 4	96 x 48	1,270	TMQ59648V	-
Nitrided	6 x 4	72 x 48	970	TMQ57248V	-
Nitrided	5 x 3	60 x 36	628	TMQ56036V	-
Nitrided	4 x 4	48 x 48	661	TMQ54848V	-

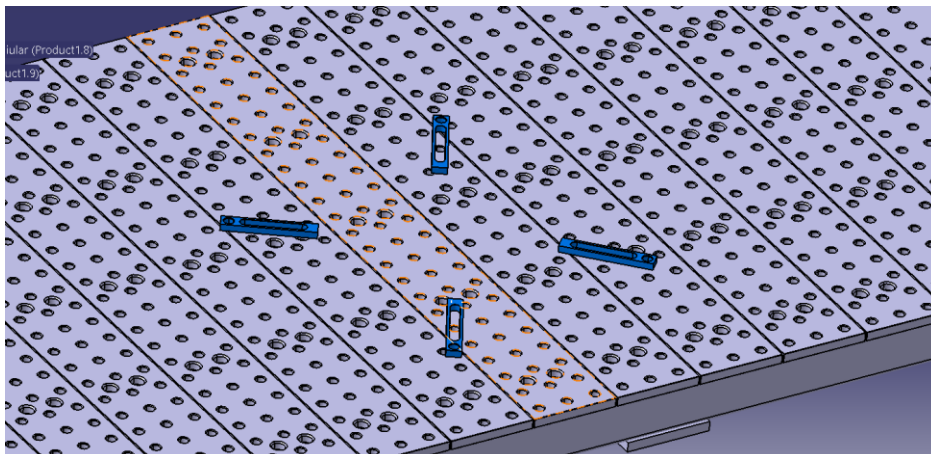
# Sistemul de prindere modulara explicat pas cu pas “BATIU IAR80”

## Etapele de realizare ale Batiului

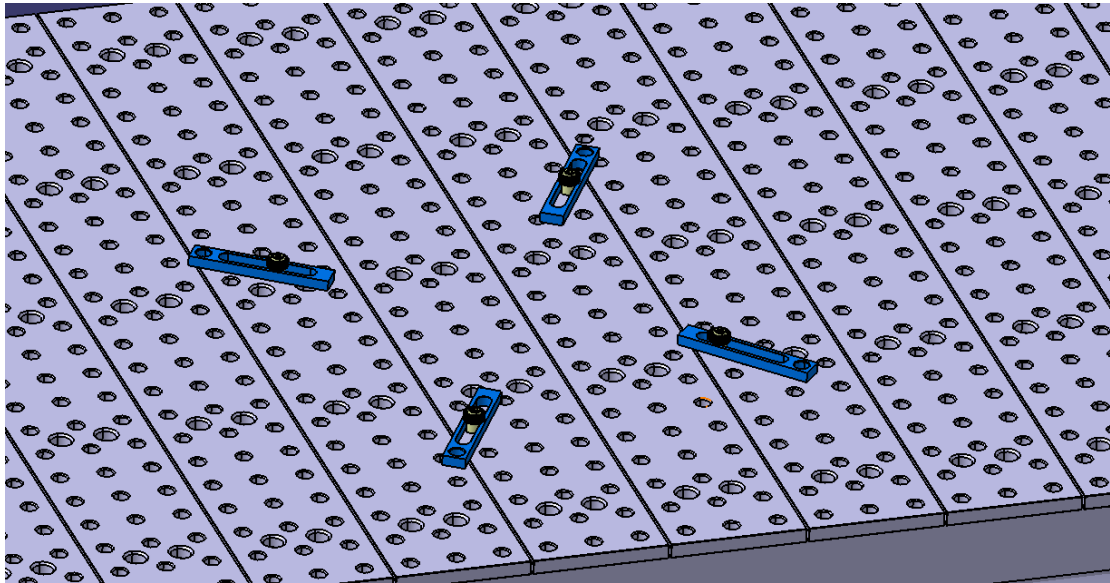
1. Alegerea si poziționarea mesei



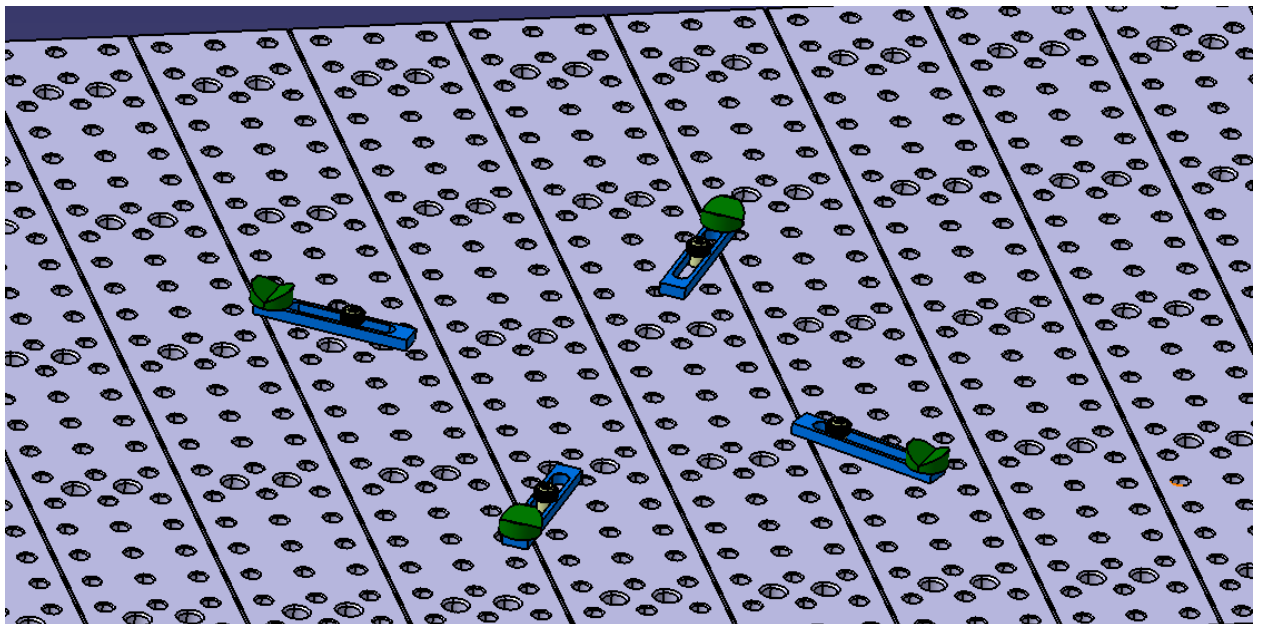
2. Sunt poziționate elementele reglabile pe masă



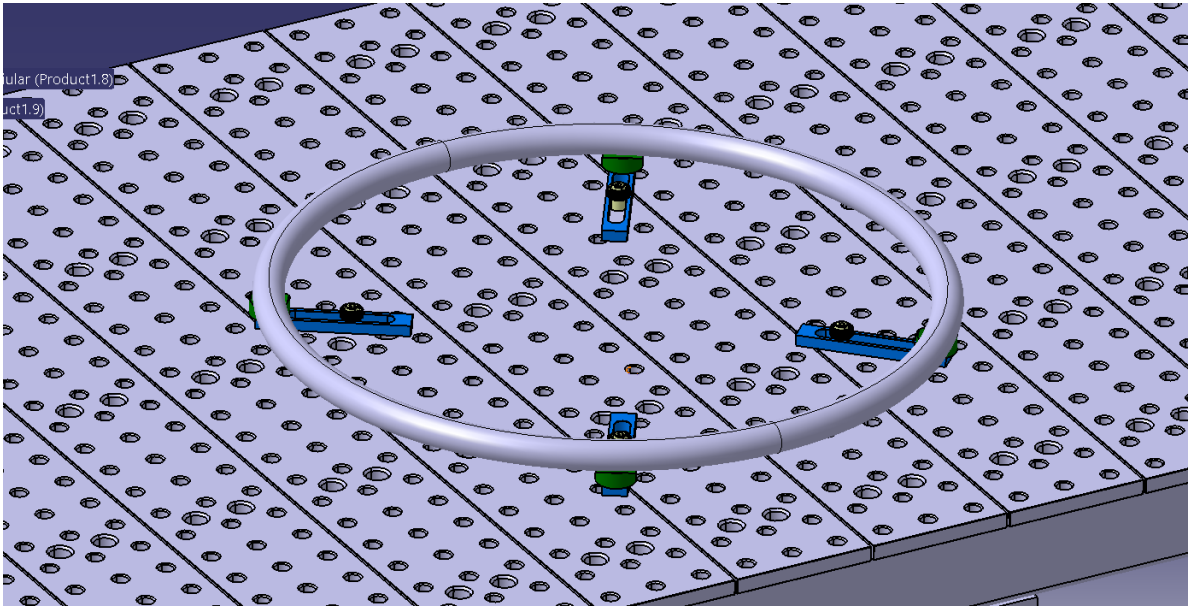
3. Se fixează elementele reglabile de masă cu ajutorul șuruburilor



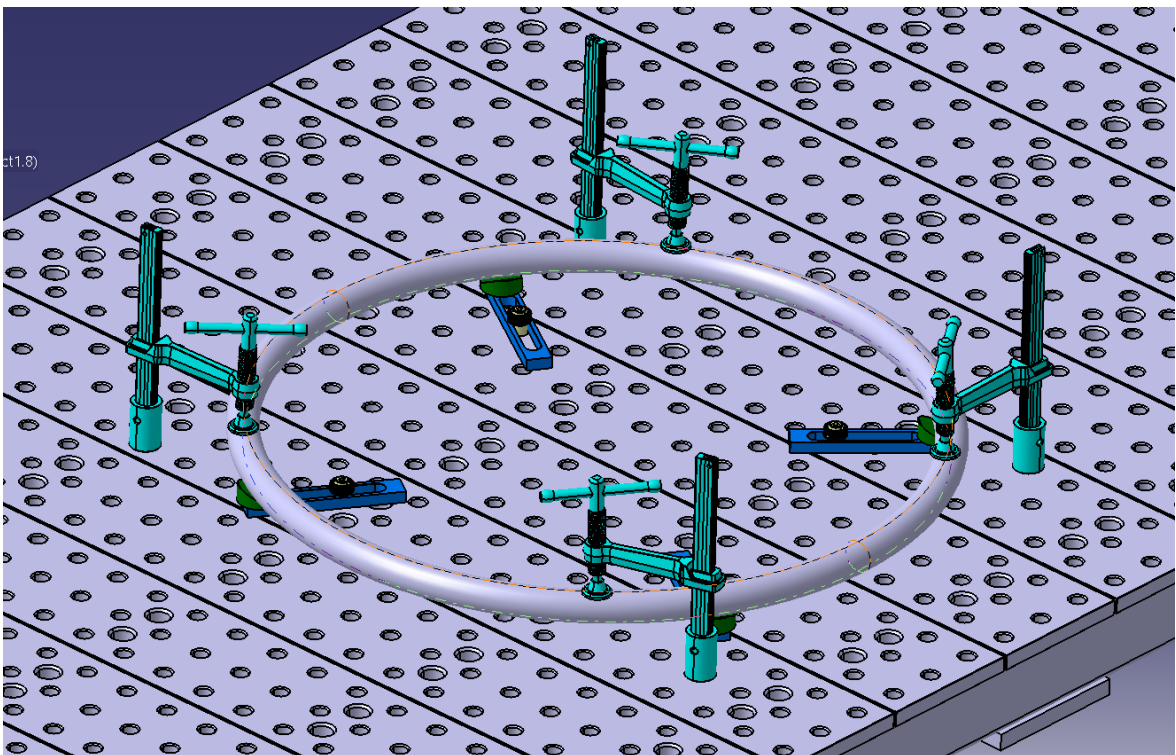
4. Se poziționează elementele de centrare (vinclurile) pe elementele reglabile



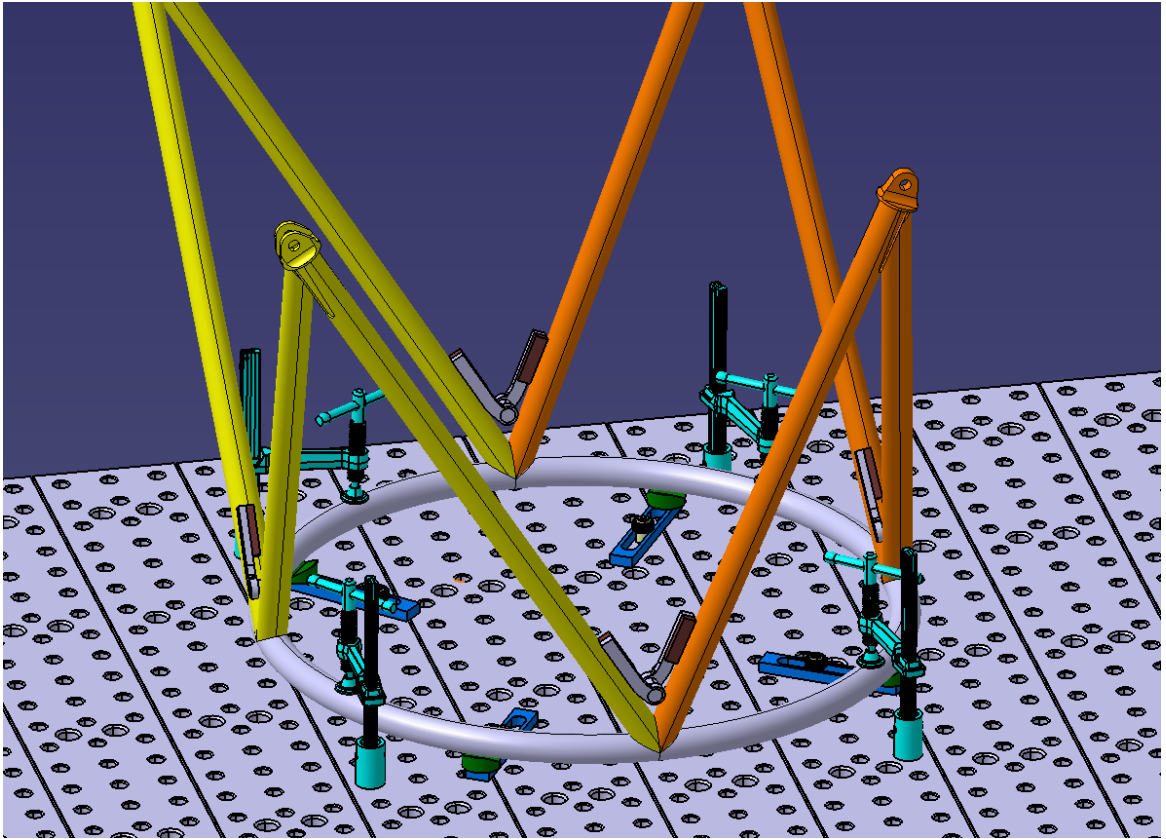
5. Se centrează baza batiului pe vincluri



6. Se fixează baza pe vincluri cu ajutorul elementelor de fixare



7. Se poziționează restul elementelor batiului și se fixează la unghiul necesar cu elemente magnetice de fixare unghiulară

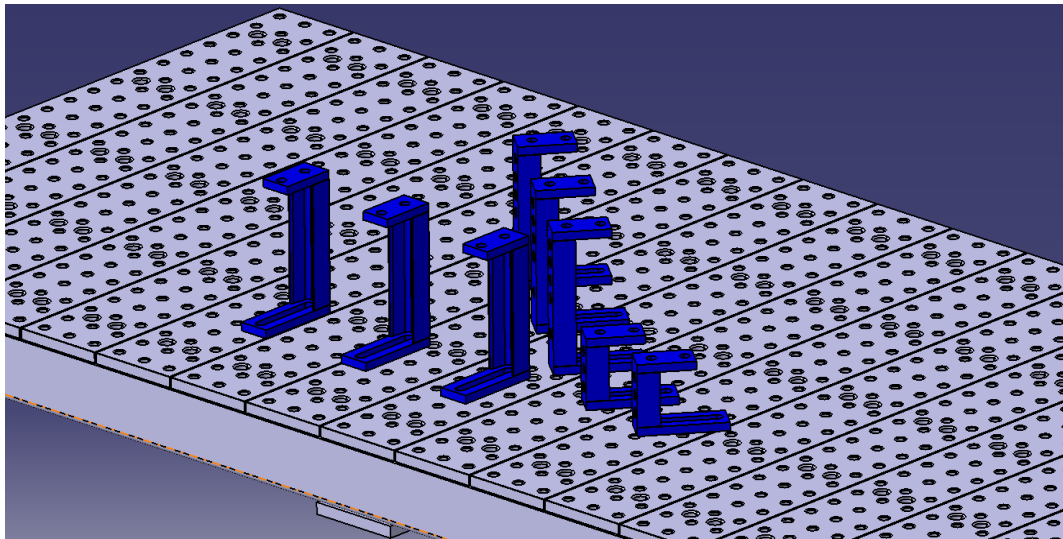


# Sistemul de prindere modulara explicat pas cu pas

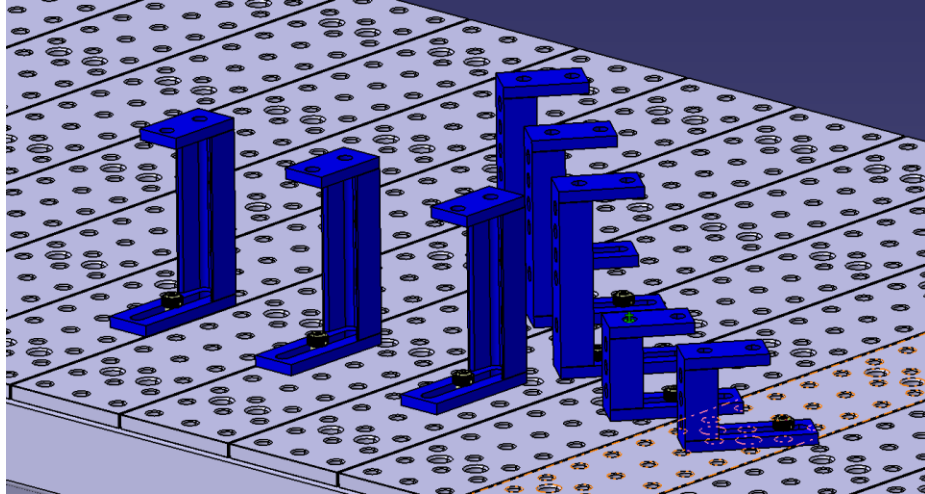
## “Bara Prindere 1” si “Bara Prindere 2”

Etapele de realizare ale ansamblului “Bării prindere 1” si “Bării prindere 2”

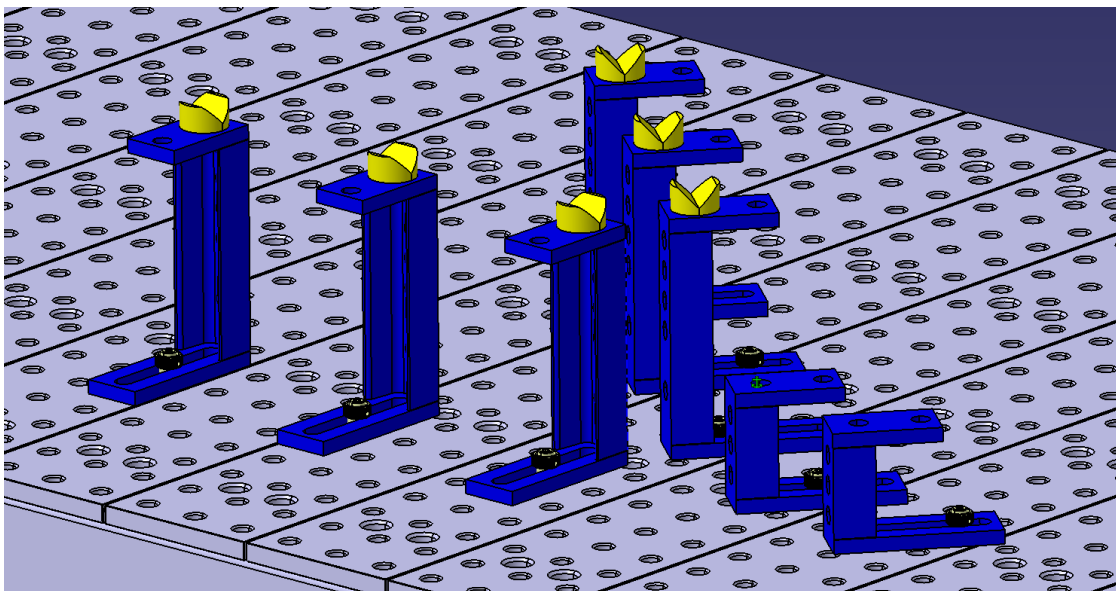
1. Se poziționează elementele de supraînălțare pe masa/platou



2. Se fixează elementele de supraînălțare de masă/platou cu ajutorul șuruburilor

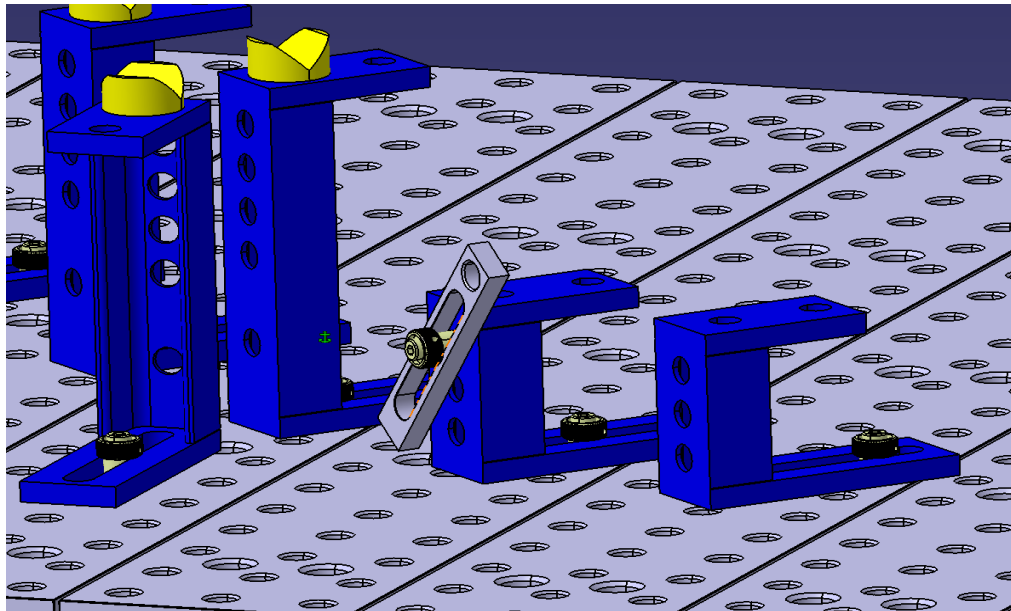


3. Se poziționează elementele de centare/ vinclurile pe elementele de supraînălțare

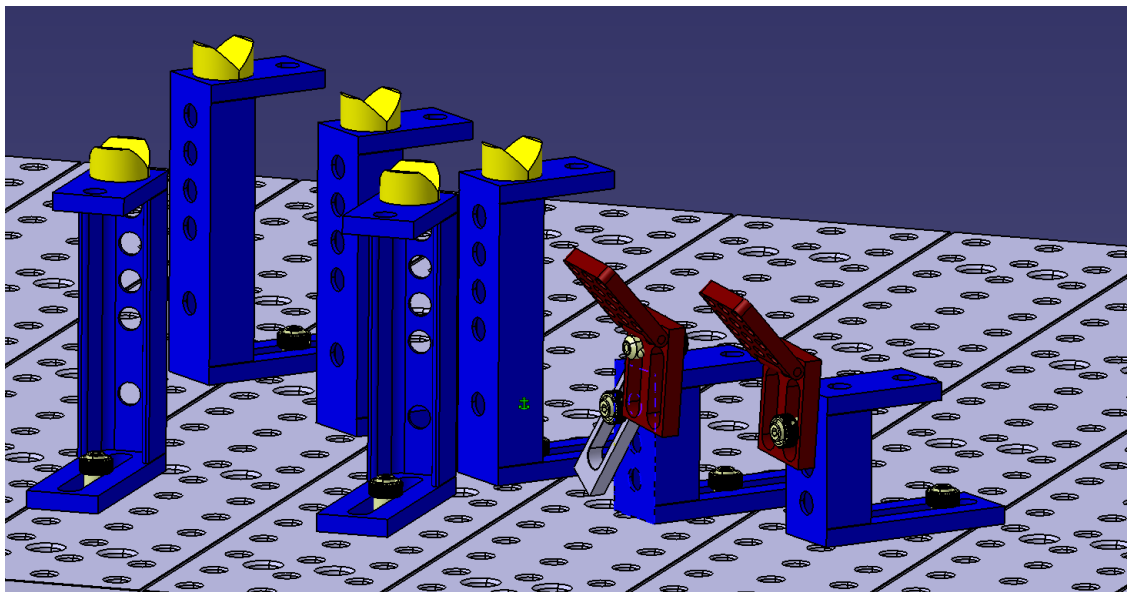


4. Se poziționează un element reglabil pe elementul de supraînălțare mic din dreapta ansamblului și se fixează cu un șurub de acesta.

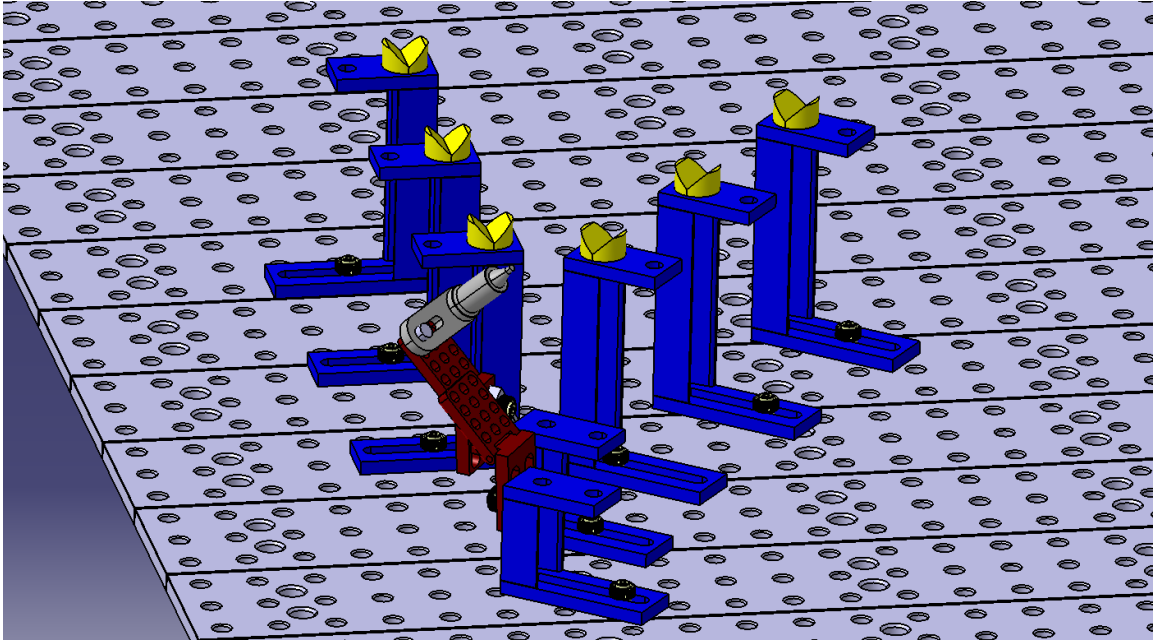




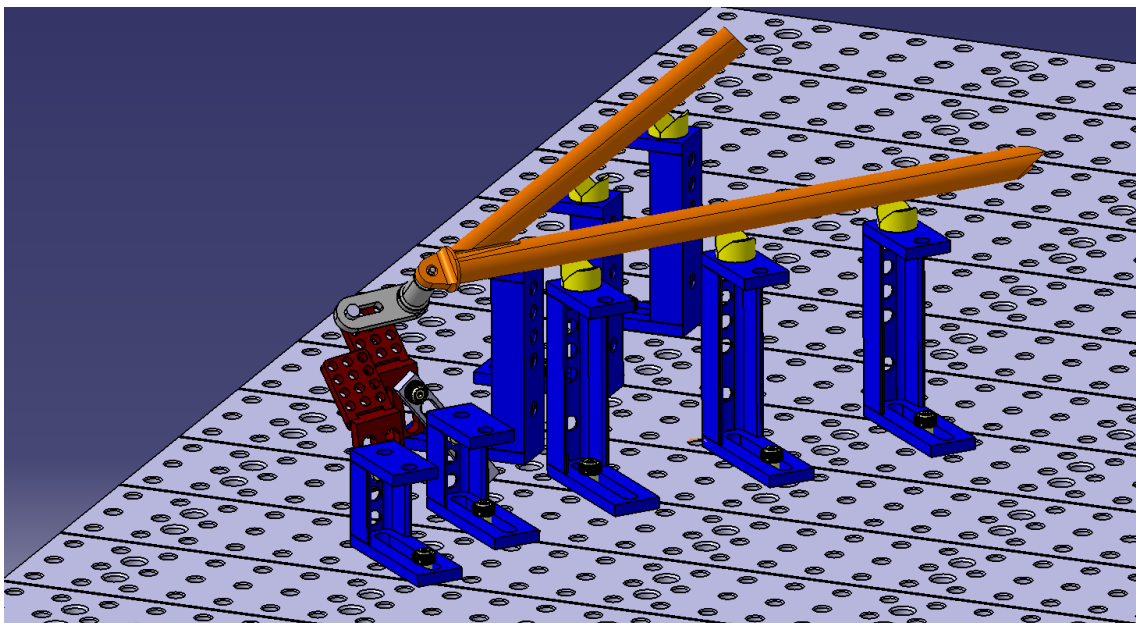
5. Se poziționează elementele reglabile unghiulare pe elementele de supraînălțare și se fixează cu șuruburi



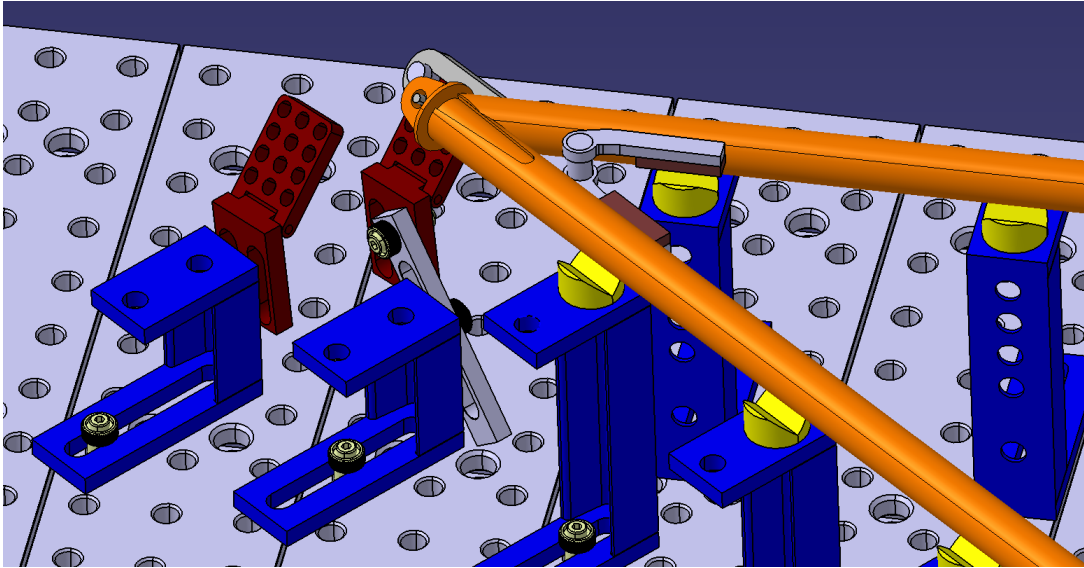
6. Se așează elementul de centrare al "Ferrii" pe elementul reglabil unghiular și se fixează cu un șurub "custom made"



7. Se centrează ulterior bara împreună cu "Ferura" pe vincluri și elementul de centrare "custom made"



8. Se poziționează elementul magnetic reglabil la unghi între cele două bări pentru a respecta unghiul impus inițial



9. Se poziționează elementele de fixare pe elementele de supraînălțare și pe elementele reglabile unghiulare

