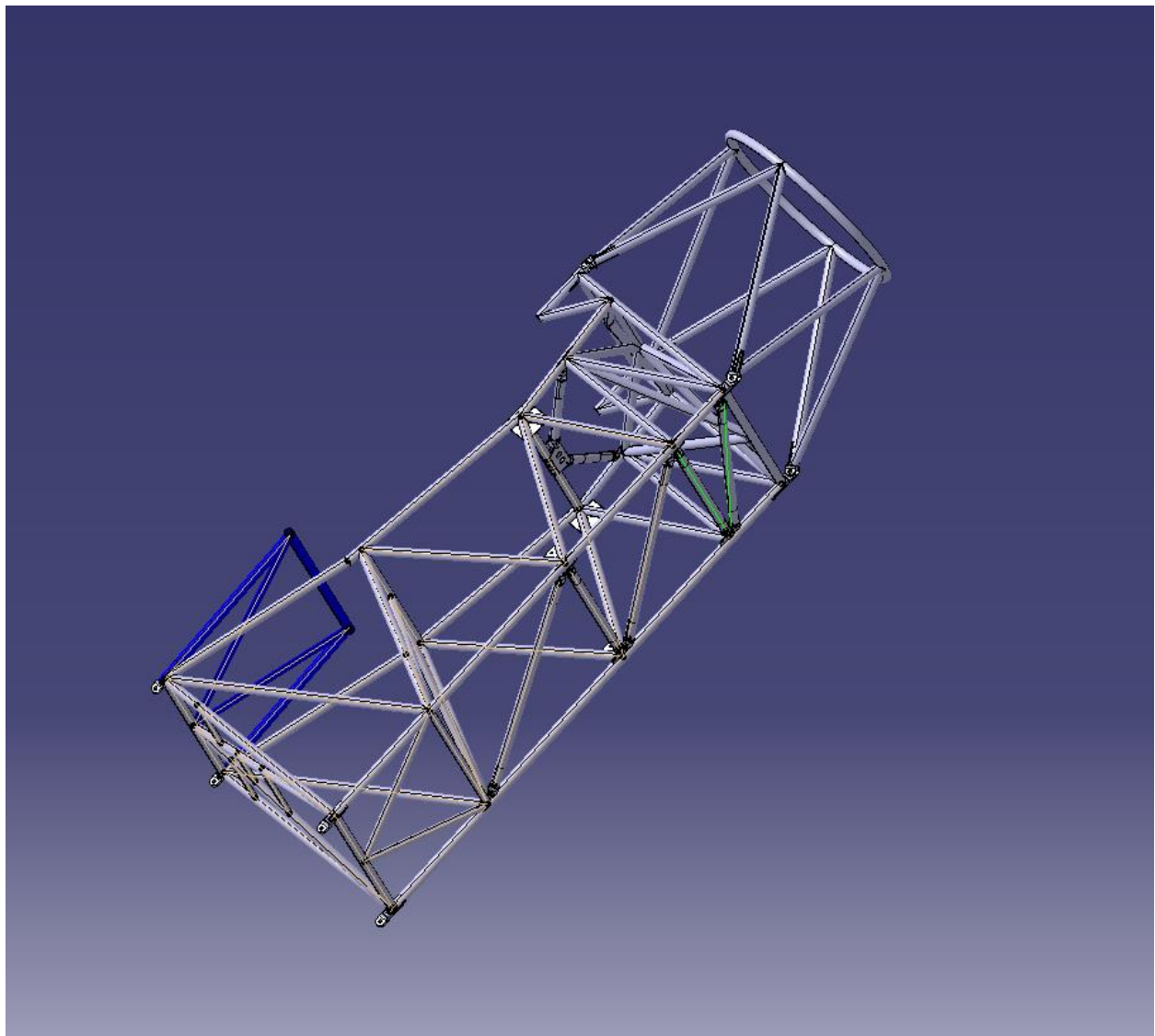
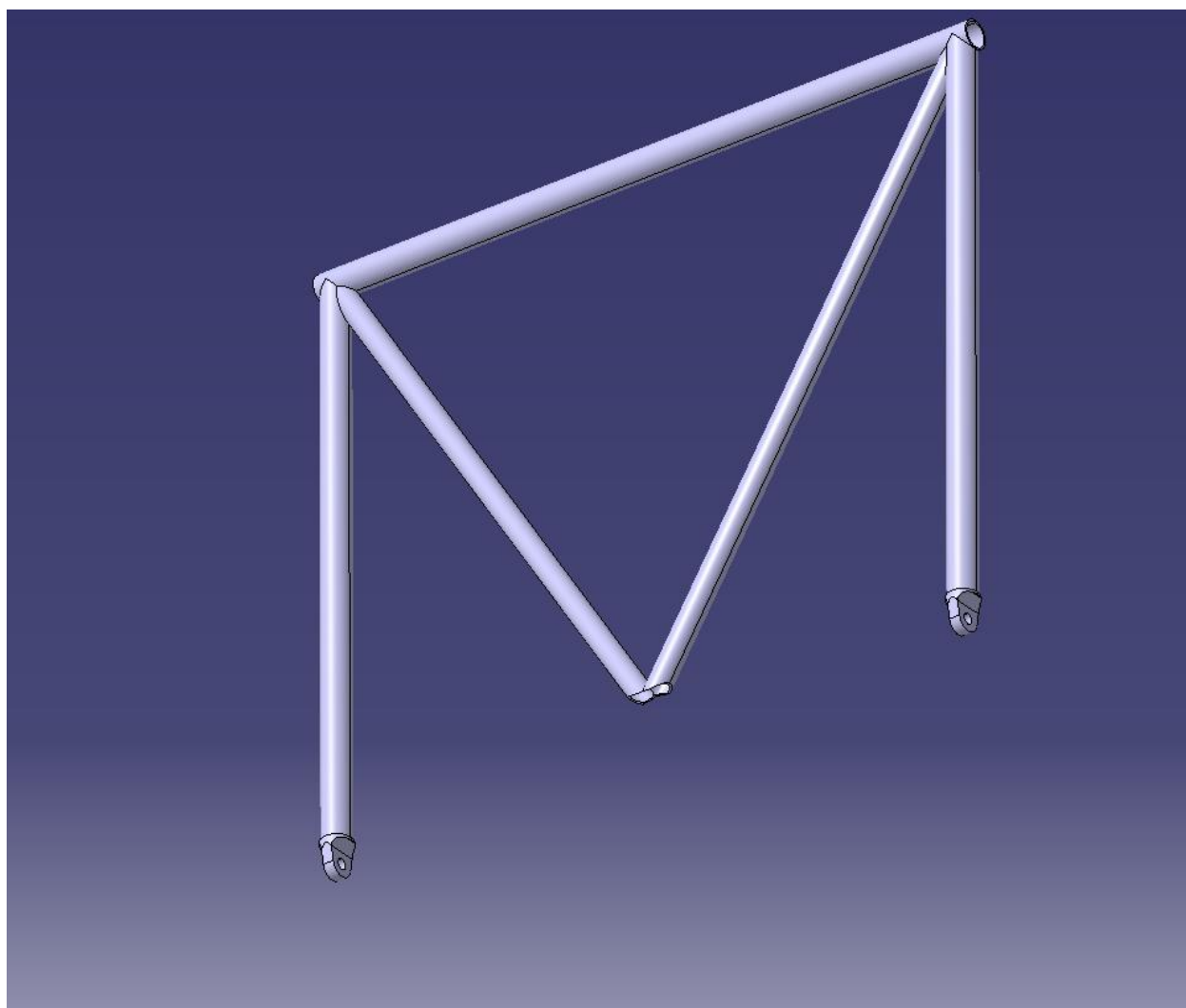


Sistem de prindere modular pentru operatii de sudare a ansamblului peretelui inferior din cadrul fuzelajului avionului IAR-80



Ansamblul Grinda cu zăbrele-Batiu Motor

Asamblu de jos



Placa de baza



MAX

Finish	Dimension (ft)	Dimension (in)	Weight (lb)	Part No.	CAD
Standard	8 x 4	96 x 48	1,270	TM59648V	Download
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	Download
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	-

<https://buildprotables.com/products/tables/tabletops/>

Elemente de suport si centrare



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	Download
Standard	120°	1.6 Dia. x 1.1	2.5	0.27	T54215	Download
Aluminum	120°	1.6 Dia. x 0.9	2.5	0.05	T54216	-
Heavy Duty	120°	2.4 Dia. x 1.7	3	1.2	T54310	-
Heavy Duty	150°	3.2 Dia. x 1.4	8	1.5	T54315	-

<https://buildprotables.com/products/fixtures/v-blocks/>

Element regrabil:



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	Download
8 x 1.18 x 0.47	2	2	0.8	T50510	Download
10 x 1.18 x 0.47	5	4	0.9	T50517	Download

<https://buildprotables.com/products/fixtures/straight-edge-stops/>

Suport reglabil:



Description	Range (in)	Weight (lb)	Part No.	CAD
Adjustable Rest with Two Interchangeable Locating Posts	2 ~ 2-3/4	1.1	T54213	Download
Low Profile. Fixed Ø5/8" Locating Post ONLY	7/8 ~ 1-3/16	0.6	T54212	-

<https://buildprotables.com/products/fixtures/adjustable-rests/>

Element de conectare folosit intre suportul reglabil si elementul reglabil:



Elemente de fixare:



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	Download
T-Handle	8-1/2	4	400	25/32 x 3/8	2.2	UEN5200	Download
Ratchet Handle	8-1/2	4	400	25/32 x 3/8	2.2	UERN5200	Download

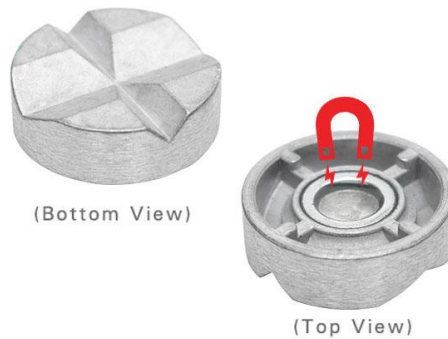
<https://buildprotables.com/products/fixtures/inserta-clamps/>

Product Details

Thread	Dia. (in)	Weight (lb)	Part No.	CAD
M8	5/8	0.06	T54605	Download
M10	5/8	0.06	T54606	-

<https://buildprotables.com/products/fixtures/connectors/>

Trebuie menționat faptul că, capul de fixare al acestor elemente poate fi schimbat cu unul care să fie potrivit pentru suprafețe cilindrice ca cel din exemplul următor:



Link: <https://buildprotables.com/products/fixtures/clamp-accessories/>

Clește de centrare cu unghi variabil



Element realizat manual in Catia V5

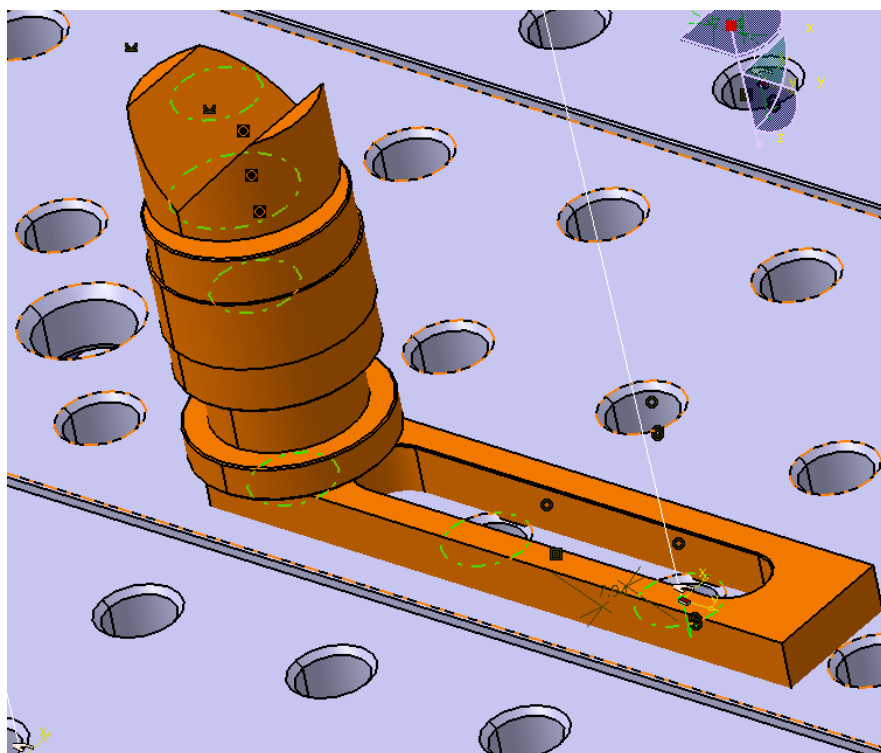
Link: <https://stronghandtools.com/metric/products/magnetic-squares/adjust-o-multi-angle/>

- Stift conic

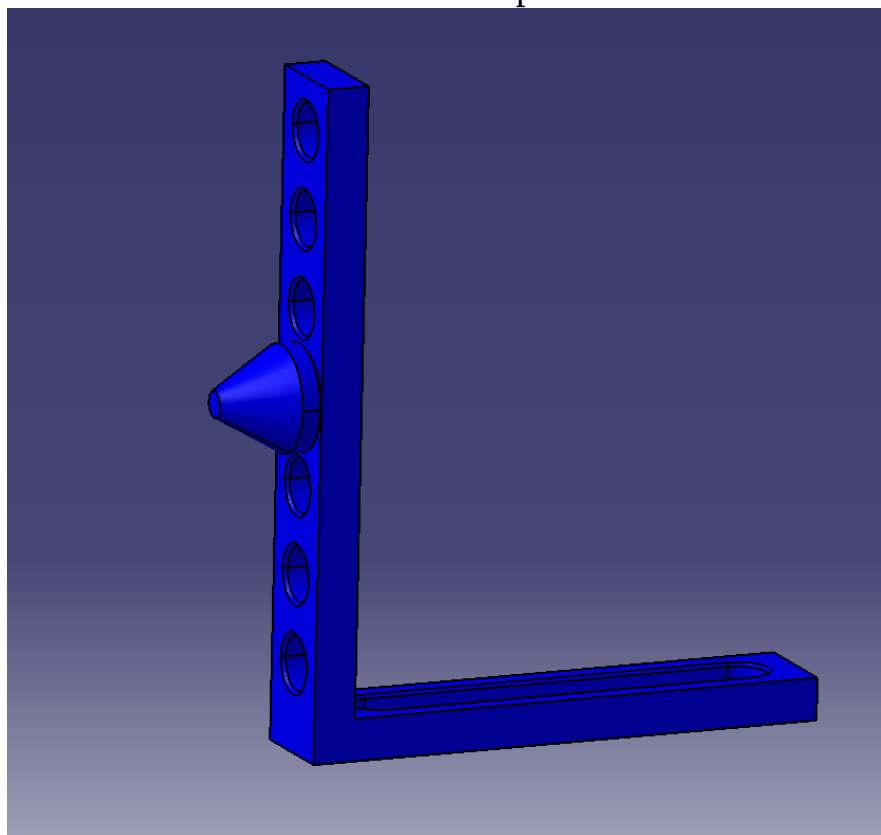


Element realizat manual in Catia V5

Link: <https://buildprotables.com/products/fixtures/setup-cone/>



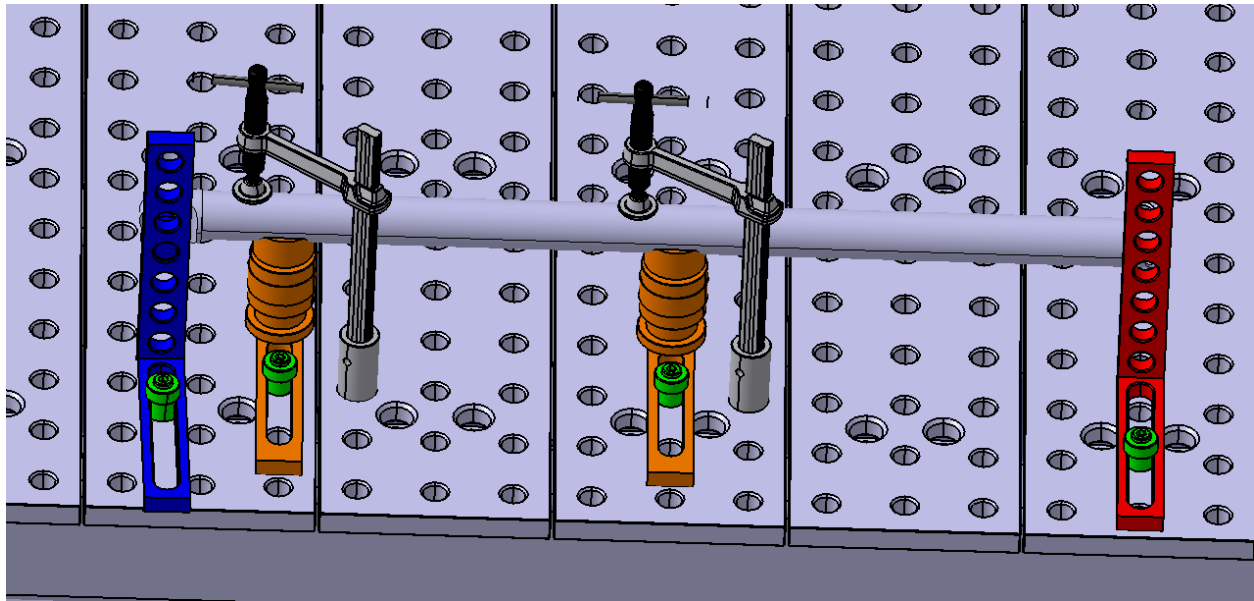
Ansamblu realizat manual cu componente de mai sus.



Ansamblu realizat manual cu componente de mai sus.

Ansamblul de prindere al barelor care formeaza partea de jos

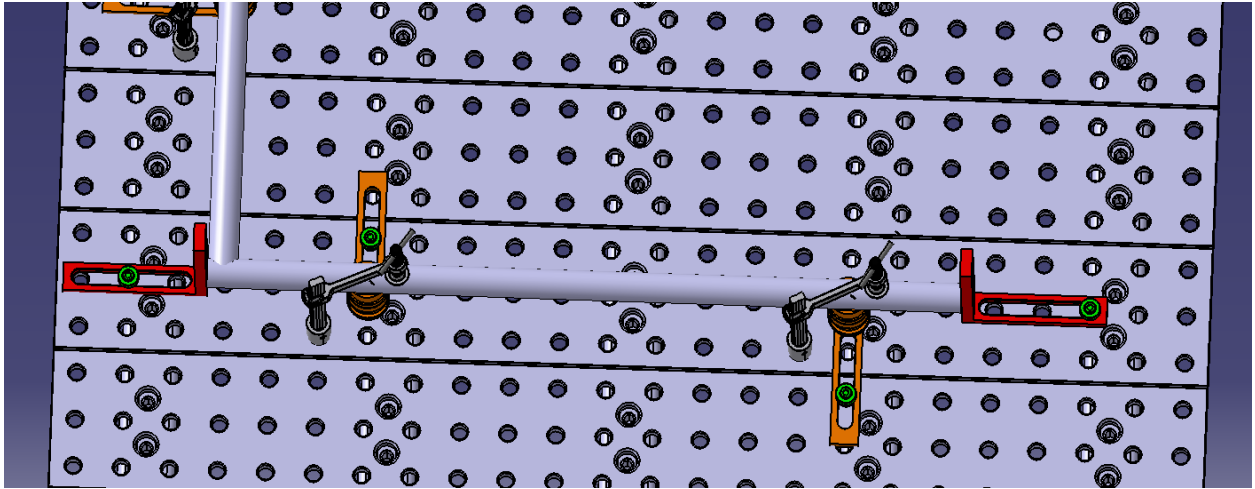
Pasul1



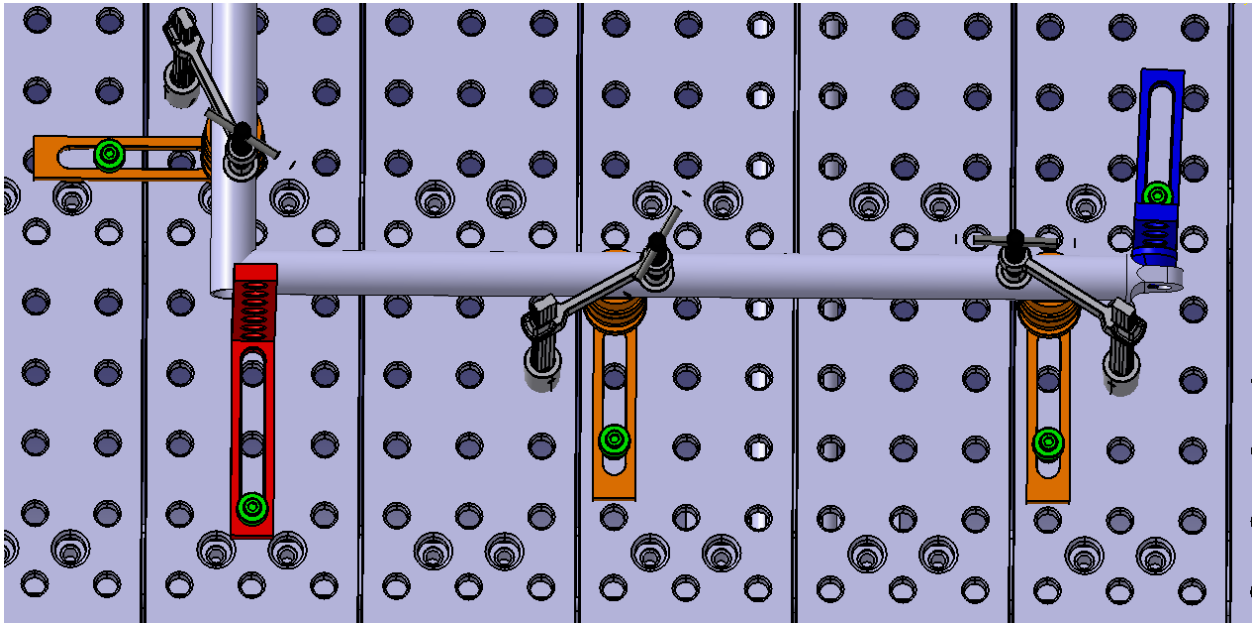
In primul pas este foarte important sa fie fixata si centrata foarte bine prima bara din ansamblu. Se pozitioneaza pe masa ansamblurile de culoare portocalie iar acesta are rol de a sustine bara cu ajutorul capetelor conice urmand a fi utilizate elemente de fixare prin strangere cu manivela pentru un contact mai bun cu capetele conice iar pentru ca bara sa nu se poata misca stanga dreapta se utilizeaza elemente pentru centrare cu unghi de 90° cum sunt cele cu culoare albastra ele avand nevoie de stifturi de pozitionare.

La pasurile 2 ,3si 4 avem acelasi proces ca la pasul 1.

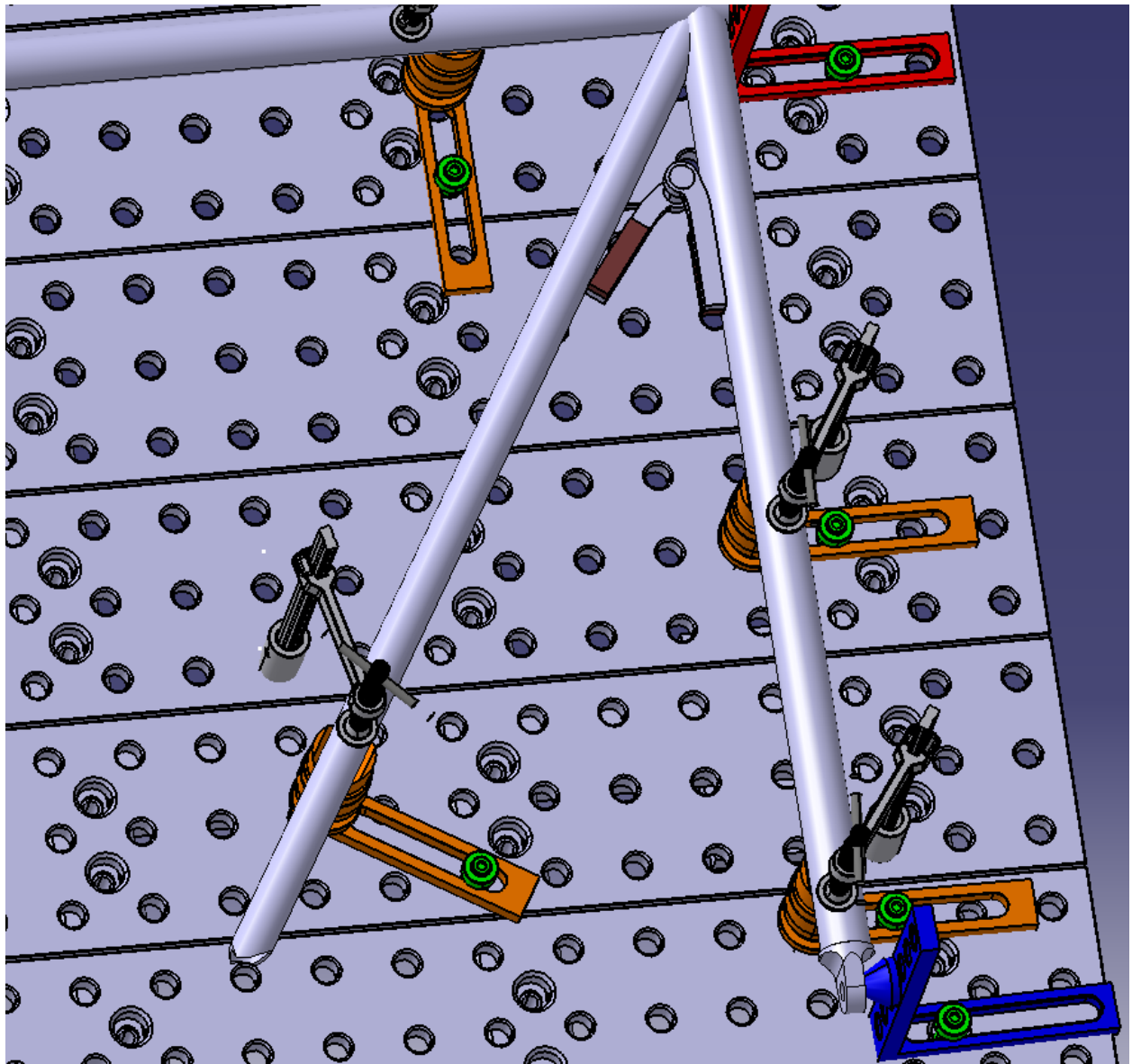
Pasul2



Pasul 3

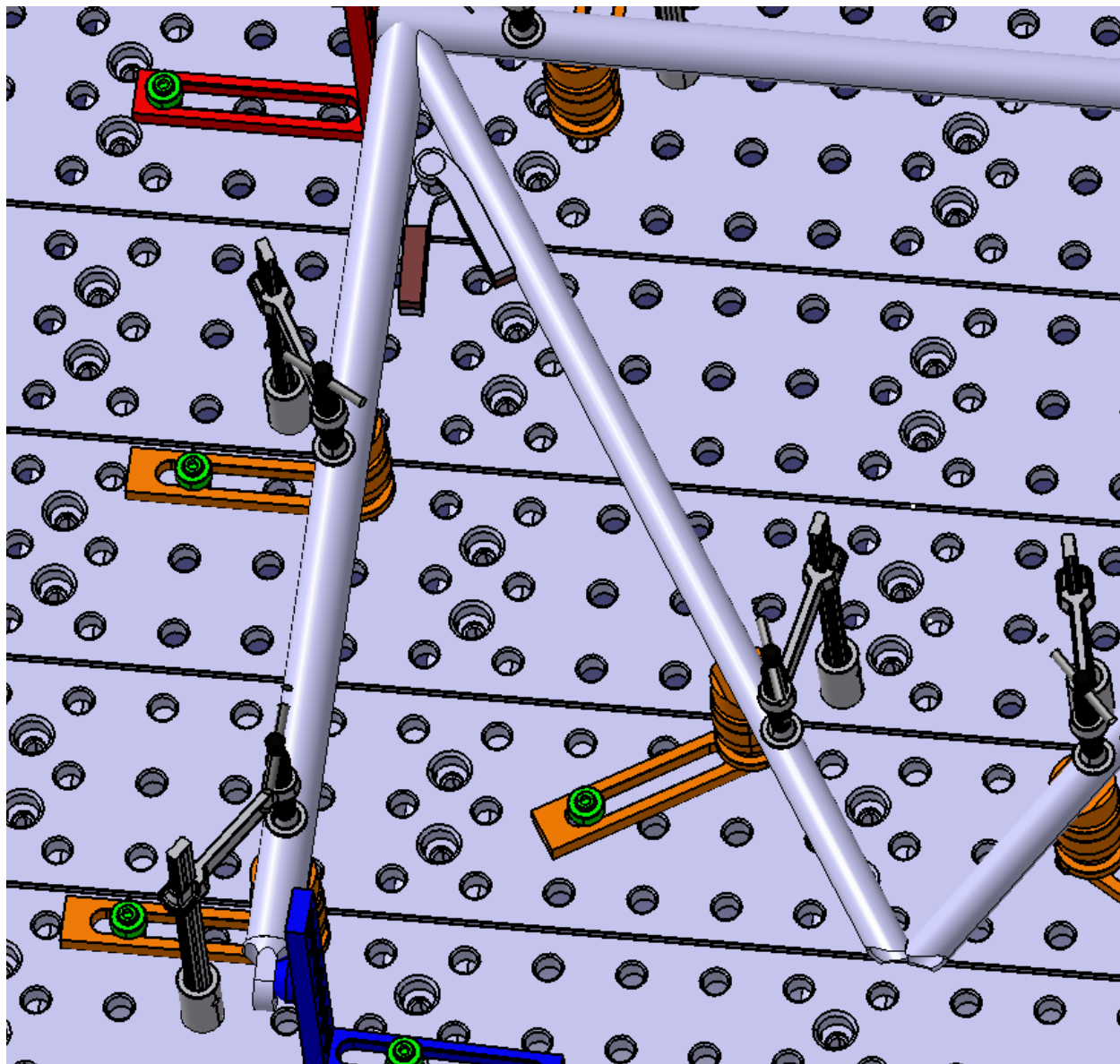


Pasul4



La pasul 5 pe langa elementele de fixare si centrare mai apare un element reglabil pentru unghi cu capete magnetice pentru a putea obtine unghiul dorit.

Pasul5



Ansamblul realizat in urma parcurgeri pasilor 1,2,3,4,5

