

# A-ONE 工具系统(一)

--用于零件加工,精密机械

## 深圳市精钻智能制造有限公司

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A-ONE中文网站



A-ONE英文网站

Folio:210\*285mm 1/16  
Sheets:1.25 2 inset  
Revision:2022-06 first printing  
Printing: 0-3000  
Code:SZJZ-3A 01-156

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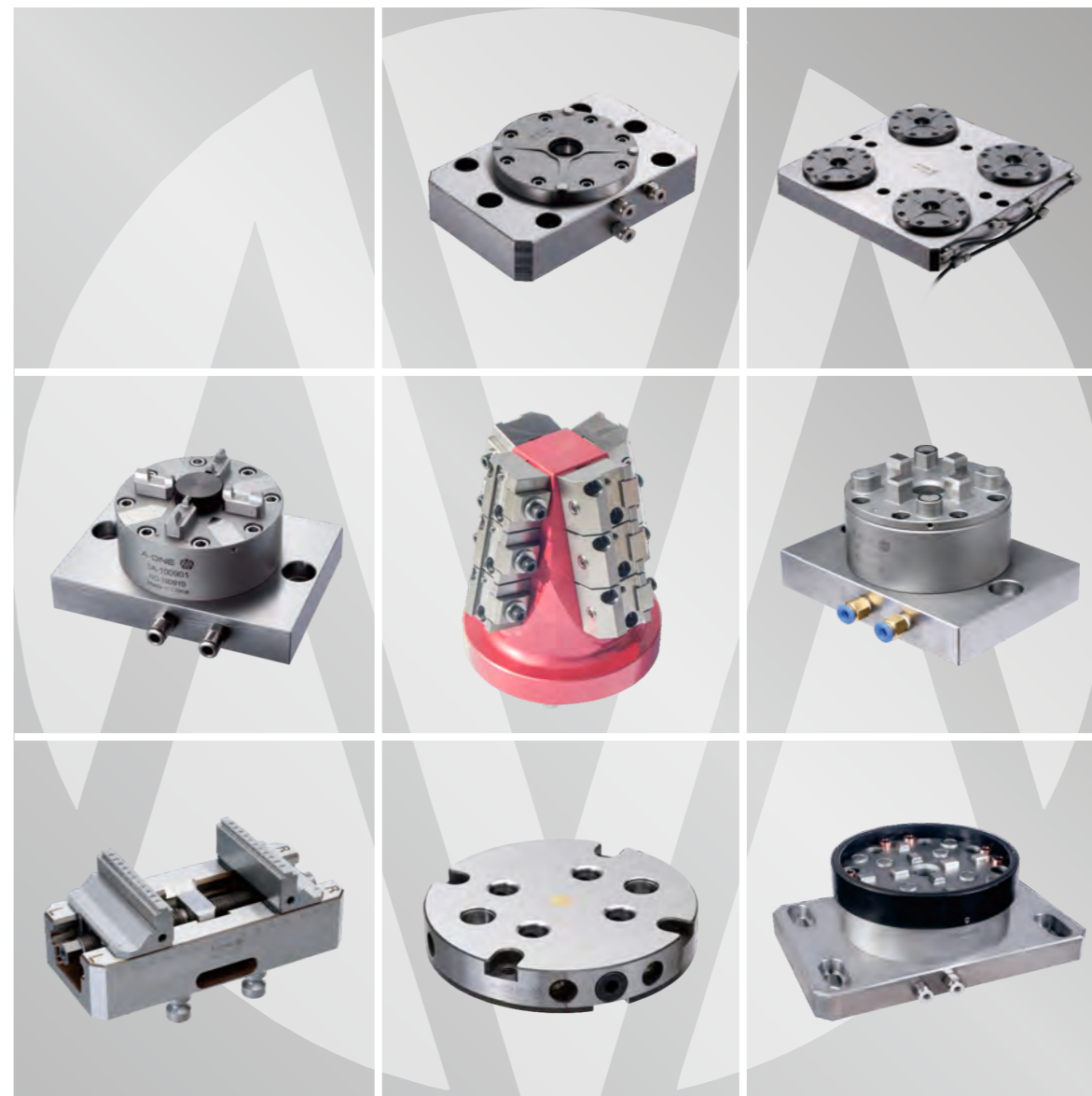
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A-ONE 



## 公司简介

深圳市精钻智能制造有限公司自2000年成立以来，秉承“精益求精，钻石服务”的经营理念，不断引进先进的设备及技术，生产高品质、稳定可靠的产品，为客户创造更多价值。现有牧野（MAKINO）、哈斯（HAAS）数控加工中心；大隈（OKUMA）数控车床，琼格（JUNG）数控成型磨床、克林伯格（KELLENBERGER-100）数控内外圆磨床、摩尔（MOORE）坐标磨床及蔡司（ZEISS）三次元等先进的制造设备及检测仪器，经过20年多年的技术沉淀及经验积累，已发展成具有一定规模的生产企业。

公司主要生产：零点快换夹具系列；电极制造夹具系列；自定心虎钳及燕尾槽夹具系列；夹头、导套等轴类产品系列，广泛应用于模具电极制造和零件加工领域，适用于加工中心、数控车床、电火花机、线切割等设备，凭借产品丰富、品质稳定、价格合理，赢得客户的信赖与支持，产品远销美国、俄罗斯、德国、瑞士、意大利、法国、西班牙、以色列、日本、韩国等国家。

并于2022年苏州生产基地正式竣工投产，使用面积达25000平方米，为高品质、批量化生产提供强有力保证，并承接非标夹具设计、精密零件及OEM委托制造服务，助您开创事业新版图。

精钻公司始终坚持：为企业及行业发展有所贡献而奋斗，我们以此为目标，专注行业发展，洞察客户需求，综合综效，以双赢思维服务好每一位客户。

## Company profile

Since its establishment in 2000, Shenzhen Jingzuan Intelligent Manufacturing Co., Ltd. has been adhering to the business philosophy of "Keep Improving, Diamond Service", constantly introducing advanced equipment and technology, producing high-quality, stable and reliable products, and creating more value for customers. The company currently has MAKINO and HAAS CNC machining centers; OKUMA CNC lathes, JUNG CNC forming grinders, KELLENBERGER-100 CNC internal and external cylindrical grinders, MOORE coordinate grinder, ZEISS three-dimensional, other advanced manufacturing equipment and testing instruments. After more than 20 years of technical precipitation and experience accumulation, it has developed into a certain scale of production enterprises.

The company mainly produces: zero-point quick change fixture series; electrode manufacturing fixture series; self-centering vise and dovetail fixture series; shaft product series such as collet chuck and guide sleeves, which are widely used in the field of mold electrode manufacturing and parts processing, suitable for machining centers, CNC lathes, EDM machines, wire cutting and other equipment. With rich products, stable quality and reasonable prices, it has won the trust and support of customers. The products are exported to the United States, Russia, Germany, Switzerland, Italy, France, Spain, Israel, Japan, South Korea and other countries.

The Suzhou production base will be completed and put into operation in 2022, with an area of 25,000 square meters, providing a strong guarantee for high-quality, mass production, and undertaking non-standard fixture design, precision parts and OEM commissioned manufacturing services to help you create a new business map.

Jingzuan Company always insists: strive to contribute to the development of the enterprise and the industry. We take this as the goal, focus on industry development, insight into customer needs, integrate comprehensive results, and serve every customer with a win-win thinking.



苏州工厂



深圳工厂

- A-ONE快速定位夹具系统使用简单，将柔性和刚性完美结合。通过客户长期使用，一起见证A-ONE快速定位夹具在使用中体现：耐用、稳定、可靠。
- 标准化的接口—实现铣削、钻削、车削、磨削、电火花成型、线切割机床以及测量和预调台高效转换，确保加工品质，提高生产效率。

- A-ONE fast positioning fixture system is easy to use and makes perfect combination of flexibility and rigidity. Through the long-term use of customers, we will witness the A-ONE quick positioning fixture in use: durable, stable and reliable.
- Standardized interfaces – highly efficient conversion among the milling, drilling, turning, grinding, EDM shaping, linear cutting machine, measuring and presetting station, which can ensure machining quality and improve the production efficiency.





## 苏州生产车间

# SUZHOU PRODUCTION WORKSHOP



MAKINO 牧野卧式加工中心 a92 轴向行程: 1520\*1250\*1350  
X、Y、Z轴光栅反馈0.1μm

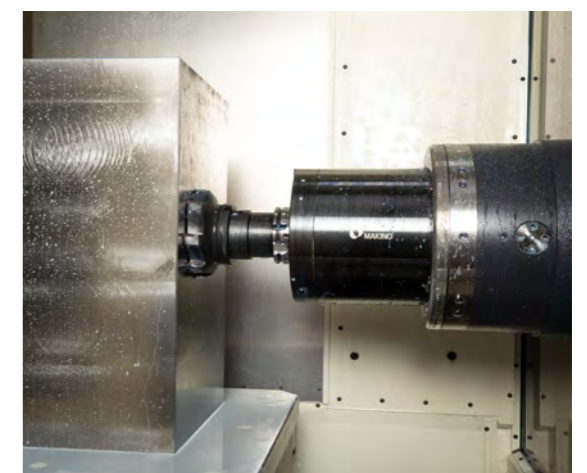


MAKINO 牧野卧式加工中心 a81NX 轴向行程: 900\*900\*1020, X、Y、Z轴光栅反馈0.05μm

### 制造设备 Manufacturing facilities

为满足客户大工件生产需求, 精钻苏州工厂投资购置: 大行程生产设备及检测仪器, 如: 大隈龙门加工中心, 轴向行程: 2000\*1600\*450、牧野数控卧式加工中心, 轴向行程: 1520\*1250\*1350, X、Y、Z轴光栅反馈0.1μm, 冈本精密平面磨床及海克斯康三坐标测量仪

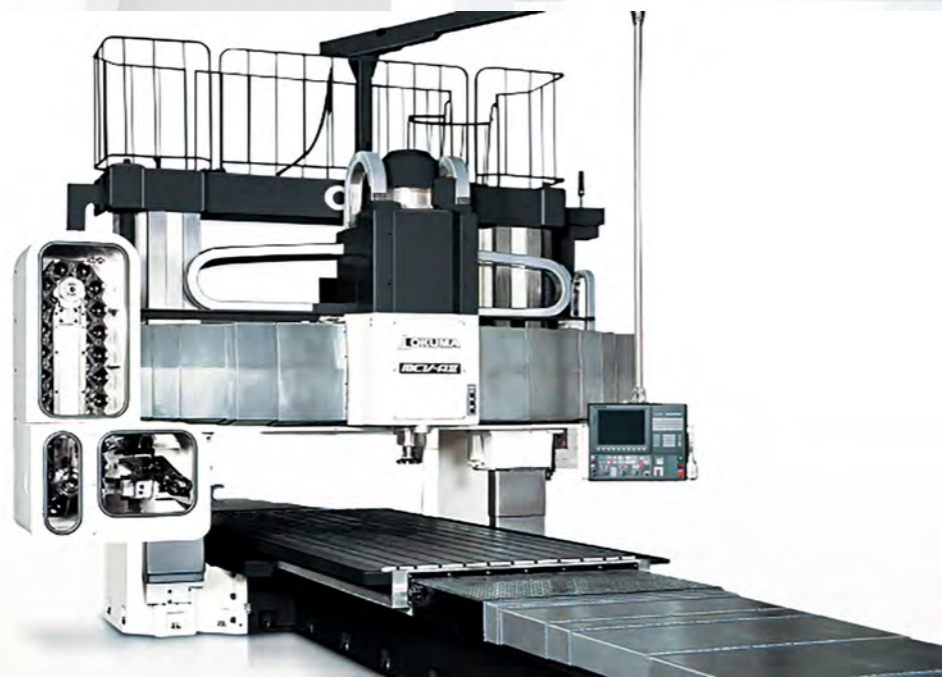
In order to meet the needs of customers for the production of large workpieces, JingZuan Suzhou factory invested and purchased: large-travel production equipment and testing instruments, such as: Okuma Machining Center, axial stroke: 2000\*1600\*450, Makino CNC horizontal machining center, axial stroke: 1520\*1250\*1350, X, Y, Z axis grating feedback 0.1μm, Okamoto precision surface grinder and Hexagon three-coordinate testing equipment.





# 苏州生产车间

## SUZHOU PRODUCTION WORKSHOP



OKUMA 大隈龙门加工中心 MCV-AII16\*20 轴向行程: 2000\*1600\*450



OKAMOTO 冈本平面磨床 ACC105GX 工作台行程: 1150\*540

# 苏州检测室

## SUZHOU TESTING WORKSHOP



HEXAGON 海克斯康三坐标测量仪 SAGER 06.08.06  
行程范围: 600\*800\*600, 长度测量误差:  $E_0=0.6+L/400\mu\text{m}$ , 重复精度:  $0.5\mu\text{m}$



HEXAGON 海克斯康三坐标测量仪 Inspector Classic 12.22.10 行程范围: 1200\*2200\*1000



## 深圳生产车间

# SHENZHEN PRODUCTION WORKSHOP



MAKINO加工中心 MAKINO Machining center



柔性生产线 Flexible production line

完整的、先进的生产加工设备、专职的技术人员及严格的生产工艺管控，保证了产品的交货期及配合客户应急的快速生产。

Complete, first-class processing equipment, professional technician and excellent manufacturing technique control, to ensure the product delivery and coordinate with emergency fasten manufacture as customer request.



OKUMA CNC 精加工 OKUMA CNC Precise machining

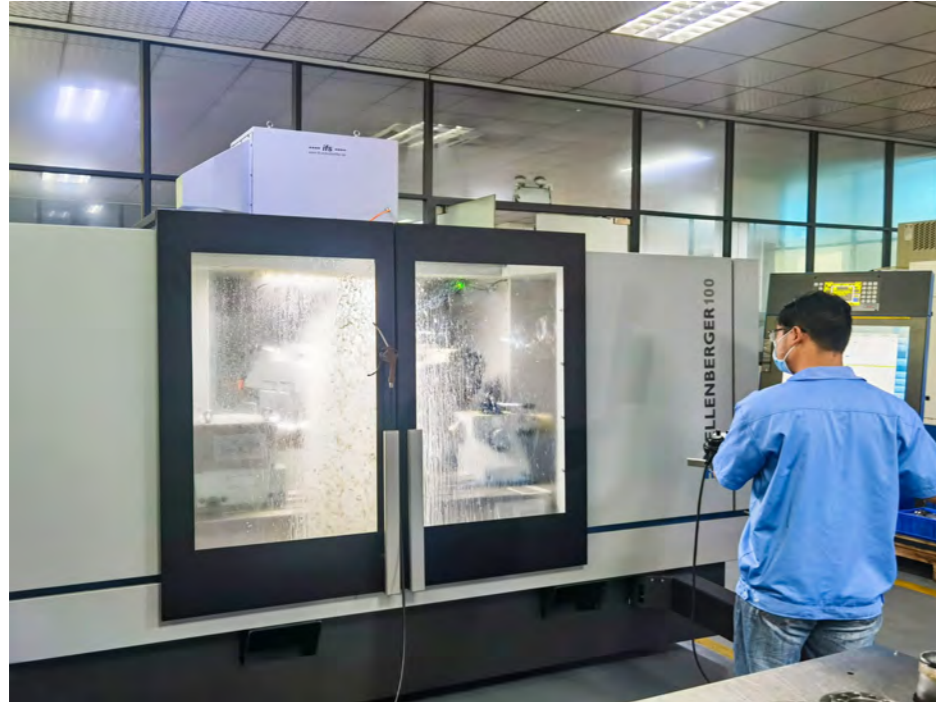


OKUMA 车床 OKUMA Lathe



## 深圳生产车间

# SHENZHEN PRODUCTION WORKSHOP



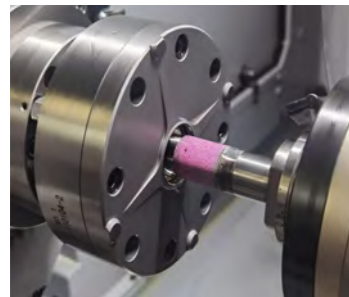
多达10种砂轮头架配置形式，所有砂轮头架均可进行直线或角向切入磨削，适用于外圆，内孔和端面磨削。控制系统的扩展软件，用于磨削标准非圆轮廓，例如：矩形，多边形，偏心圆，椭圆，半圆棒，扁平面等常见非圆轮廓。也用于磨削三棱形刀柄（COROMANT Capto），可进行圆周轮廓修正

Software extension on machine control. Simple program creation on machine control for grinding of standard non-circular contours such as Rectangle, Polygon, Eccentric, Ellipse, Rounded Bar, Flattening Subsequent Bar, Subsequent Square. Forms for polygon toolholders (COROMANT CAPTO) including extensive correction possibilities.

KELLENBERGER 100 — 完美的数控万能内外圆磨床  
Perfect CNC universal inner and outer cylindrical grinding machine



MOORE 坐标磨车间 MOORE Coordinate grinding



斯图特内外圆磨 STUDER Internal and external grinding



JUNG 琼格磨床 JUNG Grinding machine



专业 可靠 耐用 精密  
professional reliable durable precision



瑞士TESA测高仪  
Swiss TESA height indicator



瑞士TESA测高仪  
Swiss TESA height indicator

## 优良的品质保证 Excellent quality

公司全面推行ISO90001质量管理体系，并拥有德国ZEISS三坐标测量仪，ZEISS工具显微镜等检测设备，所有产品全检出货，为生产高精密的产品提供了强有力的保证。

We carried out the ISO90001 quality management system. The ZEISS coordinate measuring machine, ZEISS tool microscope and other advanced measuring equipment. All products are fully inspected to ensure the high precision.



ZEISS三坐标测量仪检测  
3A-110004零点卡盘  
ZEISS coordinate measuring machine detects Zero Point Chuck 3A-110004



ZEISS三坐标测量仪检测  
3A-200002旋转摆动式虎钳  
ZEISS coordinate measuring machine detects Rotatable Pendulum Vise 3A-200002



ZEISS三坐标测量仪检测  
ITS卡盘  
ZEISS coordinate measuring machine detects ITS Chuck



德国蔡司工具显微镜  
ZEISS tool microscope



万能工具显微镜  
ZEISS universal tool-measuring microscope




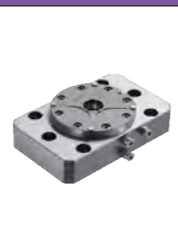

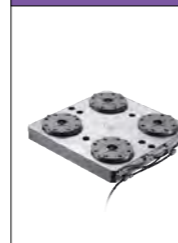














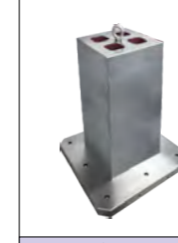
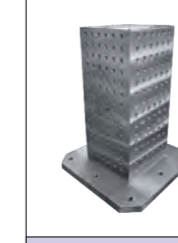











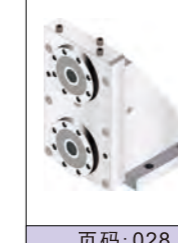

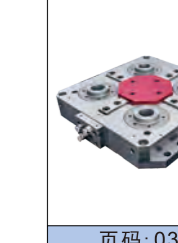











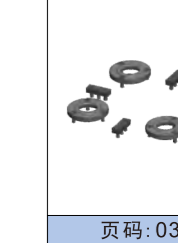











NIKON V-16A投影仪  
NIKON V-16A Projector


























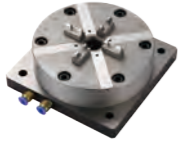




















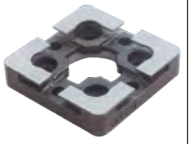












洛氏硬度计  
Rockwell hardness



































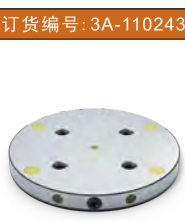







ZEISS三坐标测量仪  
ZEISS coordinate measuring machine



<p>零点定位系统</p> <p>P. 011~029</p>	<p>订货编号: 3A-110104</p>  <p>页码: 011</p>	<p>订货编号: 3A-110105</p>  <p>页码: 011</p>	<p>订货编号: 3A-110106</p>  <p>页码: 011</p>	<p>订货编号: 3A-110107</p>  <p>页码: 012</p>	<p>订货编号: 3A-110120</p>  <p>页码: 012</p>	<p>订货编号: 3A-400017</p>  <p>页码: 022</p>	<p>订货编号: 3A-400014</p>  <p>页码: 022</p>	<p>订货编号: 3A-400049</p>  <p>页码: 023</p>	<p>订货编号: 3A-400050</p>  <p>页码: 023</p>	<p>订货编号: 3A-400053</p>  <p>页码: 023</p>	<p>订货编号: 3A-400018</p>  <p>页码: 024</p>		
	<p>订货编号: 3A-110103</p>  <p>页码: 013</p>	<p>订货编号: 3A-110105P</p>  <p>页码: 013</p>	<p>订货编号: 3A-110106P</p>  <p>页码: 013</p>	<p>订货编号: 3A-110107P</p>  <p>页码: 014</p>	<p>订货编号: 3A-110120P</p>  <p>页码: 014</p>	<p>订货编号: 3A-400100</p>  <p>页码: 015</p>	<p>订货编号: 3A-400019</p>  <p>页码: 024</p>	<p>订货编号: 3A-10000154</p>  <p>页码: 025</p>	<p>订货编号: 3A-10000154</p>  <p>页码: 025</p>	<p>订货编号: 3A-110082</p>  <p>页码: 026</p>	<p>订货编号: 3A-10000818</p>  <p>页码: 026</p>	<p>订货编号: 3A-10000824</p>  <p>页码: 027</p>	
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	<p>订货编号: 3A-110092</p>  <p>页码: 017</p>	<p>订货编号: 3A-110093</p>  <p>页码: 017</p>	<p>订货编号: 3A-110019</p>  <p>页码: 018</p>	<p>订货编号: 3A-110119</p>  <p>页码: 018</p>	<p>订货编号: 3A-110004</p>  <p>页码: 019</p>	<p>订货编号: 3A-110006</p>  <p>页码: 019</p>	<p>订货编号: 3A-100044</p>  <p>页码: 034</p>	<p>订货编号: 3A-100045</p>  <p>页码: 034</p>	<p>订货编号: 3A-100046</p>  <p>页码: 034</p>	<p>订货编号: 3A-110096</p>  <p>页码: 035</p>		<p>订货编号: 3A-110097</p>  <p>页码: 035</p>	<p>订货编号: 3A-110098</p>  <p>页码: 035</p>
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订货编号: 3A-800004  页码: 040	订货编号: 3A-800003  页码: 040	圆锥拉钉套装  页码: 041	菱形拉钉套装  页码: 041	夹紧拉钉  页码: 041	圆锥定位环  页码: 042	订货编号: 3A-400005  页码: 058	订货编号: 3A-400007  页码: 058	订货编号: 3A-400076  页码: 056	订货编号: 3A-400038  页码: 058	订货编号: 3A-400039  页码: 058	订货编号: 3A-400001  页码: 059
2232粗定位环  页码: 042	<b>基准卡盘</b> P. 045~060	订货编号: 3A-100901  页码: 048	订货编号: 3A-100902  页码: 048	订货编号: 3A-100904  页码: 048	订货编号: 3A-100057  页码: 049	订货编号: 3A-400002  页码: 059	订货编号: 3A-400003  页码: 059	订货编号: 3A-300003  页码: 060	订货编号: 3A-100031  页码: 060	订货编号: 3A-100013  页码: 060	<b>R型系列 夹具</b> P. 063~067
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订货编号: 3A-100028  页码: 051	订货编号: 3A-100069  页码: 051	订货编号: 3A-100027  页码: 052	订货编号: 3A-1000349  页码: 052	五轴台安装板、进气板  页码: 053	订货编号: 3A-110018  页码: 054	订货编号: 3A-400141  页码: 065	订货编号: 3A-100075  页码: 065	订货编号: 3A-100056  页码: 065	订货编号: 3A-300027  页码: 066	订货编号: 3A-400008  页码: 066	订货编号: 3A-400090  页码: 066
订货编号: 3A-110048  页码: 054	订货编号: 3A-110084  页码: 054	订货编号: 3A-110031  页码: 054	订货编号: 3A-110099  页码: 055	订货编号: 3A-110401  页码: 056	订货编号: 3A-110402  页码: 056	订货编号: 3A-400006  页码: 067	订货编号: 3A-400043  页码: 067	订货编号: 3A-400143  页码: 067	<b>自定心 虎钳</b> P. 069~077	订货编号: 3A-110185  页码: 074	订货编号: 3A-110186  页码: 074

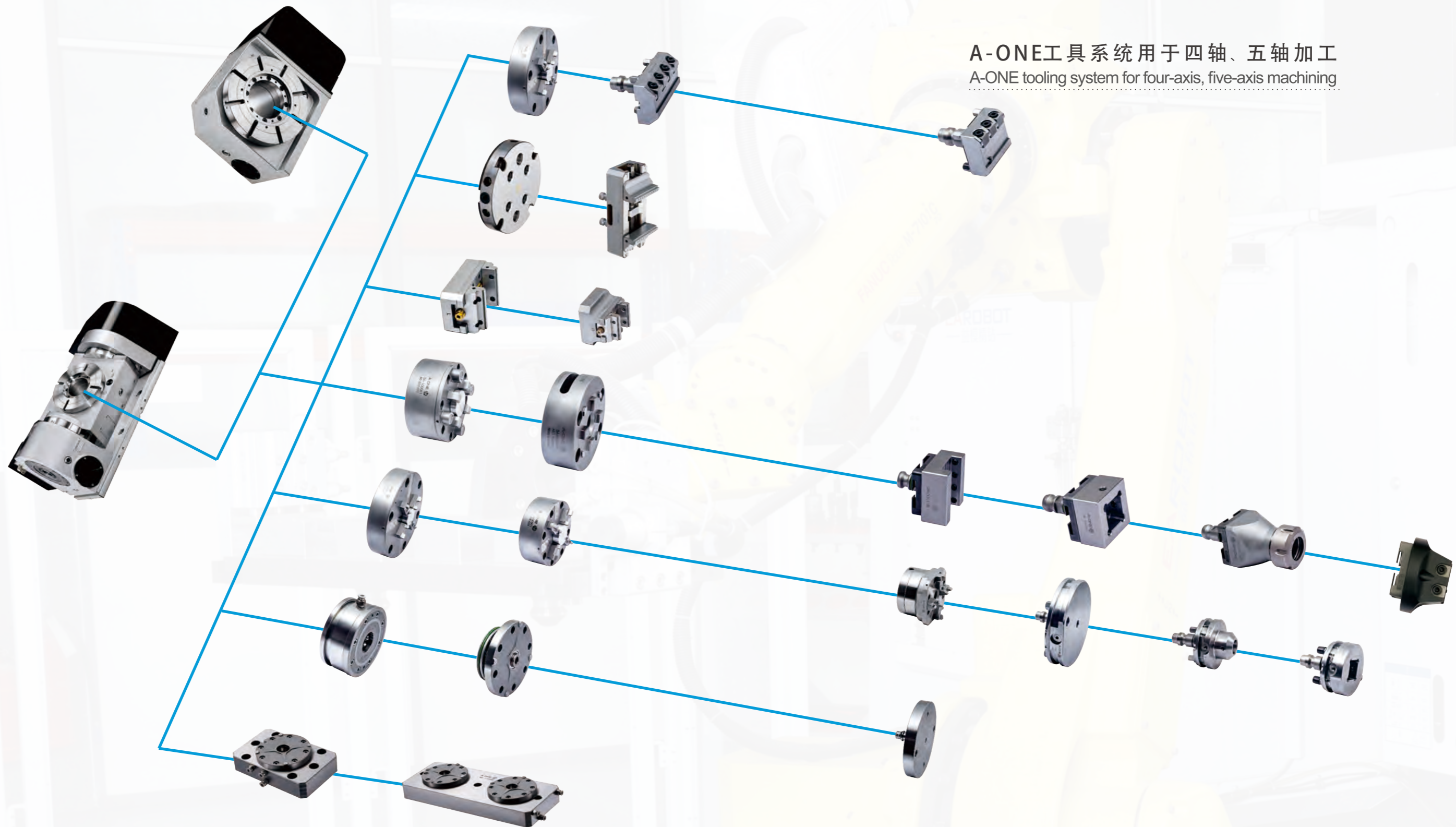
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左右爪  页码: 077	丝杆基座  页码: 077	订货编号: 3A-110197  页码: 077	六角扳手  页码: 077	零点定位快锁 P. 079~090	订货编号: 3A-110165  页码: 080	订货编号: 3A-110241  页码: 090	订货编号: 3A-110194  页码: 090	夹紧装置 P. 093~103	订货编号: 3A-110010  页码: 094	订货编号: 3A-110011  页码: 094	订货编号: 3A-110012  页码: 094
订货编号: 3A-110170  页码: 080	订货编号: 3A-110171  页码: 080	订货编号: 3A-110172  页码: 081	订货编号: 3A-110173  页码: 081	订货编号: 3A-110166  页码: 081	订货编号: 3A-110167  页码: 082	订货编号: 3A-110013  页码: 094	订货编号: 3A-110226  页码: 095	订货编号: 3A-110222  页码: 095	订货编号: 3A-110221  页码: 095	订货编号: 3A-110070  页码: 96	订货编号: 3A-110511  页码: 097
订货编号: 3A-110168  页码: 082	订货编号: 3A-110169  页码: 082	订货编号: 3A-110174  页码: 083	订货编号: 3A-110175  页码: 083	订货编号: 3A-110176  页码: 083	订货编号: 3A-110164  页码: 084	订货编号: 3A-110513  页码: 098	订货编号: 3A-110519  页码: 099	订货编号: 3A-110301  页码: 100	订货编号: 3A-110303  页码: 100	订货编号: 3A.1  页码: 101	订货编号: 3A.20  页码: 102
订货编号: 3A-110243  页码: 086	订货编号: 3A-110247  页码: 086	订货编号: 3A-110248  页码: 086	订货编号: 3A-110249  页码: 087	订货编号: 3A-110250  页码: 087	订货编号: 3A-110162  页码: 087	订货编号: 3A.30  页码: 103	其他夹具 P. 105~120	订货编号: 3A-110081  页码: 106	订货编号: 3A-110083  页码: 106	组合夹具  页码: 107	订货编号: 3A-110211  页码: 112



订货编号: 3A-110212  页码: 112	订货编号: 3A-110213  页码: 112	订货编号: 3A-110214  页码: 113	订货编号: 3A-110215  页码: 113	订货编号: 3A-110079  页码: 113	订货编号: 3A-110089  页码: 114
订货编号: 3A-110077  页码: 114	订货编号: 3A-110078  页码: 114	燕尾托板 A  页码: 115	订货编号: 3A-110064  页码: 115	订货编号: 3A-110065  页码: 115	订货编号: 3A-110095  页码: 116
订货编号: 3A-110061  页码: 116	订货编号: 3A-110085  页码: 116	订货编号: 3A-700004  页码: 118	订货编号: 3A-700001  页码: 118	订货编号: 3A-700005  页码: 119	订货编号: 3A-120001  页码: 120







A-ONE工具系统用于四轴、五轴加工  
A-ONE tooling system for four-axis, five-axis machining

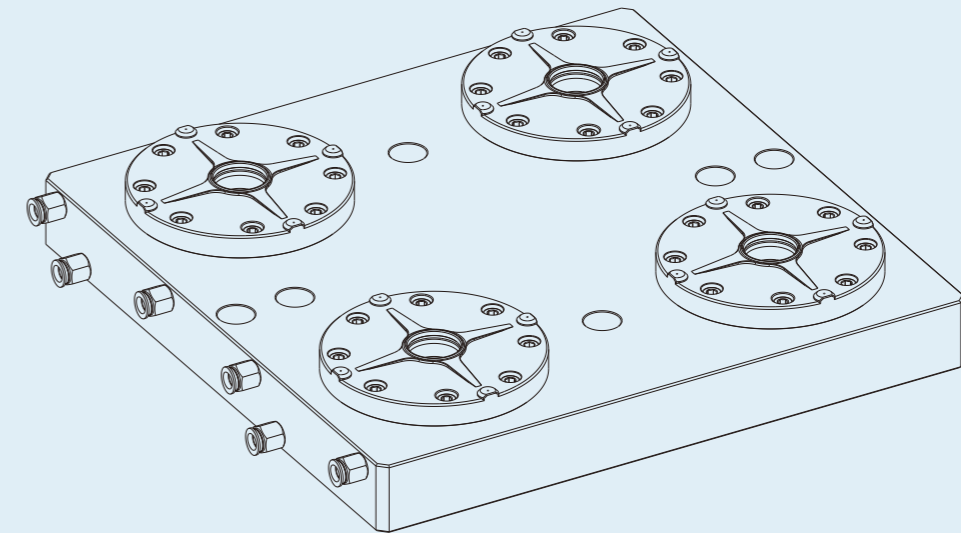


# 零点定位系统

Zero point system

<http://www.szjztools.com>  
<http://www.system3a.com>

最新产品信息、公司资讯等敬请浏览本公司主页  
Please visit our homepage for the latest product information, company information, etc.



P.005~P.028



1. 安装夹具占用机床时间太长怎么办?



▲ 技术娴熟的工人在加工中心上安装角固定虎钳至少需要15-17分钟时间,使用零点定位系统在安装同样虎钳时,普通操作工人在1分钟不到时间就可完美实现,缩短安装时间,降低工人的技能要求,提高95%以上效率!

3. 灵活简单设计,可实现多面加工



▲ 使用A-ONE 零点定位系统,在立式加工中心、卧式加工中心上,轻松实现多面加工,提高生产效率

2. 人工成本高、精密机床工时昂贵,如何提高效率?



▲ A-ONE零点定位系统一标准化接口,重复定位精度小于0.005mm,配备多套托板夹具后可实现零件离线安装,提高快换效率,减少待机时间,提高机床使用效率

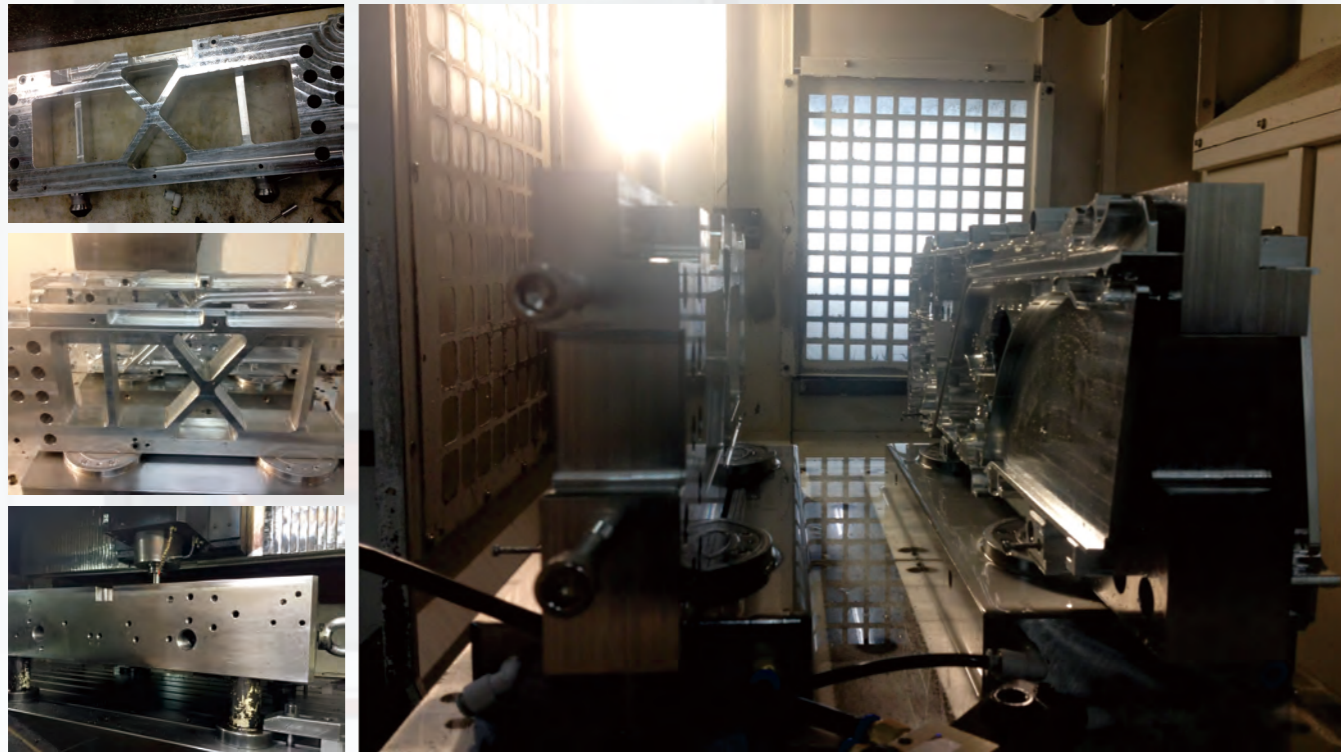
4. 广泛应用于四轴,五轴加工中心



▲ A-ONE零点定位系统内嵌安装可直接替代四轴托板,在实现快速切换的同时又减小系统运用尺寸,给工件留出更大的空间实现工装夹具可以快速更换,提高生产效率



5. 如何更高效的加工大件壳体类零件?



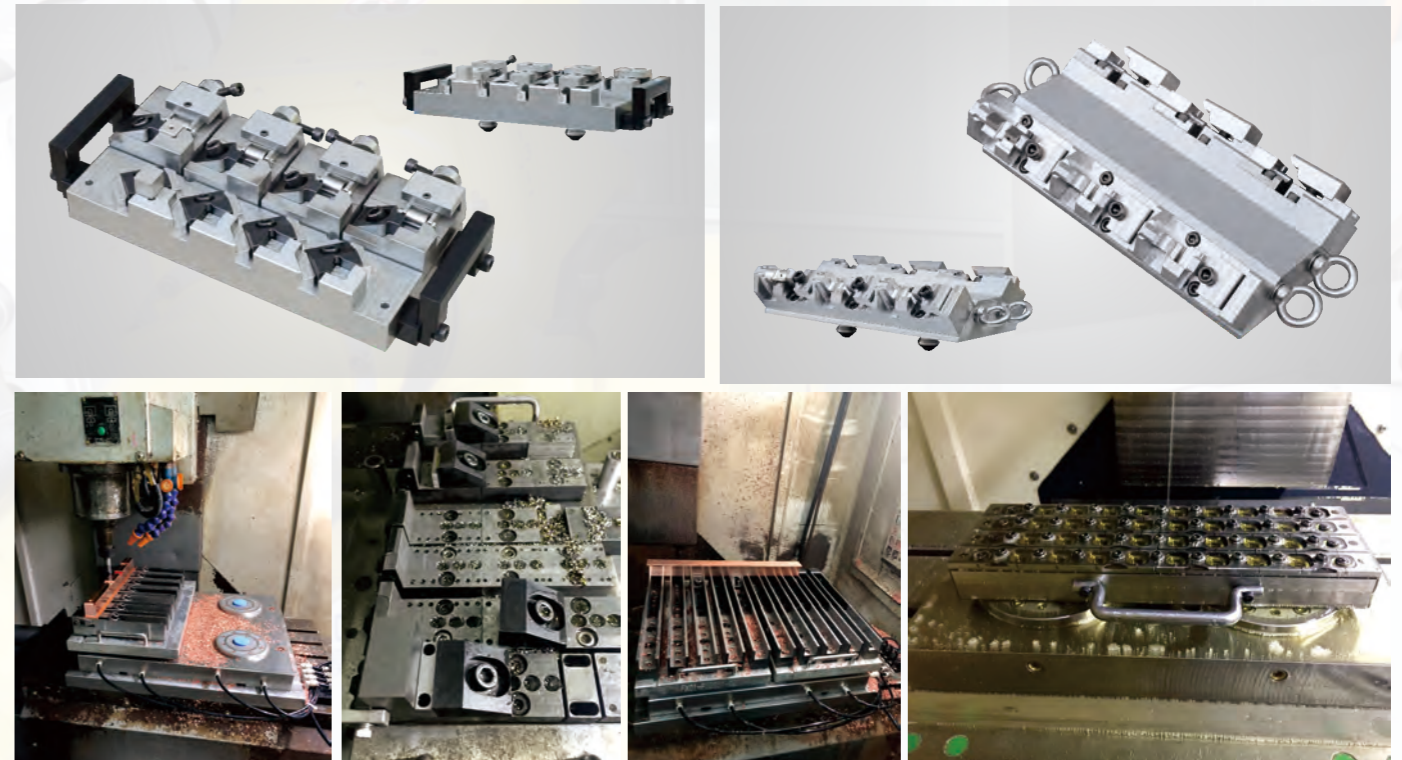
▲ A-ONE零点定位系统在加工大件壳体类零件时，直接将A-ONE零点定位器安装在工件上，可发挥随行夹具的作用，降低夹具成本的同时，又能提高加工精度！

6. 零点定位系统与其他夹具完美组合使用



▲ A-ONE零点定位系统和TTS卡盘混合使用，再根据工件尺寸灵活选择最合适的工具系统

7. 如何解决不规则工件装夹



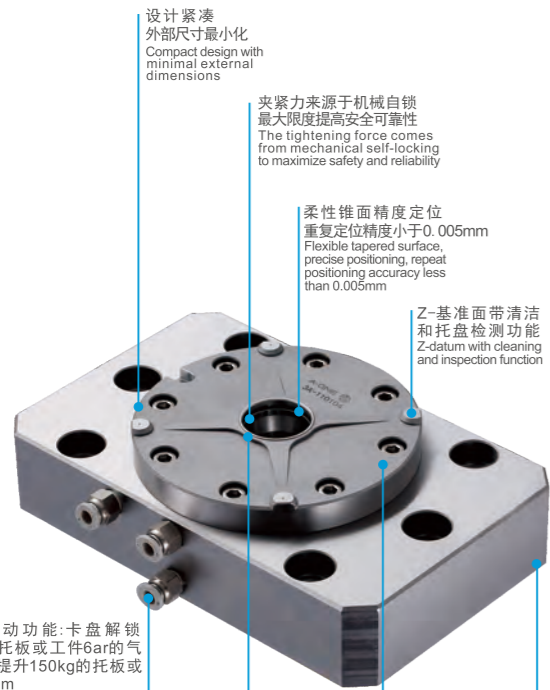
▲ A-ONE零点定位系统以其易安装、重复定位精度高(小于0.005mm)、夹紧力大、性价比高、品质稳定等优点，广泛应用于自动化生产线、加工中心、柔性制造系统，深受客户青睐，在实际加工中根据客户加工需求，量身订做，提供整套夹具系统设计方案

8. 零点定位系统可运用自动化生产线吗?



▲ 使用A-ONE 零点定位系统以其标准化接口易安装，重复定位精度是<0.005mm，性能稳定，完全满足自动化要求





设计紧凑  
外部尺寸最小化  
Compact design with  
minimal external  
dimensions

夹紧力来源于机械自锁  
最大限度提高安全可靠  
The tightening force comes  
from mechanical self-locking  
to maximize safety and reliability

柔性锥面精度定位  
重复定位精度小于0.005mm  
Flexible tapered surface,  
precise positioning, repeat  
positioning accuracy less  
than 0.005mm

Z-基准面带清洁  
和托盘检测功能  
Z-datum with cleaning  
and inspection function

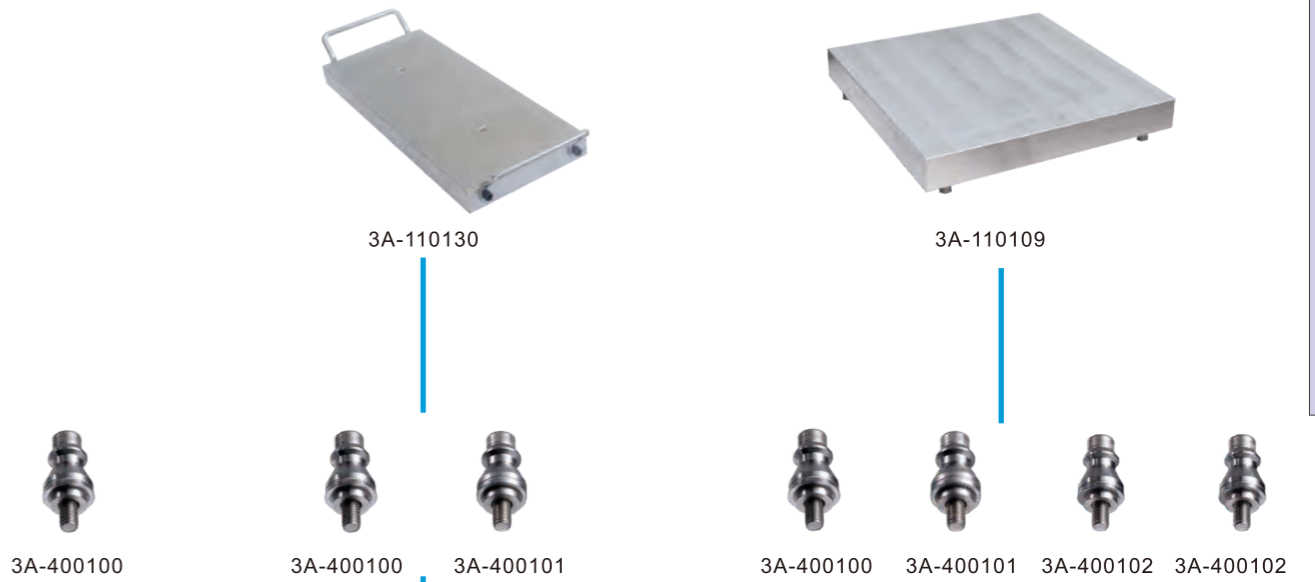
组合气动功能:卡盘解锁  
和提升托板或工件6ar的气  
压最大提升150kg的托板或  
工件1mm  
Combined pneumatic function:  
the chuck unlocks and lifts the  
pallet or workpiece. The 6Bar  
air pressure can be increased by  
up to 150kg pallet or workpiece 1mm

凸起的轴环可减少  
夹紧部分受污染  
Raised collar reduces  
contamination of the  
clamping section

不锈钢材质,适用  
于铣削、车削、磨削、  
电加工等几乎所有机床  
Stainless steel, suitable  
for milling, turning, grinding,  
EDM machining and all  
kinds of lathe

气动涡轮增压功能:  
最大夹紧力可达15000N  
Pneumatic turbocharger  
function, Maximum tightening  
force of up to 15000N

- **快速更换治具**  
Quick change fixture
- **快速更换产线**  
Quick change production line
- **重复定位精度 < 0.005mm**  
Repeat positioning accuracy < 0.005mm
- **降低生产成本**  
Reduce manufacturing cost
- **提高设备稼动率**  
Improve equipment utilization
- **整合产线模组化**  
Integrated production line modularization



3A-110130

3A-110109

3A-400100

3A-400100

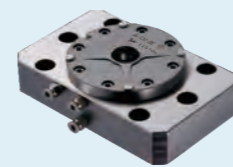
3A-400101

3A-400100

3A-400101

3A-400102

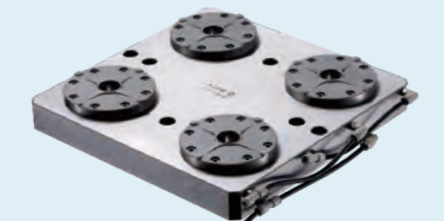
3A-400102



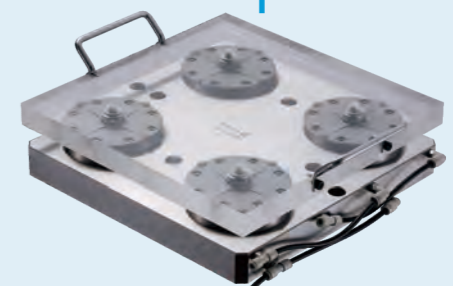
3A-110105



3A-110106



3A-110107



### 传统调机 Traditional Tuning

调机所需2~4小时以上, 停机即是损失  
It takes more than 2-4 hours to adjust the machine,  
and the downtime is a loss



停机更换工件/模治具  
Stop replacing workpiece  
/mold



人工调机  
Manual adjustment



校正基准原点(坐标系)  
Correction reference origin  
(coordinate system)



程式单节验证  
Single-section program  
verification



进行生产  
In production

**3分钟完成定位**  
3 minutes to complete positioning

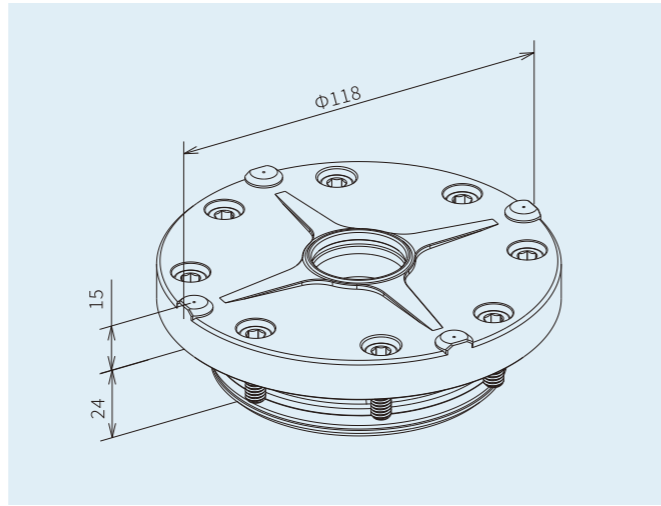
  
使用A-ONE零点定位夹持系统  
Use A-one zero positioning clamping system

  
直接定位  
Direct positioning



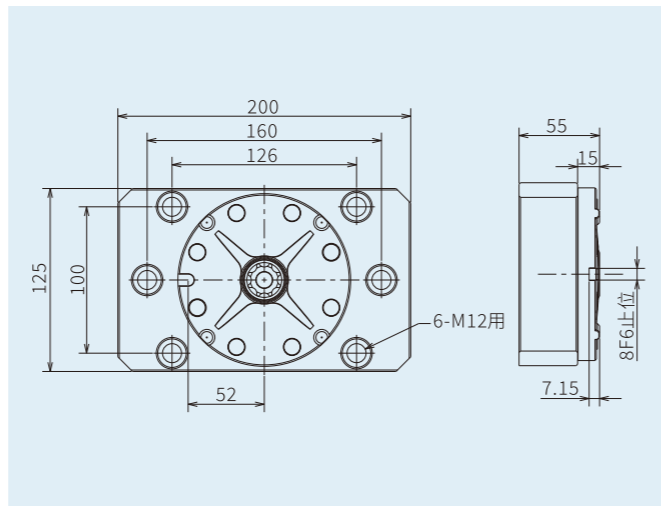
**3A-110104** 内置零点卡盘  
Built-in zero point chuck

- ▶ 解锁气压 0.6MPa, 带清洁和气检功能
- ▶ 夹紧力 增压后可达15000N
- ▶ 重复定位精度 小于0.005mm
- ▶ 特点 内置式, 镶嵌于客户自行设计的夹具基础板可抬升150kg的托板或工件1mm点接触, 减少接触面积, 提高定位精度
- ▶ Unlocking air pressure 0.6 MPa ,with cleaning and gas detection
- ▶ Clamping force Up to 15000N
- ▶ Resetting precision Less than 0.005mm
- ▶ Characteristics Built-in type, embedded in the base plate of the fixture designed by the customer, can lift a 150kg pallet or a workpiece by 1mm,Point contact, reducing contact area and improving positioning accuracy



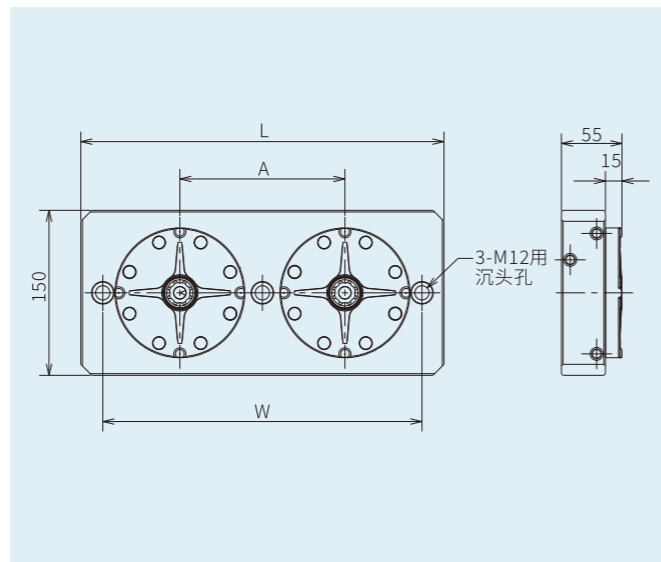
**3A-110105** 单中心零点卡盘  
Single zero-point positioning chuck

- ▶ 应用 适合63/80/100/125(126)间距T槽工作台
- ▶ 解锁气压 0.6MPa, 带清洁和气检功能
- ▶ 夹紧力 增压后可达15000N
- ▶ 重复定位精度 小于0.005mm,带止位槽
- ▶ 特点 可抬升150kg的托板或工件1mm点接触, 减少接触面积, 提高定位精度
- ▶ Application Suitable for 63/80/100/125 pitch T slot workbench
- ▶ Unlocking air pressure 0.6 MPa ,with cleaning and gas detection
- ▶ Clamping force Up to 15000N
- ▶ Resetting precision Less than 0.005mm, with stop groove
- ▶ Characteristics Can lift a 150kg pallet or a workpiece by 1mm Point contact, reducing contact area and improving positioning accuracy



**两联零点卡盘**  
Zero-point positioning chuck-double

- ▶ 解锁气压 0.6MPa, 带清洁和气检功能
- ▶ 夹紧力 单个卡盘增压后可达15000N
- ▶ 重复定位精度 小于0.005mm
- ▶ 特点 单个卡盘可抬升150kg的托板或工件1mm点接触, 减少接触面积, 提高定位精度
- ▶ Unlocking air pressure 0.6 MPa,With cleaning and gas detection
- ▶ Clamping force Single chuck can up to 15000N
- ▶ Resetting precision Less than 0.005mm
- ▶ Characteristics Single chuck Can lift a 150kg pallet or a workpiece by 1mm Point contact, reducing contact area and improving positioning accuracy

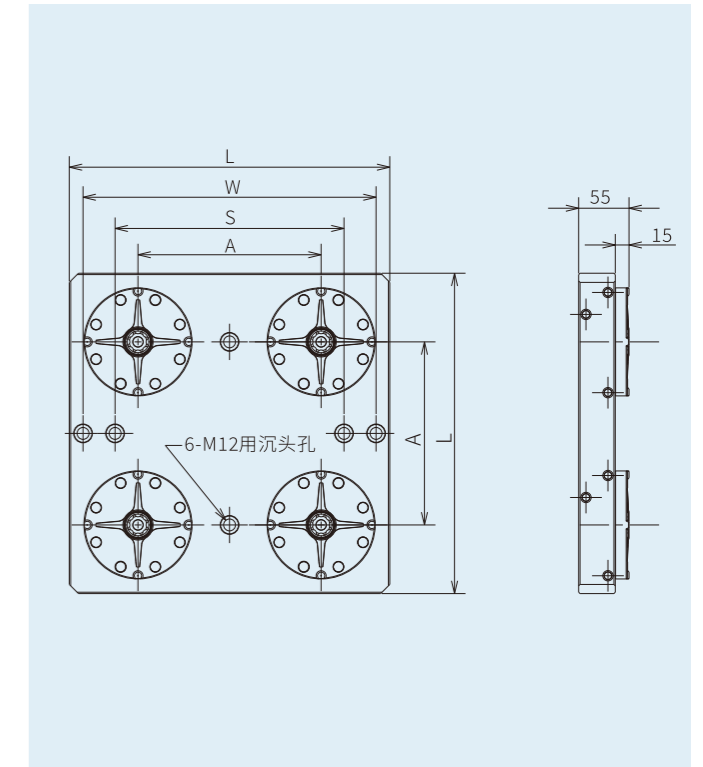


编号 Model NO	L(mm)	A(mm) 中心距 (center distance)	W(mm)
3A-110110	330	150	290
3A-110106	380	200	340
3A-110111	430	250	390

**四联零点卡盘**  
Zero-point positioning chuck -quatro

- ▶ 解锁气压 0.6 MPa, 带清洁和气检功能
- ▶ 夹紧力 单个卡盘增压后可达15000N
- ▶ 重复定位精度 小于0.005mm
- ▶ 特点 单个卡盘可抬升150kg的托板或工件1mm点接触, 减少接触面积, 提高定位精度
- ▶ Unlocking air pressure 0.6MPa, with cleaning and gas detection
- ▶ Clamping force Single chuck can up to 15000N
- ▶ Resetting precision Less than 0.005mm
- ▶ Characteristics Single chuck Can lift a 150kg pallet or a workpiece by 1mm Point contact, reducing contact area and improving positioning accuracy

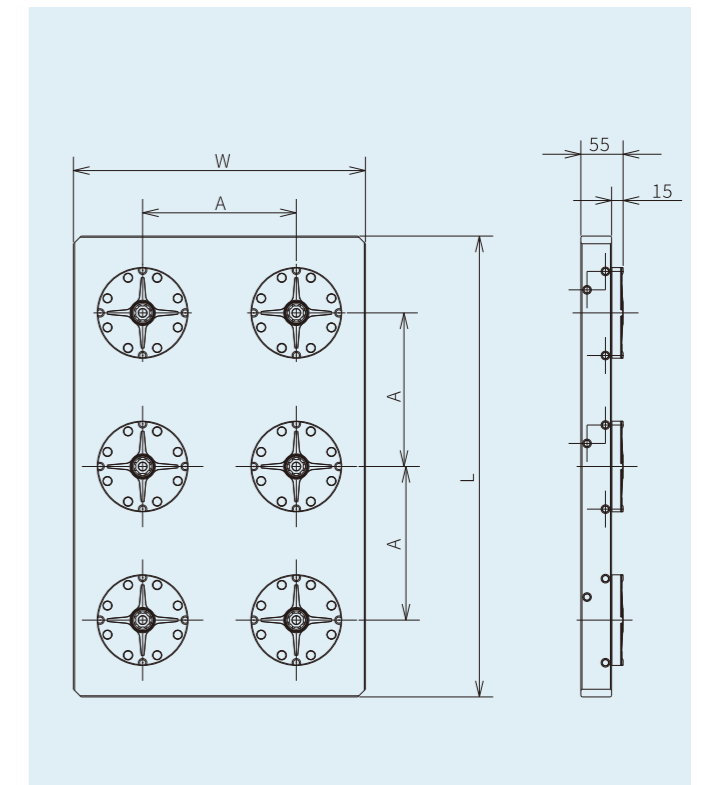
编号 Model NO	A(mm) 中心距 (center distance)	L(mm)	W(mm)	S(mm)
3A-110107	200	350	320	250
3A-110108	250	430	320	200



**六联零点卡盘**  
Zero-point positioning chuck -Hexa

- ▶ 解锁气压 0.6 MPa, 带清洁和气检功能
- ▶ 夹紧力 单个卡盘增压后可达15000N
- ▶ 重复定位精度 小于0.005mm
- ▶ 注意 钻连接孔时请不要钻破气孔
- ▶ 特点 单个卡盘可抬升150kg的托板或工件1mm点接触, 减少接触面积, 提高定位精度
- ▶ Unlocking air pressure 0.6MPa, with cleaning and gas detection
- ▶ Clamping force Single chuck can up to 15000N
- ▶ Resetting precision Less than 0.005mm
- ▶ Note Do not damage the air holes when drilling the connecting holes
- ▶ Characteristics Single chuck Can lift a 150kg pallet or a workpiece by 1mm Point contact, reducing contact area and improving positioning accuracy

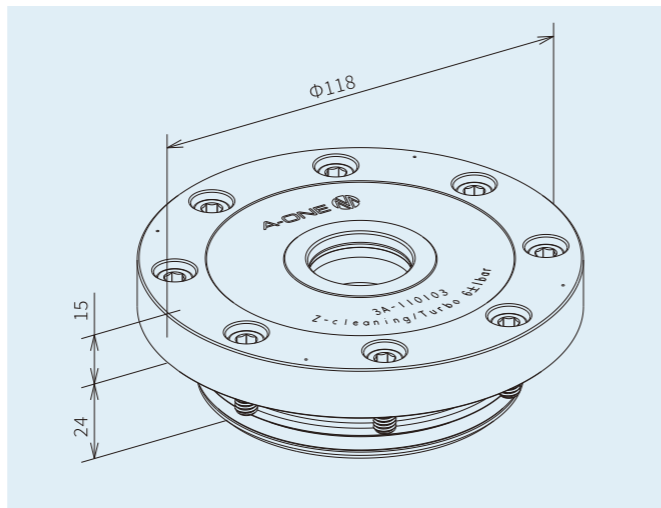
编号 Model NO	A(mm) 中心距 (center distance)	L(mm)	W(mm)
3A-110120	200	600	380
3A-110121	250	700	430





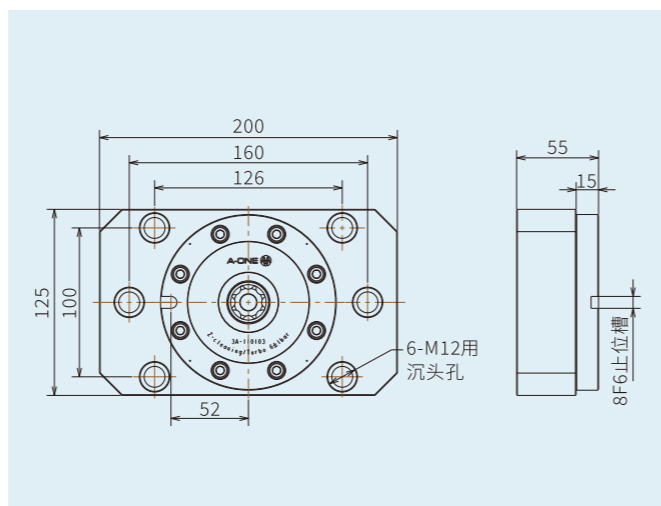
**3A-110103** 内置零点卡盘  
Built-in zero point chuck

- ▶ 解锁气压 0.6MPa, 带清洁和气检功能
- ▶ 夹紧力 增压后可达15000N
- ▶ 重复定位精度 小于0.005mm
- ▶ 特点 内置式, 镶嵌于客户自行设计的夹具基础板可抬升150kg的托板或工件1mm面接触, 接触面积大, 夹持稳定
- ▶ Unlocking air pressure 0.6 MPa, with cleaning and gas detection
- ▶ Clamping force Up to 15000N
- ▶ Resetting precision Less than 0.005mm
- ▶ Characteristics Built-in type, embedded in the base plate of the fixture designed by the customer, can lift a 150kg pallet or a workpiece by 1mm Surface contact, large contact area, stable clamping



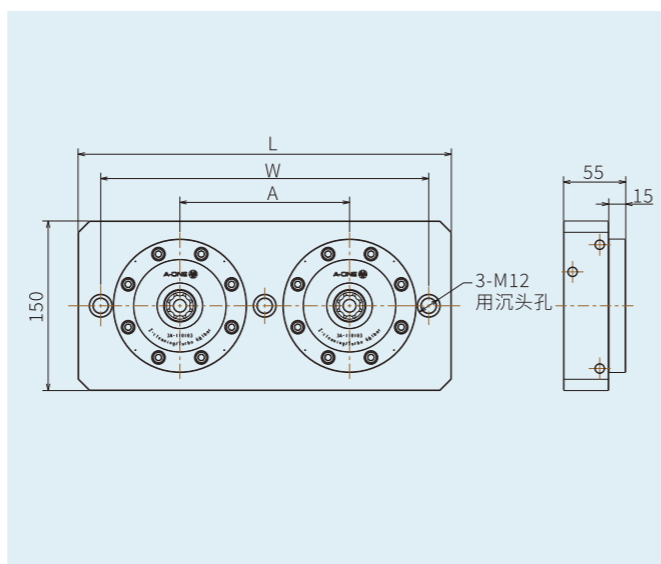
**3A-110105P** 单中心零点卡盘  
Single zero-point positioning chuck

- ▶ 应用 适合63/80/100/125(126)间距T槽工作台
- ▶ 解锁气压 0.6MPa, 带清洁和气检功能
- ▶ 夹紧力 增压后可达15000N
- ▶ 重复定位精度 小于0.005mm, 带止位槽
- ▶ 特点 可抬升150kg的托板或工件1mm面接触, 接触面积大, 夹持稳定
- ▶ Application Suitable for 63/80/100/125 pitch T slot workbench
- ▶ Unlocking air pressure 0.6 MPa, with cleaning and gas detection
- ▶ Clamping force Up to 15000N
- ▶ Resetting precision Less than 0.005mm, with stop groove
- ▶ Characteristics Can lift a 150kg pallet or a workpiece by 1mm Surface contact, large contact area, stable clamping



**两联零点卡盘**  
Zero-point positioning chuck-double

- ▶ 解锁气压 0.6MPa, 带清洁和气检功能
- ▶ 夹紧力 单个卡盘增压后可达15000N
- ▶ 重复定位精度 小于0.005mm
- ▶ 特点 单个卡盘可抬升150kg的托板或工件1mm面接触, 接触面积大, 夹持稳定
- ▶ Unlocking air pressure 0.6 MPa, With cleaning and gas detection
- ▶ Clamping force Single chuck can up to 15000N
- ▶ Resetting precision Less than 0.005mm
- ▶ Characteristics Single chuck Can lift a 150kg pallet or a workpiece by 1mm Surface contact, large contact area, stable clamping

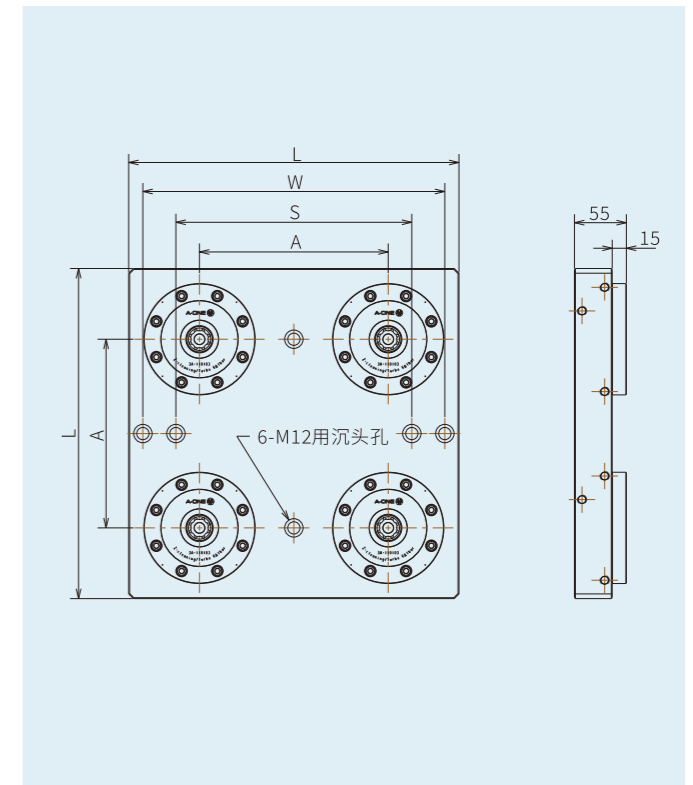


编号 Model NO	L(mm)	A(mm) 中心距 (center distance)	W(mm)
3A-110110P	330	150	290
3A-110106P	380	200	340
3A-110111P	430	250	390

**四联零点卡盘**  
Zero-point positioning chuck -quatro

- ▶ 解锁气压 0.6MPa, 带清洁和气检功能
- ▶ 夹紧力 单个卡盘增压后可达15000N
- ▶ 重复定位精度 小于0.005mm
- ▶ 特点 单个卡盘可抬升150kg的托板或工件1mm面接触, 接触面积大, 夹持稳定
- ▶ Unlocking air pressure 0.6MPa, with cleaning and gas detection
- ▶ Clamping force Single chuck can up to 15000N
- ▶ Resetting precision Less than 0.005mm
- ▶ Characteristics Single chuck Can lift a 150kg pallet or a workpiece by 1mm Surface contact, large contact area, stable clamping

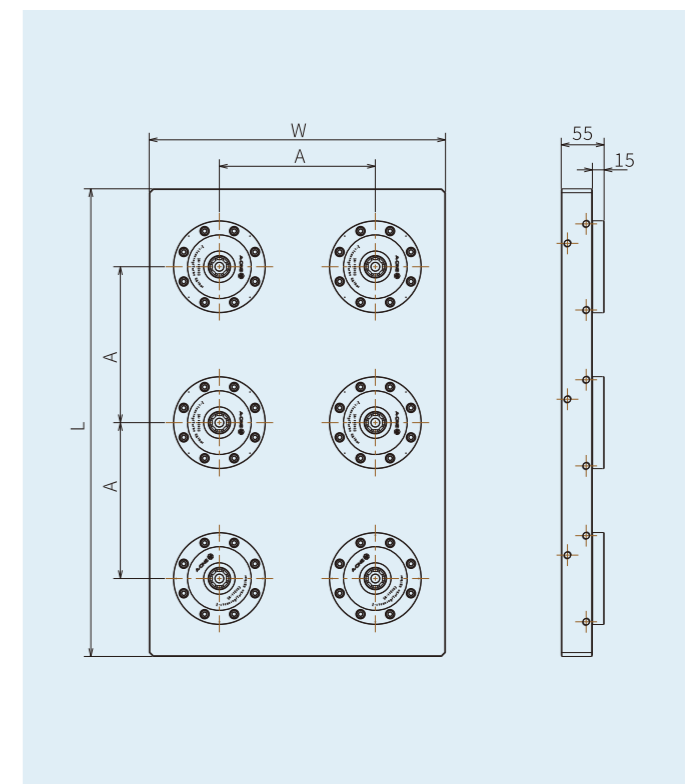
编号 Model NO	A(mm) 中心距 (center distance)	L(mm)	W(mm)	S(mm)
3A-110107P	200	350	320	250
3A-110108P	250	430	320	200



**六联零点卡盘**  
Zero-point positioning chuck -Hexa

- ▶ 解锁气压 0.6MPa, 带清洁和气检功能
- ▶ 夹紧力 单个卡盘增压后可达15000N
- ▶ 重复定位精度 小于0.005mm
- ▶ 注意 钻连接孔时请不要钻破气孔
- ▶ 特点 单个卡盘可抬升150kg的托板或工件1mm面接触, 接触面积大, 夹持稳定
- ▶ Unlocking air pressure 0.6MPa, with cleaning and gas detection
- ▶ Clamping force Single chuck can up to 15000N
- ▶ Resetting precision Less than 0.005mm
- ▶ Note Do not damage the air holes when drilling the connecting holes
- ▶ Characteristics Single chuck Can lift a 150kg pallet or a workpiece by 1mm Surface contact, large contact area, stable clamping

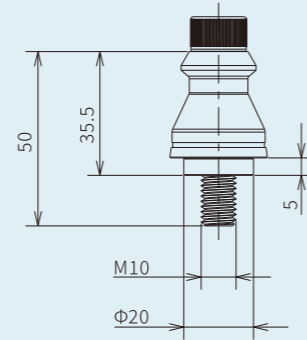
编号 Model NO	A(mm) 中心距 (center distance)	L(mm)	W(mm)
3A-110120P	200	600	380
3A-110121P	250	700	430





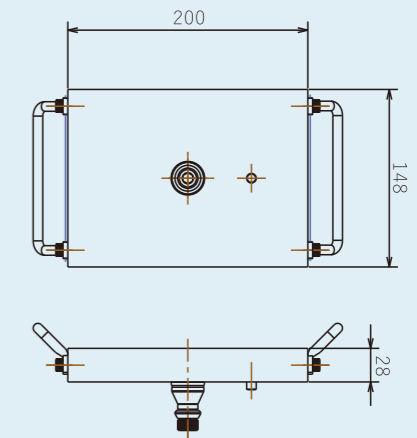
**3A-400100** 定位拉钉  
Centering spigot

- ▶ 应用 用于中心定位
- ▶ 安装 安装于托板或工件底部
- ▶ Application For center positioning
- ▶ Mounting Mounted on pallet or on the bottom of workpiece



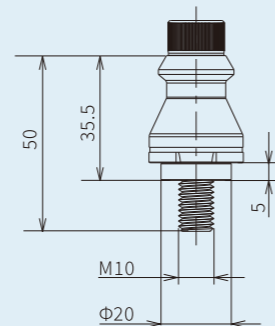
**3A-110134** 单中心零点托板  
Single center zero point tray

- ▶ 材质 铝合金
- ▶ 安装 已安装一个定位拉钉 (3A-400100) 和一个圆柱销  
非标尺寸可定制
- ▶ Material Aluminum alloy
- ▶ Mounting A positioning (3A-400100) pull pin and a cylindrical pin have been installed  
Non-standard sizes can be customized



**3A-400101** 补偿拉钉  
Compensation spigot

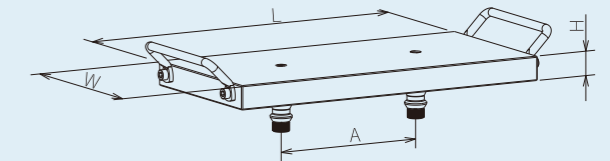
- ▶ 应用 用于角向定位
- ▶ 安装 安装于托板或工件底部
- ▶ Application For angular positioning
- ▶ Mounting Mounted on pallet or on the bottom of workpiece



两联零点托板  
2-Fold Pallet

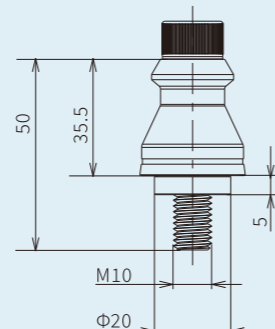
- ▶ 材质 铝合金
- ▶ 安装 1个定位拉钉, 1个补偿拉钉
- ▶ Material Aluminum alloy
- ▶ Mounting 1 centering spigot, 1 compensation spigot

编号 Model NO	A(mm) 中心距 (center distance)	L(mm)	W(mm)	H(mm)
3A-110130	150	330	160	24
3A-110131	200	380	160	28
3A-110132	250	430	160	34



**3A-400102** 夹紧拉钉  
Chucking spigot

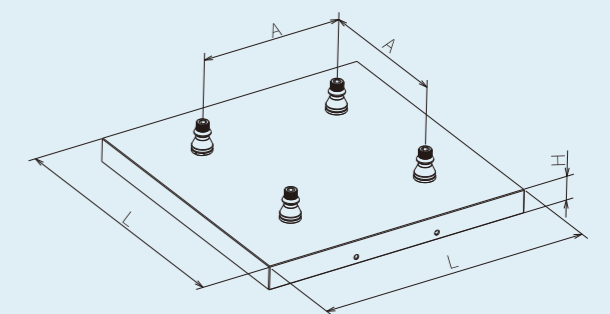
- ▶ 应用 用于辅助拉紧
- ▶ 安装 安装于托板或工件底部
- ▶ Application For auxiliary tightening
- ▶ Mounting Mounted on pallet or on the bottom of workpiece



四联零点托板  
4-Fold Pallet

- ▶ 材质 铝合金
- ▶ 安装 1个定位拉钉, 1个补偿拉钉, 2个夹紧拉钉
- ▶ Material Aluminum alloy
- ▶ Mounting 1 centering spigot, 1 compensation spigot  
2 chucking spigot

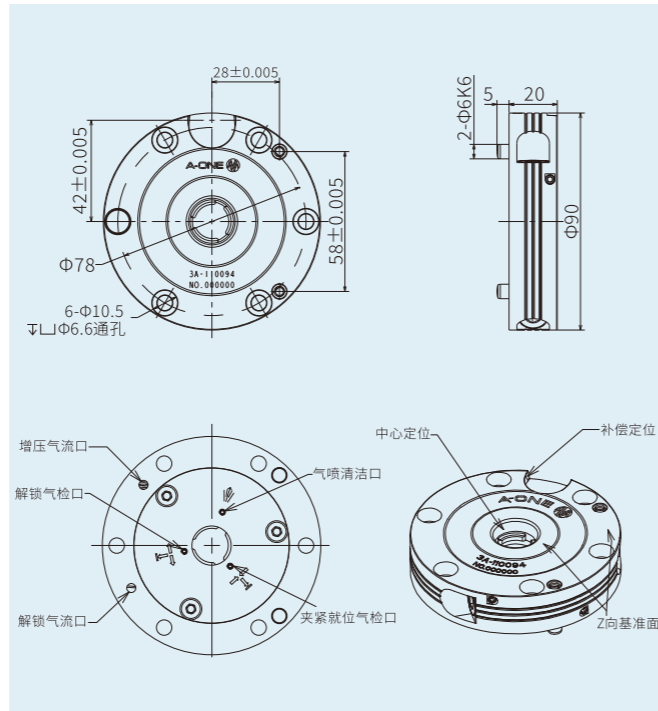
编号 Model NO	A(mm) 中心距 (center distance)	L(mm)	H(mm)
3A-110109	200	380	34
3A-110133	250	430	38





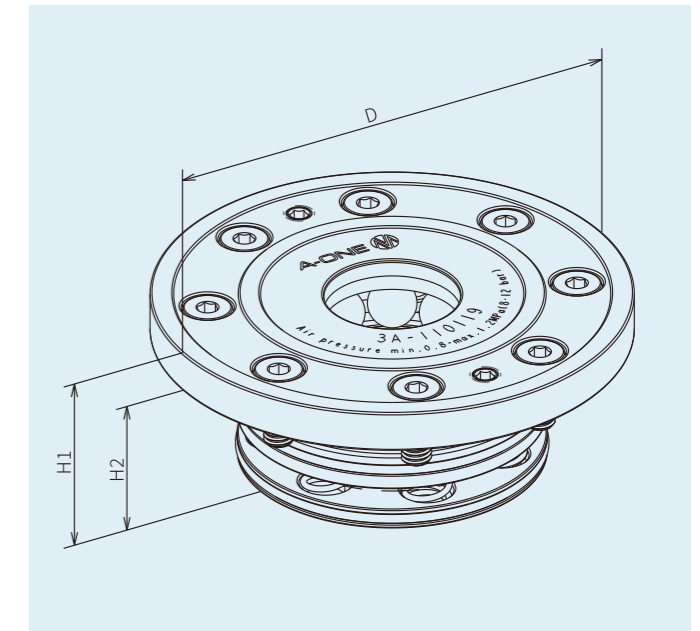
**3A-110094** 迷你超薄零点卡盘  
MINI Ultrathin zero-point chuck

- ▶ 重复定位精度 0.005mm
- ▶ 高度 20mm
- ▶ 夹紧力 增压后可达1500N
- ▶ 材质 马氏体不锈钢，耐腐蚀
- ▶ Repetition accuracy 0.05mm
- ▶ Height 20mm
- ▶ Clamping force Up to 1500N
- ▶ Material Martensitic stainless steel, corrosion-resistant



内置安装型零点卡盘  
Built-in installation type zero point system chuck

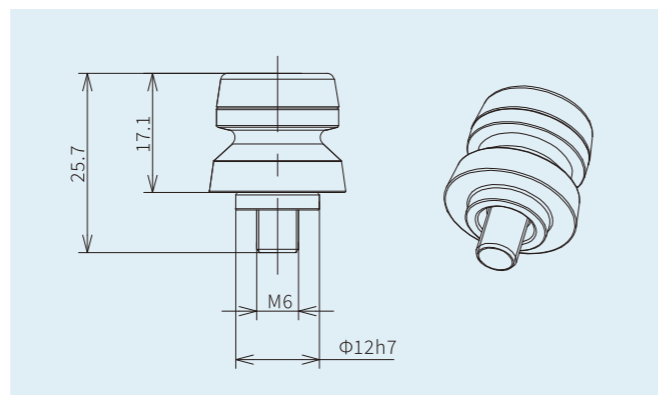
- ▶ 规格 气压解锁  
气压自动除屑  
解锁气压: 0.6MPa  
增压气压: 0.5Mpa-0.6Mpa  
表面及活塞化处理  
重复定位精度0.005mm
- ▶ 特点 内置式, 镶嵌于客户自行设计的夹具基础板
- ▶ 应用 用于减少更换工装的时间, 可在金属切削和非切削领域中使用, 也可用于食品工业、化工和制药行业中使用。
- ▶ 说明 具有夹紧力和拉紧力高的特点。通过气压解锁, 通过弹簧力进行机械锁紧。为了获得更大的夹紧力, 可提供增压气压。锁紧状态下可随时切断压力源, 因为正常锁紧不需要通压力。
- ▶ Specifications Air pressure unlock  
Air pressure automatic chip removal  
Unlocking air pressure: 0.6MPa  
Booster air pressure: 0.5Mpa-0.6Mpa  
Surface and Piston Treatment  
Repeat positioning accuracy 0.005mm
- ▶ Characteristic Built-in ,Embedded in the customer designed fixture base plate.
- ▶ Application It is used to reduce the time of changing fixtures, it can be used in metal cutting and non-cutting fields, and it can also be used in food industry, chemical industry and pharmaceutical industry.
- ▶ Explain It has the characteristics of high clamping force and tension force. Released by air pressure, mechanically locked by spring force. For greater clamping force, boost air pressure is available. In the locked state, the pressure source can be cut off at any time, because normal locking does not require pressure.



编号 Model NO	尺寸 Size	D	H1	H2	夹紧力 Clamping force	拉紧力 Tightening force	重量 Net weight
3A-110119	K10	Φ78	30	23	8000N	25000N	0.45Kg
3A-110219	K20	Φ112	44	34	17000N	55000N	1.40Kg

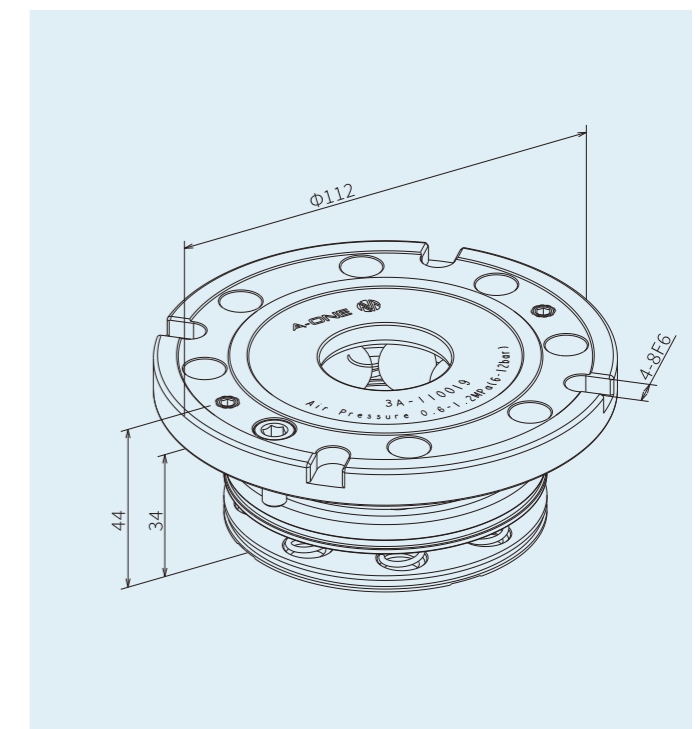
**3A-110092** 圆锥拉杆  
Taper spigot

- ▶ 应用 配合卡盘 3A-110094 使用
- ▶ Application Used with chuck 3A-110094



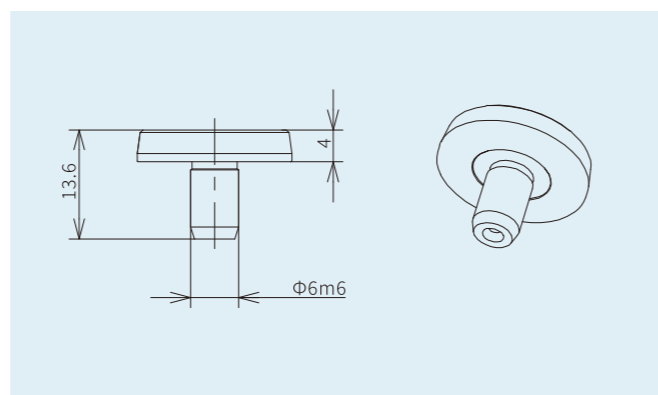
**3A-110019** 内置带止位零点定位盘  
Built-in zero-point positioning system chuck

- ▶ 规格 尺寸: K20  
气压解锁  
气压自动除屑  
解锁气压: 0.6MPa  
增压气压: 0.5Mpa-0.6Mpa  
表面及活塞硬化处理  
重复定位精度: 0.005mm
- ▶ 夹紧力 15000N
- ▶ 拉紧力 55000N
- ▶ 特点 内置式, 镶嵌于客户自行设计的夹具基础板  
止位功能可以为夹具托板提供90°的分度定位
- ▶ Specifications Size: K20  
Air pressure unlock  
Air pressure automatic chip removal  
Unlocking air pressure: 0.6MPa  
Booster air pressure: 0.5Mpa-0.6Mpa  
Surface and Piston Treatment  
Repeat positioning accuracy 0.005mm
- ▶ Clamping force 17000N
- ▶ Tightening force 55000N
- ▶ Characteristic Built-in ,Embedded in the customer designed fixture base plate.  
The stop function can provide 90° indexing positioning for the fixture pallet.



**3A-110093** 圆锥销  
Taper pin

- ▶ 应用 配合卡盘 3A-110094 使用
- ▶ Application Used with chuck 3A-110094

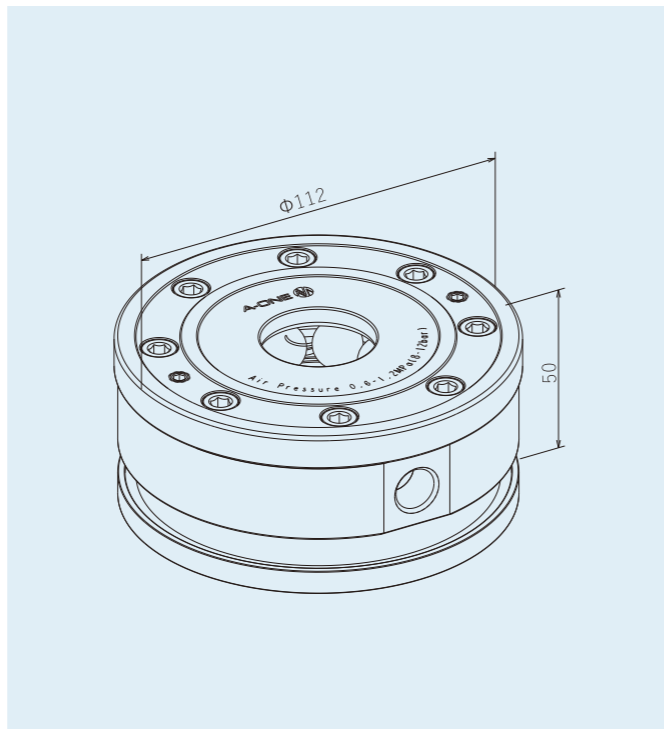




零点定位系统

**3A-110004** 外置式 20 型零点卡盘  
External 20 Type zero-point positioning system chuck

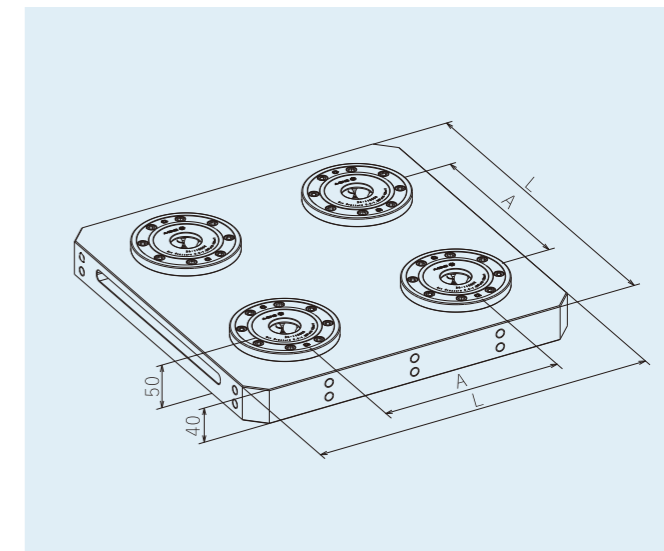
- ▶ **规格** 尺寸: K20  
气压解锁  
气压自动除屑  
解锁气压: 0.6MPa  
增压气压: 0.5Mpa-0.6Mpa  
表面及活塞硬化处理  
重复定位精度: 0.005mm  
内部机械锁紧, 配合定位拉钉使用
- ▶ **夹紧力** 17000N
- ▶ **拉紧力** 55000N
- ▶ **Specifications** Size:K20  
Air pressure unlock  
Air pressure automatic chip removal  
Unlocking air pressure: 0.6MPa  
Booster air pressure: 0.5Mpa-0.6Mpa  
Surface and Piston Treatment  
Repeat positioning accuracy 0.005mm  
Internal mechanical locking  
Use with positioning studs
- ▶ **Clamping force** 17000N
- ▶ **Tightening force** 55000N



**四中心零点卡盘**  
Centering base plate-quatro

- ▶ **规格** 基础板, 钢, 未淬硬; 可根据客户需求订做, 价格另议
- ▶ **连接** 侧面打开: 气动
- ▶ **应用** 适用于双托板, 直接安装在机床台面上
- ▶ **注意** 客户可自行配做连接孔, 钻孔时不要钻穿任何气路
- ▶ **Version** Base plate, steel, unhardened; OEM Service available, the price is negotiable
- ▶ **Connection** Lateral, to open: pneumatic
- ▶ **Application** To accommodate double pallets, mounted directly on machine table
- ▶ **Note** Attachment boreholes can be drilled by customers  
Do not drill through any air or oil ducts

编号 Model NO	L(mm)	A(mm) 中心距 (center distance)
3A-110007	380	200
3A-110034	430	250

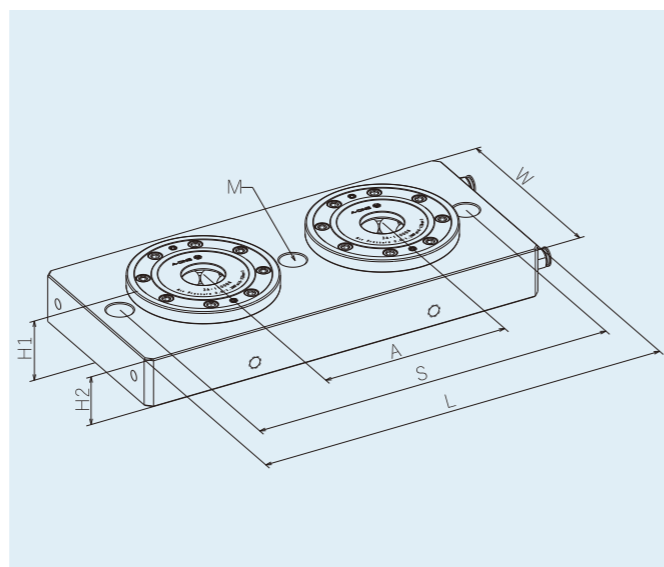


零点定位系统

零点定位系统

**两中心零点卡盘**  
Centering base plate-double

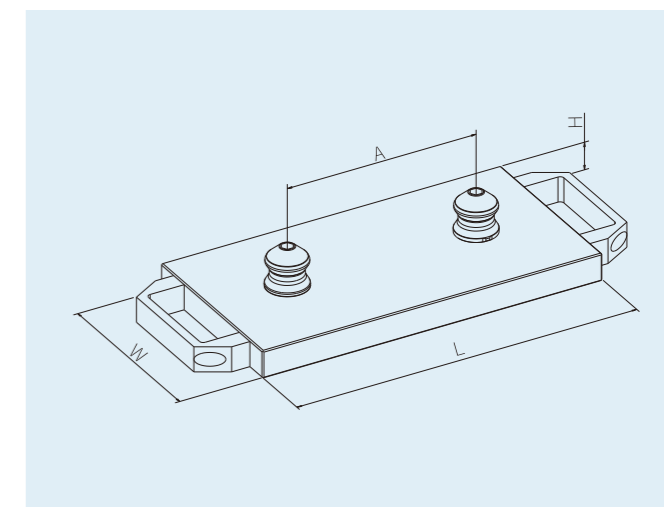
- ▶ **规格** 基础板, 钢, 未淬硬; 可根据客户需求订做, 价格另议
- ▶ **连接** 侧面打开: 气动
- ▶ **应用** 适用于双托板, 直接安装在机床台面上
- ▶ **注意** 客户可自行配做连接孔, 钻孔时不要钻穿任何气路
- ▶ **Version** Base plate, steel, unhardened; OEM Service available, the price is negotiable
- ▶ **Connection** Lateral, to open: pneumatic
- ▶ **Application** To accommodate double pallets, mounted directly on machine table
- ▶ **Note** Attachment boreholes can be drilled by customers  
Do not drill through any air or oil duct



**托板**  
Pallet

- ▶ **规格** 铝托板, 2联式, 含补偿拉钉1件, 定位拉钉1件
- ▶ **应用** 夹持工件, 虎钳和量具
- ▶ **Version** Aluminum pallet, 2-fold, including 1 compensation spigot, 1 precision pallet stopper
- ▶ **Application** To clamp workpieces, vises and gauges

编号 Model NO	A(mm) 中心距 (center distance)	L(mm)	W(mm)	H(mm)
3A-110040	150	270	140	22
3A-110042	200	320	150	25
3A-110043	250	380	180	30



零点定位系统

UPC系统

下拉圆柱夹具

基准卡盘

R型系列夹具

自定心虎钳

零点定位快锁

夹紧装置

其他夹具

夹紧装置

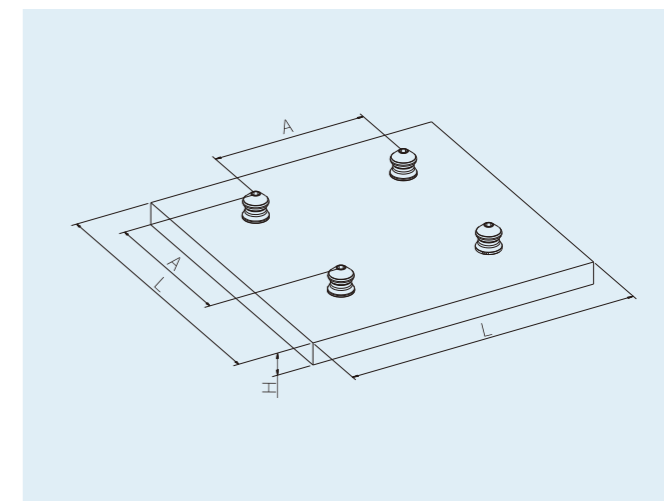
其他夹具

编号 Model NO	尺寸 Size	L(mm)	A(mm) 中心距 (center distance)	S(mm)	W(mm)	H1(mm)	H2(mm)	M
3A-110123	K10	230	100	200	100	35	28	3-Φ11通孔 └┐Φ17.5└┐10
3A-110008	K20	330	150	290	150	50	40	3-Φ13通孔 └┐Φ20└┐12
3A-110006	K20	380	200	340	150	50	40	3-Φ13通孔 └┐Φ20└┐12
3A-110032	K20	430	250	390	150	50	40	3-Φ13通孔 └┐Φ20└┐12

**托板**  
Pallet

- ▶ **规格** 铝托板, 4联式, 含补偿拉钉1件, 定位拉钉1件  
夹紧拉钉2件
- ▶ **应用** 夹持工件, 虎钳和量具
- ▶ **Version** Aluminum pallet, 4-fold, 1 compensation spigot, 1 precision pallet stopper, 2 chucking spigots
- ▶ **Application** To clamp workpieces, vises and gauges

编号 Model NO	A(mm) 中心距 (center distance)	L(mm)	H(mm)
3A-110044	200	380	30
3A-110045	250	430	30

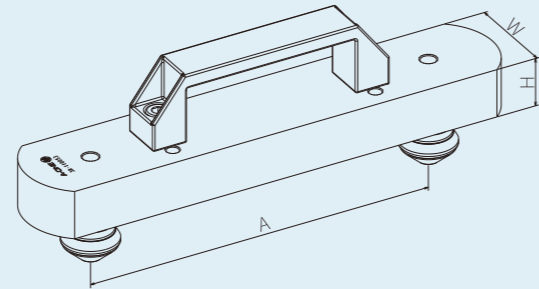




零点卡盘校正基准 W\*H-A  
Zero-point chuck Alignment datum W\*H-A

- ▶ 规格 零点卡盘角度、位置校正
- ▶ Version To adjust the angle position of Zero-point chuck

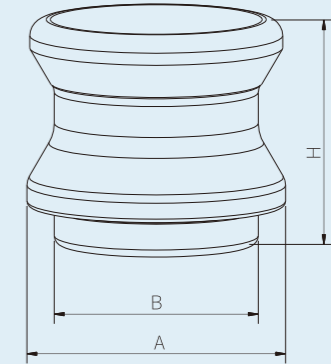
编号 Model NO	W(mm)	H(mm)	A(mm) 中心距 (center distance)
3A-110052	48	25	150
3A-110053	54	28	200
3A-110054	60	30	250



夹紧拉钉  
Clamp pallet stopper

- ▶ 规格 一个具有锁紧功能的夹紧拉钉
- ▶ 应用 用于工件/托板的自动装载/卸载  
3A-400117配合K10卡盘使用, 含3A-400114螺栓1件  
3A-400017配合K20卡盘使用, 含3A-400014螺栓1件
- ▶ Version A clamping chucking spigot with locking function
- ▶ Application For automatic loading/unloading of workpieces/pallets  
3A-400117 is used with K10 chuck, including 1 piece of bolt 3A-400114  
3A-400017 is used with K20 chuck, including 1 piece of bolt 3A-400014

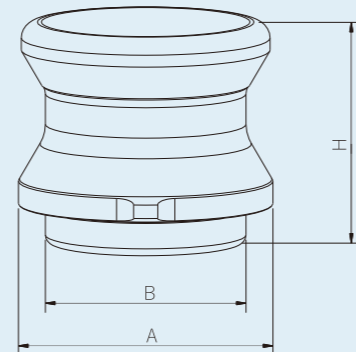
编号 Model NO	A(mm)	B(mm)	H(mm)
3A-400117	Φ21.8	Φ15	19
3A-400017	Φ31.7	Φ25	27.8



补偿拉钉  
Compensation spigot

- ▶ 规格 用螺栓锁在工件托板上, 起补偿定位作用, 需配合定位拉钉/夹紧拉钉使用。确保轴向及径向定位精度0.005mm
- ▶ 应用 3A-400115配合K10卡盘使用, 含3A-400114螺栓1件  
3A-400015配合K20卡盘使用, 含3A-400014螺栓1件
- ▶ Version To be fixed on pallets. Compensation and positioning functions. To be used with positioning fixing stopper and clamping fixing stopper. To ensure axial and radial positioning accuracy 0.005mm
- ▶ Application 3A-400115 is used with K10 chuck, including 1 piece of bolt 3A-400114  
3A-400015 is used with K20 chuck, including 1 piece of bolt 3A-400014

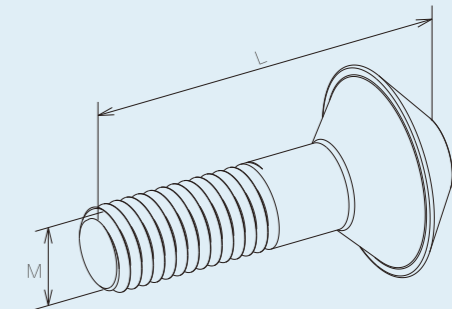
编号 Model NO	A(mm)	B(mm)	H(mm)
3A-400115	Φ21.7-Φ22	Φ15	19
3A-400015	Φ31.7-Φ32	Φ25	27.8



螺栓  
Bolt

- ▶ 规格 定位接头螺栓  
等级 10.9
- ▶ Version Positioning of the joint bolt  
Level: 10.9  
For quick positioning of built-in and built-out type zero point quick positioning holder

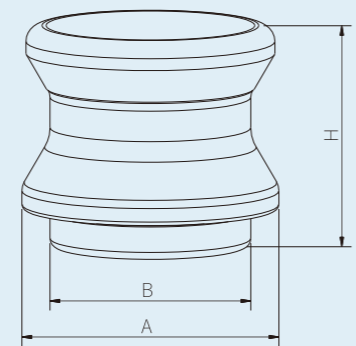
Model No	M	L	Weight(g)
3A-400014	M12	51	65
3A-400114	M8	37	20.5



定位拉钉  
Positioning pallet stopper

- ▶ 规格 一个具有定位功能的夹紧拉钉 (无定位间隙)
- ▶ 应用 用于托板的自动装载/卸载。定位拉钉决定了基准点(无定位间隙)  
3A-400116配合K10卡盘使用, 含3A-400114螺栓1件  
3A-400016配合K20卡盘使用, 含3A-400014螺栓1件
- ▶ Version A clamping chucking spigot with positioning function (no positioning gap)
- ▶ Application Used for automatic loading/unloading of pallets, positioning chucking spigot determine the reference point (no positioning gap)  
3A-400116 is used with K10 chuck, including 1 piece of bolt 3A-400114  
3A-400016 is used with K20 chuck, including 1 piece of bolt 3A-400014

编号 Model NO	A(mm)	B(mm)	H(mm)
3A-400116	Φ22	Φ15	19
3A-400016	Φ32	Φ25	27.8

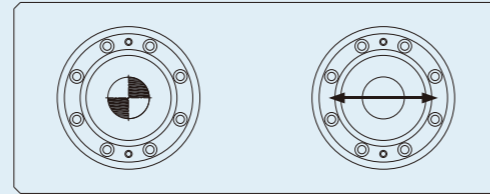




夹紧拉钉套装(2件套)  
Chuckling spigot set 2

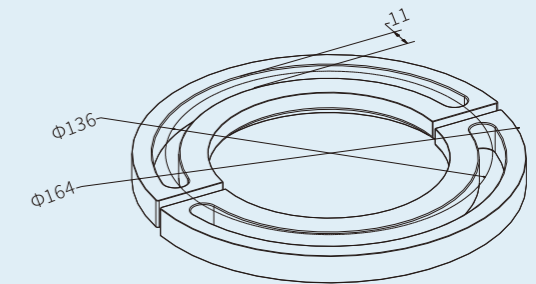
- ▶ 规格 1个定位拉钉, 1个补偿拉钉
- ▶ 安装 用所提供的螺栓穿过托板或夹紧拉钉
- ▶ Version 1 centering spigot, 1 compensation spigot
- ▶ Mounting With the supplied bolts through the pallet or through the chucking spigot

尺寸 Size	编号 Model No	适配两中心卡盘 Adapt to two center chucks
K10	3A-400118	3A-100123
K20	3A-400049	3A-110006
		3A-110008
		3A-110032



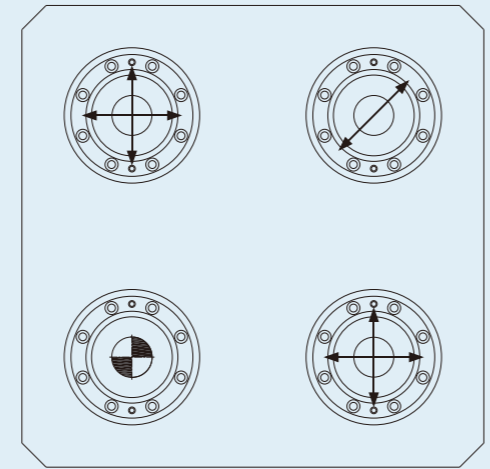
3A-400018 环形压板  
Round clamp

- ▶ 规格 环形压板二件一套
- ▶ 应用 用于安装 3A-110004
- ▶ Version 2 pcs/set
- ▶ Application To be used with 3A-110004



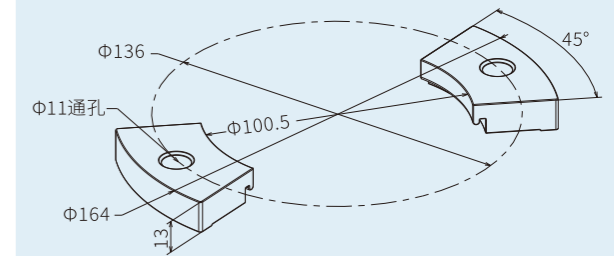
3A-400050 夹紧拉钉套装 (4件套)  
Chuckling spigot set 4

- ▶ 规格 1个定位拉钉, 1个补偿拉钉, 2个夹紧拉钉
- ▶ 应用 用所提供的螺栓穿过托板或夹紧拉钉
- ▶ Version 1 centering spigot, 1 compensation spigot, 2 chucking spigots
- ▶ Application With the supplied bolts through the pallet or through the chucking spigot



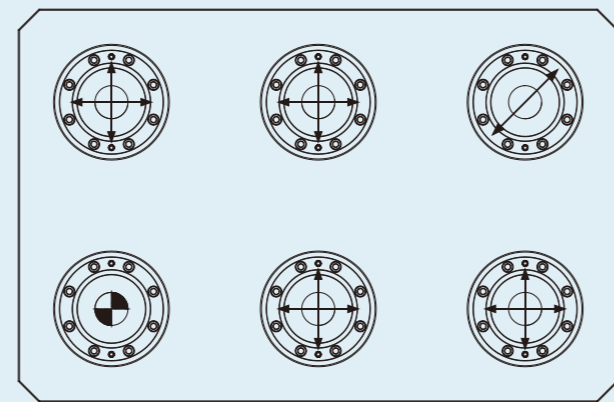
3A-400019 扇形压板  
Angle clamp

- ▶ 规格 一套两件, 结构简单, 占空间小
- ▶ 应用 用于安装 3A-110004, 非重切削
- ▶ Version 2 pcs/set . Simple design with minimum space
- ▶ Application To be used with 3A-110004. For non heavy cutting



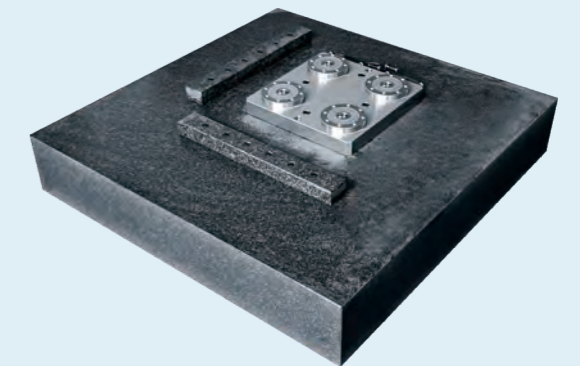
3A-400053 夹紧拉钉套装(6件套)  
Chuckling spigot set 6

- ▶ 规格 1个定位拉钉, 1个补偿拉钉, 4个夹紧拉钉
- ▶ 安装 用所提供的螺栓穿过托板或夹紧拉钉
- ▶ Version 1 centering spigot, 1 compensation spigot, 4 chucking spigots
- ▶ Mounting With the supplied bolts through the pallet or through the chucking spigot



零点预调台 Zero point presetting station

- ▶ 材质: 济南青
- ▶ 根据客户需求订做
- ▶ Station material: Cyanogen
- ▶ Customized according to customer needs



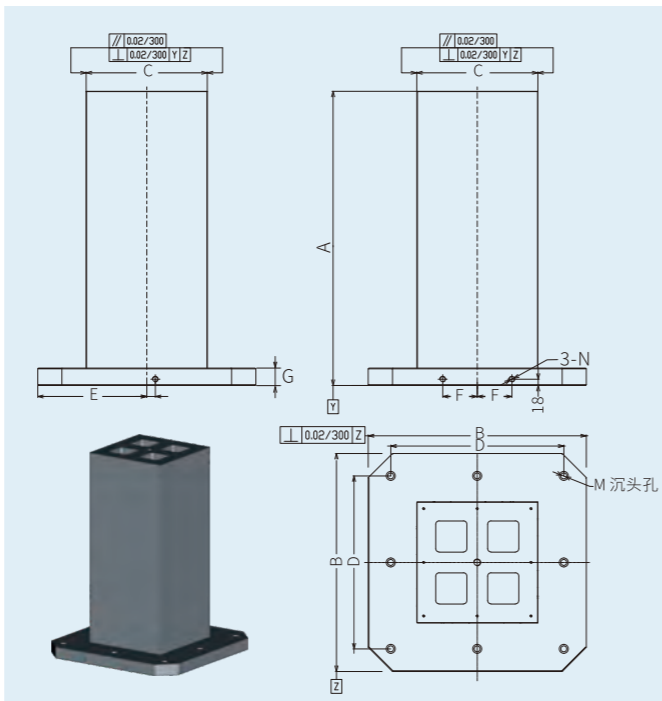


**3A-130001** MC四面基座  
MC square tooling column

- ▶ 材质 FC30
- ▶ 热处理 烧钝
- ▶ 用途 适用于卧式MC
- ▶ 特点 可依实际需要，自行钻孔加工制作专用治具

- ▶ Block material FC30
- ▶ Heat treatment Bright Annealing
- ▶ Function Suitable for horizontal machining centre
- ▶ Features According to actual needs, you can make special fixtures by drilling and processing by yourself

MODEL NO.	A	B	C	D	E	F	G	M	N	Mounting holes	kg
3A-130001-300300-0500	500	300	150	250	150	40	50	M12	M12	4	96
3A-130001-400400-0500	500	400	250	320	200	55	50	M16	M16	4	153
3A-130001-400400-0650	650	400	250	320	200	55	50	M16	M16	4	218
3A-130001-500500-0600	600	500	300	400	250	75	50	M16	M16	8	250
3A-130001-500500-0750	750	500	300	400	250	75	50	M16	M16	8	335
3A-130001-630630-0700	700	630	350	500	315	100	50	M16	M16	8	361
3A-130001-630630-0850	850	630	350	500	315	100	50	M16	M16	8	496
3A-130001-800800-0800	800	800	500	640	400	135	50	M16	M16	8	700
3A-130001-800800-1000	1000	800	500	640	400	135	50	M16	M16	8	859



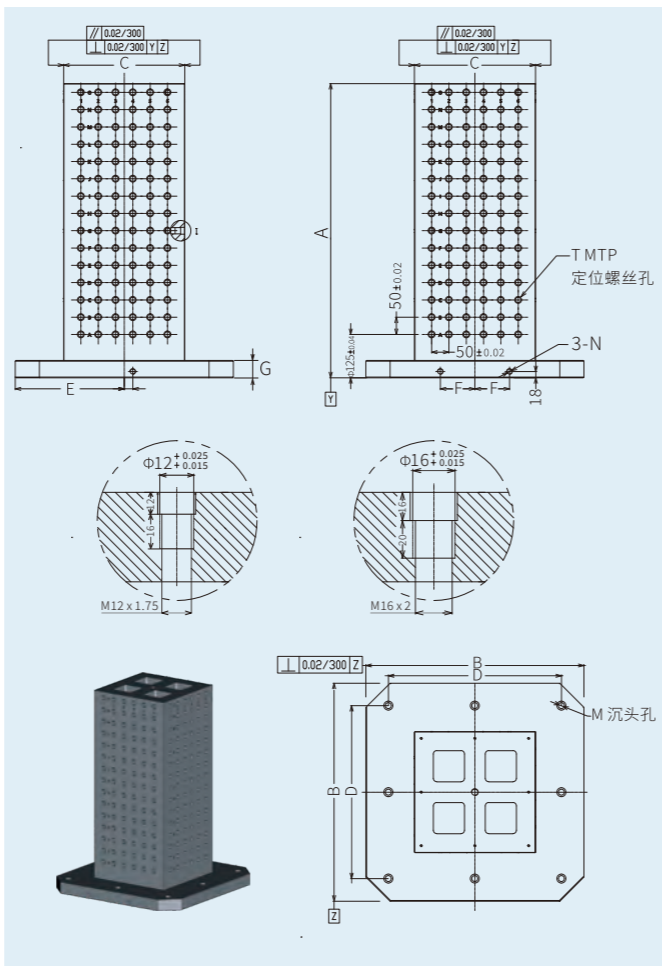
**3A-130002** MC四面基座  
MC square tooling column

- ▶ 材质 FC30
- ▶ 热处理 烧钝
- ▶ 用途 适用于卧式MC
- ▶ 特点 以孔定位方式，利用标准化治具零件可快速组立完成一套符合需求的治具

- ▶ Block material FC30
- ▶ Heat treatment Bright Annealing
- ▶ Function Suitable for horizontal machining centre
- ▶ Features By hole positioning, using standardized fixture parts A set of fixtures that meet your needs can be quickly assembled

MODEL NO.	A	B	C	D	E	F	G	T	M	N	MTP	Mounting holes	kg	
3A-130002-300300-0500-12	500	300	150	250	150	40	50	Φ12	M12	M12	M12	64	4	96
3A-130002-400400-0500-12	500	400	250	320	200	55	50	Φ12	M12	M16	M16	128	4	149
3A-130002-400400-0650-12	650	400	250	320	200	55	50	Φ12	M12	M16	M16	176	4	218
3A-130002-500500-0600-12	600	500	300	400	250	75	50	Φ12	M12	M16	M16	200	8	243
3A-130002-500500-0750-12	750	500	300	400	250	75	50	Φ12	M12	M16	M16	260	8	335
3A-130002-630630-0700-12	700	630	350	500	315	100	50	Φ12	M12	M16	M16	288	8	360
3A-130002-630630-0850-12	850	630	350	500	315	100	50	Φ12	M12	M16	M16	360	8	496
3A-130002-800800-0800-12	800	800	500	640	400	135	50	Φ12	M12	M16	M16	504	8	635
3A-130002-800800-1000-12	1000	800	500	640	400	135	50	Φ12	M12	M16	M16	648	8	859

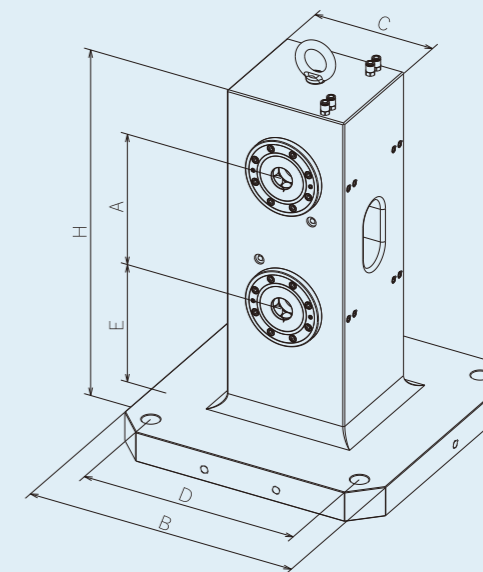
MODEL NO.	A	B	C	D	E	F	G	T	M	N	MTP	Mounting holes	kg	
3A-130002-300300-0500-16	500	300	150	250	150	40	50	Φ16	M16	M12	M12	64	4	96
3A-130002-300300-0500-16	500	400	250	320	200	55	50	Φ16	M16	M16	M16	128	4	148
3A-130002-300300-0500-16	650	400	250	320	200	55	50	Φ16	M16	M16	M16	176	4	218
3A-130002-300300-0500-16	600	500	300	400	250	75	50	Φ16	M16	M16	M16	200	8	234
3A-130002-300300-0500-16	750	500	300	400	250	75	50	Φ16	M16	M16	M16	260	8	335
3A-130002-300300-0500-16	700	630	350	500	315	100	50	Φ16	M16	M16	M16	288	8	360
3A-130002-300300-0500-16	850	630	350	500	315	100	50	Φ16	M16	M16	M16	360	8	496
3A-130002-300300-0500-16	800	800	500	640	400	135	50	Φ16	M16	M16	M16	504	8	655
3A-130002-300300-0500-16	1000	800	500	640	400	135	50	Φ16	M16	M16	M16	648	8	859



**3A-110082** MC双面零点基座  
MC double-side zeropoint base block

- ▶ 规格 单个卡盘解锁气压: 0.6MPa  
单个卡盘增压后夹紧力可达17000N  
重复定位精度小于0.005mm  
基座材质: FC30
- ▶ 热处理 烧钝
- ▶ 用途 适用于卧式MC
- ▶ 特点 双面零位, 夹具/工件快速换装, 标准化接口, 生产更灵活, 多品种、少批量、大批量生产均适合  
可按客户机台及要求定制

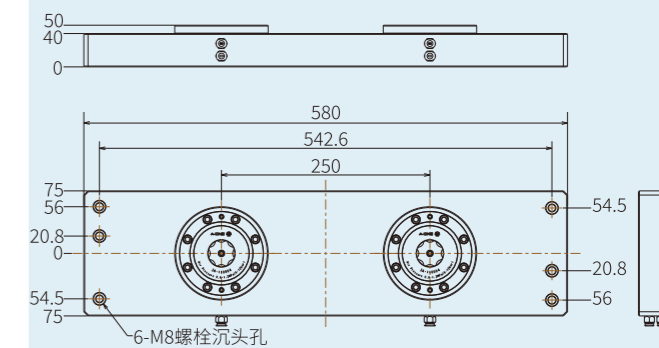
- ▶ Version Single chuck unlocking air pressure: 0.6 MPa  
The clamping force of a single chuck can up to 17000N after pressurization  
Repeat positioning accuracy is less than 0.005mm
- ▶ Block material Block material:FC30
- ▶ Heat treatment Bright Annealing
- ▶ Function Suitable for horizontal machining centre
- ▶ Features Zero-point chuck integrated on both sides;quick-change of fixtures or Workpiece; standard interface, makes the production process much easier  
Suitable for producing various products in large or small  
Can be customized according to customer's machine table



**3A-1000818** 两联桥板零点卡盘  
Zero point chuck for two-link bridge

- ▶ 规格 基础板, 钢, 未淬硬;  
单个卡盘解锁气压: 0.6MPa  
单个卡盘增压后夹紧力可达17000N  
重复定位精度小于0.005mm
- ▶ 连接 侧面打开: 气动
- ▶ 应用 两联桥板零点卡盘安装在四轴上
- ▶ 注意 可按客户机台及要求定制

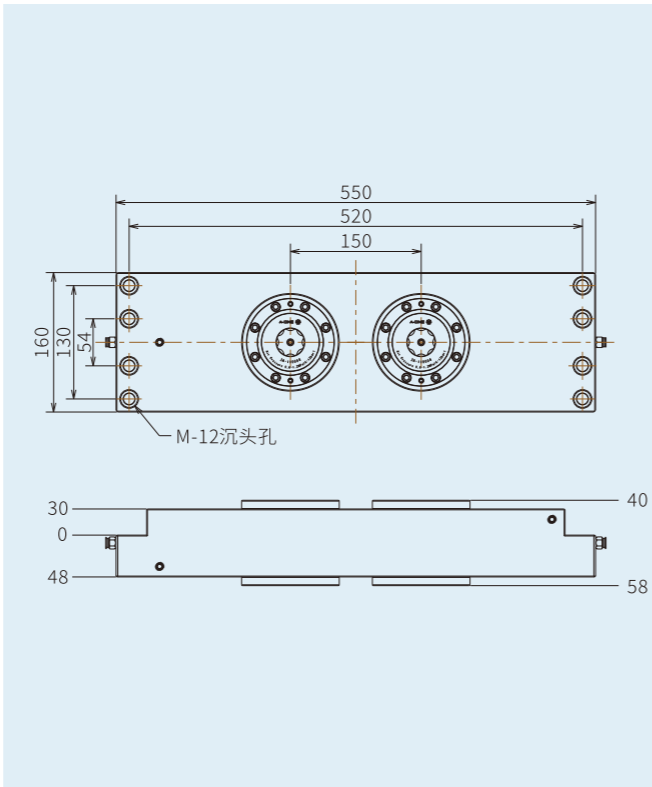
- ▶ Version Base plate, steel, unhardened  
Single chuck unlocking air pressure: 0.6 MPa  
The clamping force of a single chuck can up to 17000N after pressurization  
Repeat positioning accuracy is less than 0.005mm
- ▶ Connection Side open: pneumatic
- ▶ Application The Zero point chuck for two-link bridge is installed on the four-axis
- ▶ Note Customizable





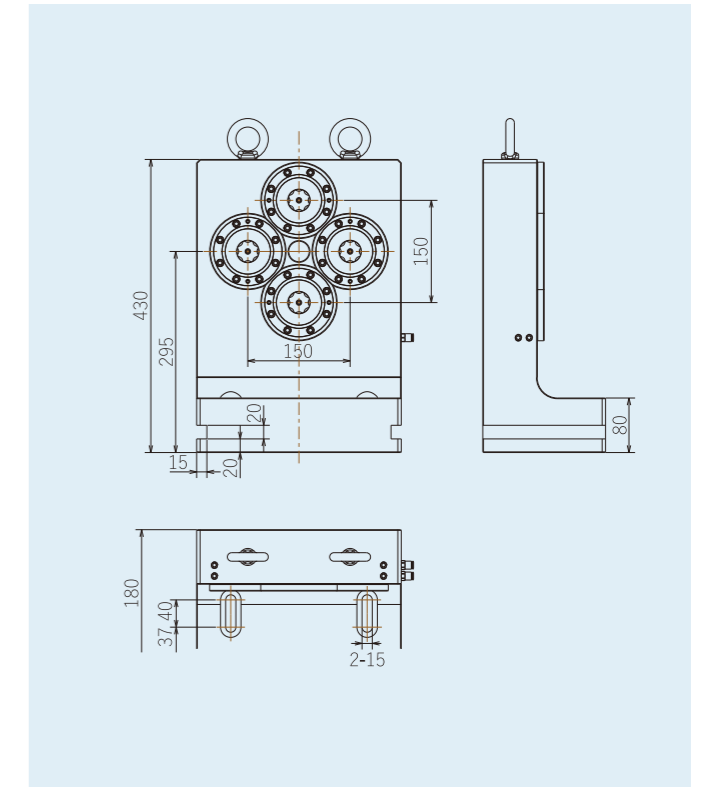
**3A-1000824** 双面桥板零点卡盘  
Double-sided bridge zero point chuck

- ▶ 规格 基础板, 钢, 未淬硬;  
单个卡盘解锁气压: 0.6MPa  
单个卡盘增压后夹紧力可达17000N  
重复定位精度小于0.005mm
- ▶ 连接 侧面打开: 气动
- ▶ 应用 双面桥板零点卡盘安装在四轴上
- ▶ 特点 双面零点桥板可配置两个托板进行加工  
添加工位提高效率
- ▶ 注意 可按客户机台及要求定制
- ▶ Version Base plate, steel, unhardened  
Single chuck unlocking air pressure: 0.6 MPa  
The clamping force of a single chuck can up to 17000N after pressurization  
Repeat positioning accuracy is less than 0.005mm
- ▶ Connection Side open: pneumatic
- ▶ Application The double-sided zero-point chuck is installed on the four-axis
- ▶ Characteristic The double-sided zero-point bridge can be configured with two pallets for processing, increasing the number of workstations and improving efficiency
- ▶ Note Customizable



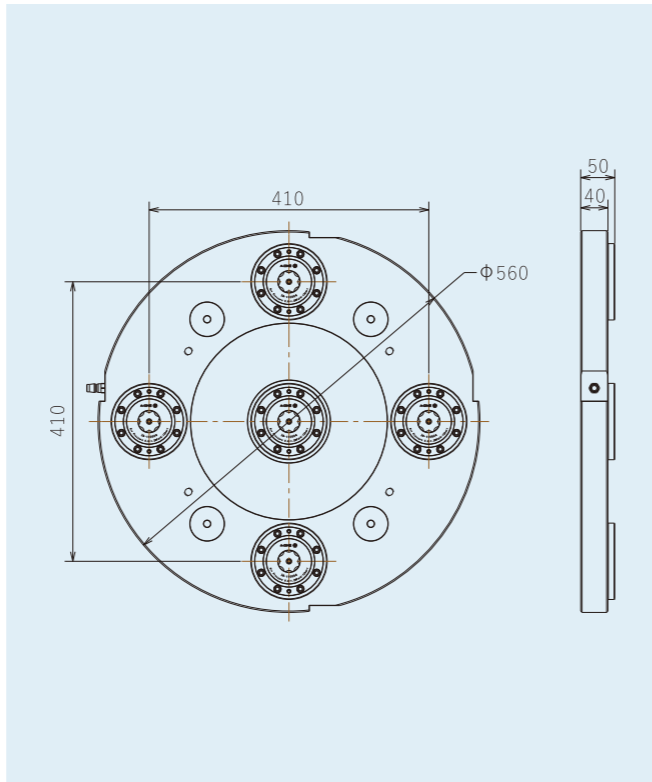
**3A-1000154** 零点直角座  
Zero point square block

- ▶ 规格 基础板, 钢, 未淬硬;  
单个卡盘解锁气压: 0.6MPa  
单个卡盘增压后夹紧力可达17000N  
重复定位精度小于0.005mm
- ▶ 连接 侧面打开: 气动
- ▶ 应用 适用于双托板, 直接安装在机床台面上
- ▶ 注意 可按客户机台及要求定制
- ▶ Version Base plate, steel, unhardened  
Single chuck unlocking air pressure: 0.6 MPa  
The clamping force of a single chuck can up to 17000N after pressurization  
Repeat positioning accuracy is less than 0.005mm
- ▶ Connection Side open: pneumatic
- ▶ Application Suitable for double pallets, directly installed on the machine table
- ▶ Note Customizable



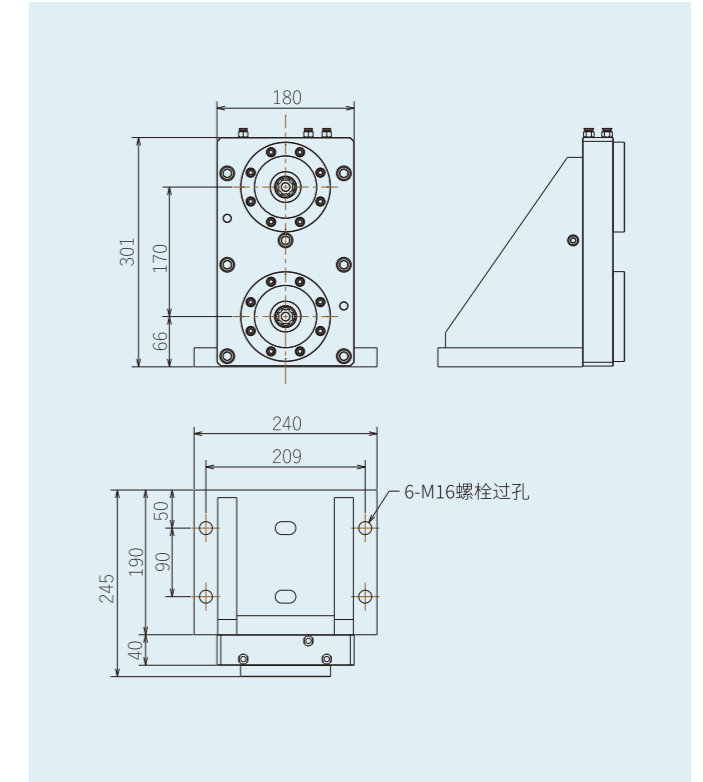
**3A-1000887** 五联零点卡盘  
Five joint zero point chuck

- ▶ 规格 基础板, 钢, 未淬硬;  
单个卡盘解锁气压: 0.6MPa  
单个卡盘增压后夹紧力可达17000N  
重复定位精度小于0.005mm
- ▶ 连接 侧面打开: 气动
- ▶ 应用 适用于双托板, 直接安装在机床台面上
- ▶ 注意 可按客户机台及要求定制
- ▶ Version Base plate, steel, unhardened  
Single chuck unlocking air pressure: 0.6 MPa  
The clamping force of a single chuck can up to 17000N after pressurization  
Repeat positioning accuracy is less than 0.005mm
- ▶ Connection Side open: pneumatic
- ▶ Application Suitable for double pallets, directly installed on the machine table
- ▶ Note Customizable



**3A-1000891** 两联零点直角卡盘  
Zero-point square chuck-double

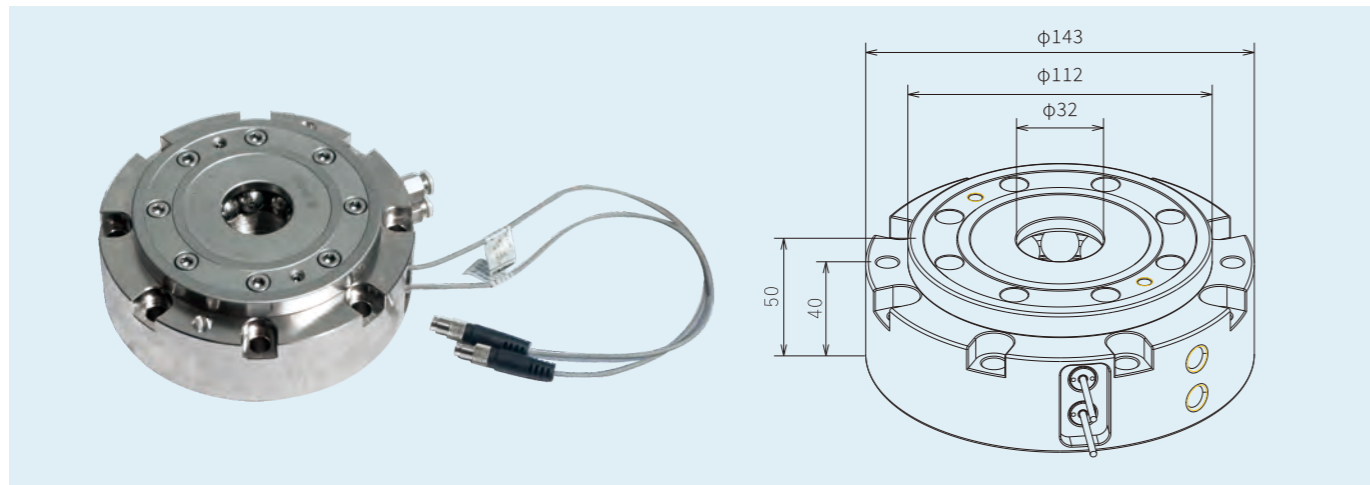
- ▶ 规格 基础板, 钢, 未淬硬;  
单个卡盘解锁气压: 0.6MPa  
单个卡盘增压后夹紧力可达17000N  
重复定位精度小于0.005mm
- ▶ 连接 侧面打开: 气动
- ▶ 应用 适用于双托板, 直接安装在机床台面上
- ▶ 注意 可按客户机台及要求定制
- ▶ Version Base plate, steel, unhardened  
Base plate, steel, unhardened  
Single chuck unlocking air pressure: 0.6 MPa  
The clamping force of a single chuck can up to 17000N after pressurization  
Repeat positioning accuracy is less than 0.005mm
- ▶ Connection Side open: pneumatic
- ▶ Application Suitable for double pallets, directly installed on the machine table
- ▶ Note Customizable





3A-110114

带传感器零点卡盘  
Zero point chuck with sensor



- |          |  |                          |  |
|----------|--|--------------------------|--|
| ▶ 气压解锁   | 解锁气压: 最小0.8Mpa-1.2Mpa<br>增压气压: 最小0.5Mpa-0.6Mpa | ▶ Air pressure unlocking | Unlocking air pressure: Min 0.8Mpa-1.2Mpa<br>Boost pressure: Min 0.5Mpa-0.6Mpa |
| ▶ 特点     | 表面及活塞硬化处理                                      | ▶ Features               | Hardened surface and piston  |
| ▶ 重复定位精度 | 小于0.005mm                                      | ▶ Resetting accuracy     | less than 0.005mm  |

**应用领域**  
Application

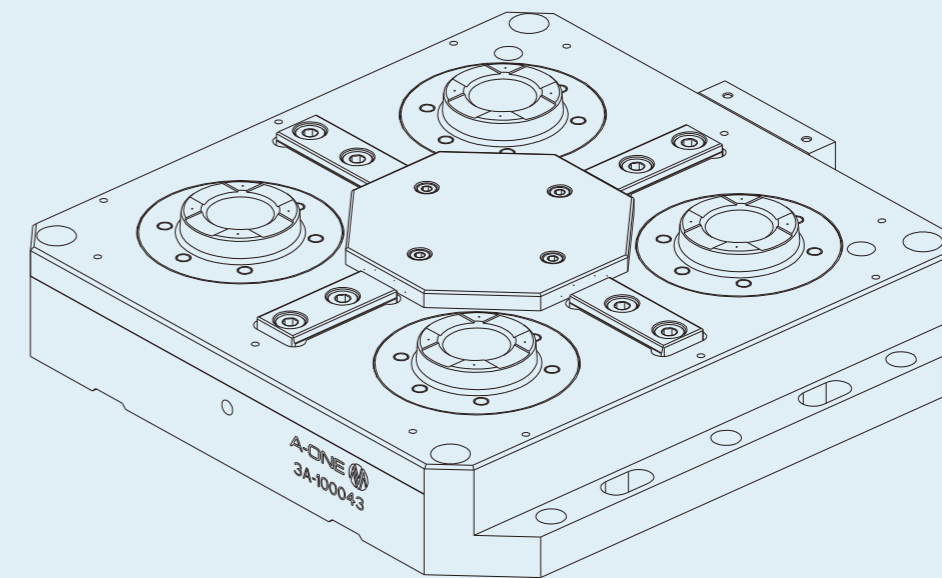
- 零点定位系统在自动化解决方案中应用, 可减少更换工装的时间, 可在金属切削和非切削领域中使用, 也可用于食品工业, 化工和制药中使用。  
The zero point positioning system is used in automation solutions, which can reduce the time of tool replacement. It can be used in metal cutting and non-cutting fields, and can also be used in the food industry, chemical industry and pharmaceuticals.

**说明**  
Explanation

- 带传感器内置安装型零点定位器包括两个感应状态(打开/锁紧)的传感器, 通过气压解锁, 通过弹簧力进行机械锁紧。为了获得更大的夹紧力, 可提供增压气压。锁紧状态下可随时切断压力源, 因为正常锁紧时不需要通压力。需要时候建议使用气压增压泵。这种零点定位器有两个接口: 气压解锁接口、气压增压接口。  
The zero-point locator with a built-in sensor includes two sensors in the sensing state (open/locked), unlocked by air pressure, and mechanically locked by spring force. In order to obtain greater clamping force, pressurized air pressure can be provided. The pressure source can be cut off at any time in the locked state, because normal locking does not require pressure. It is recommended to use a pneumatic booster pump when needed.  
This kind of zero-point locator has two interfaces: air pressure unlock interface and air pressure boost interface.

# UPC系统

## UPC system



P.031~P.036



UPC系统

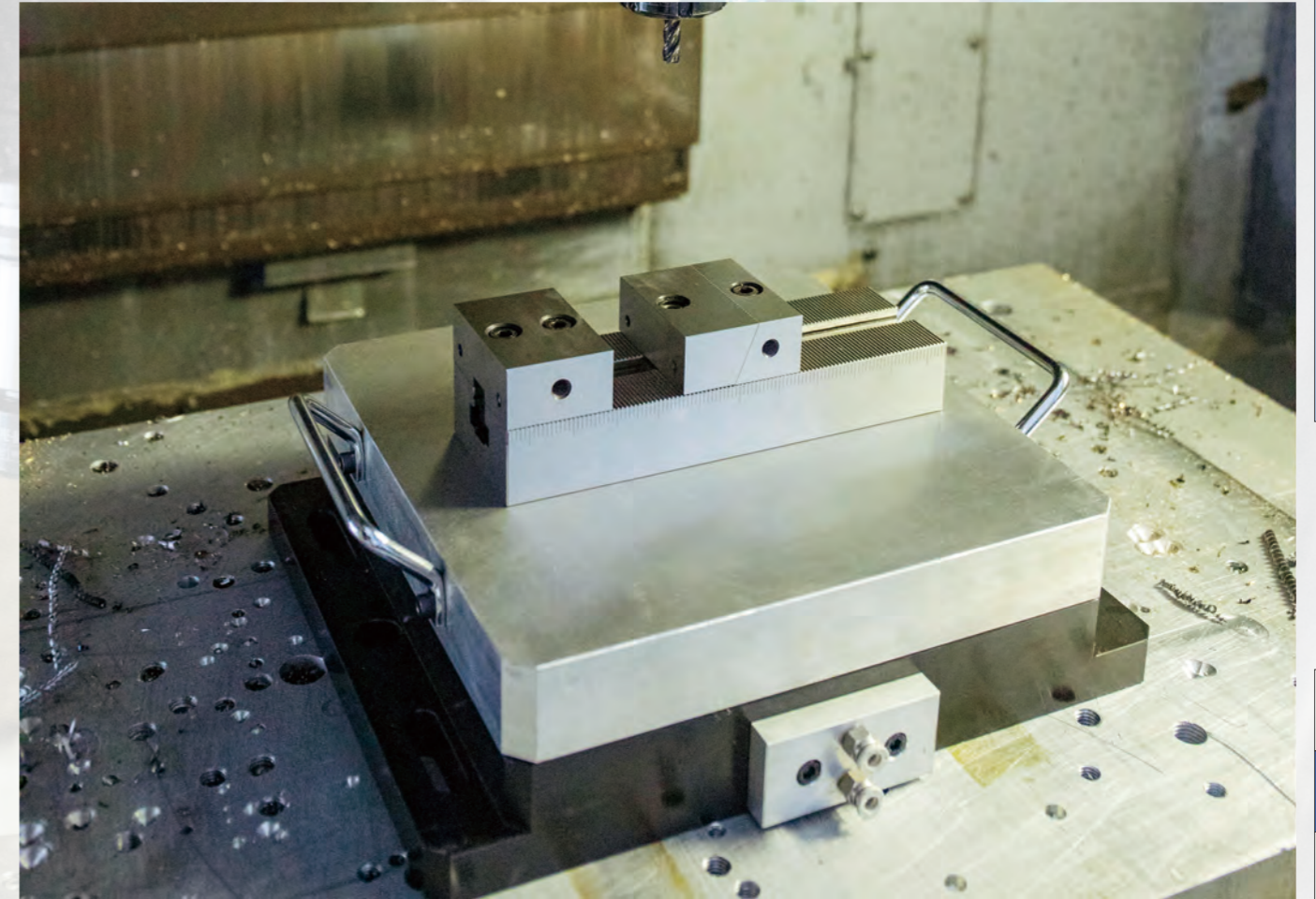


▲ 机床台面上的UPC可作为接口, 连接工件托板载体, 换装无需费时, 可立即完成, 这样保持生产的连续性



◀ UPC托板上的多重装夹

UPC系统



零点定位系统

UPC系统

下拉圆柱夹具

基准卡盘

R型系列夹具

自定心虎钳

零点定位快锁

夹紧装置

其他夹具



▲ 可根据不同加工工件匹配各种装夹工具, 应用广泛, 灵活多样

零点定位系统

UPC系统

下拉圆柱夹具

基准卡盘

R型系列夹具

自定心虎钳

零点定位快锁

夹紧装置

其他夹具

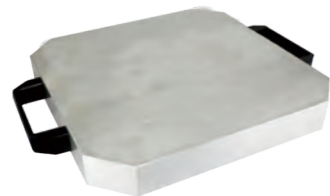


▲ UPC可作为机床和检测的基准接口, 实现快速换装, 保证生产的连续性

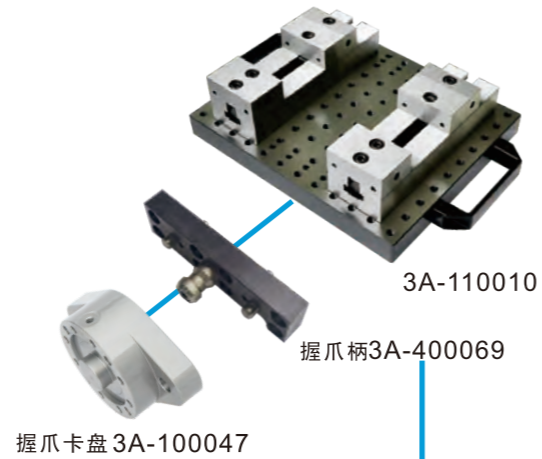




3A-100045



3A-100044



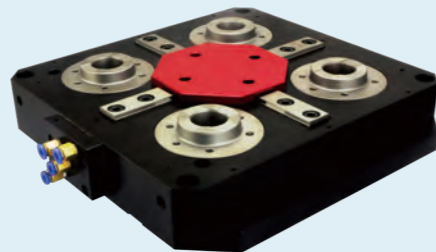
3A-110010

握爪卡盘 3A-100047

握爪柄 3A-400069



3A-100046



3A-100043

**3A-100043** UPC P 卡盘 (生产型)  
UPC P Chuck (production)

- ▶ 规格 用于强力切削加工的卡盘  
解锁气压 0.6MPa  
重复定位精度 0.002mm
- ▶ 连接 底部、侧面进气
- ▶ 应用 铣削、磨削、钻削、及生产线
- ▶ 夹紧力 32000N
- ▶ Version Chuck for high machining forces during chip removal  
Unlocking air pressure: 0.6MPa  
Repeat positioning accuracy 0.002mm
- ▶ Connection From the bottom, side intake
- ▶ Application On milling, grinding, and drilling centers and in production lines
- ▶ Clamping force 32000N

**3A-100044** UPC 托板 铝 320 x 320 x 40mm  
UPC Pallet 320 x 320 x 40mm

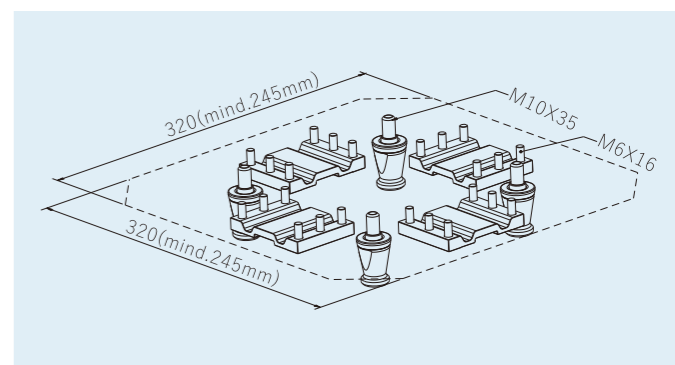
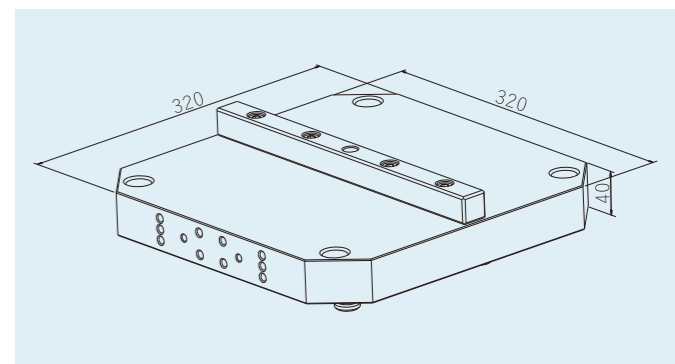
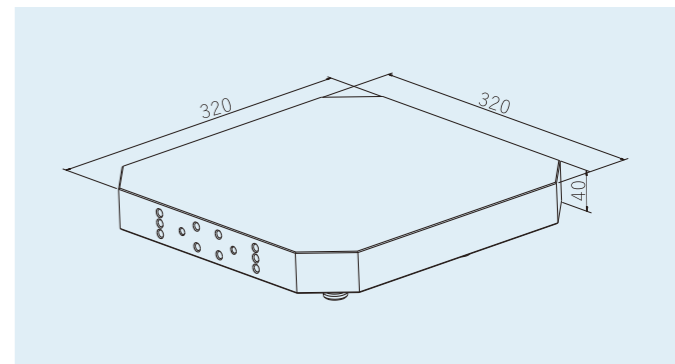
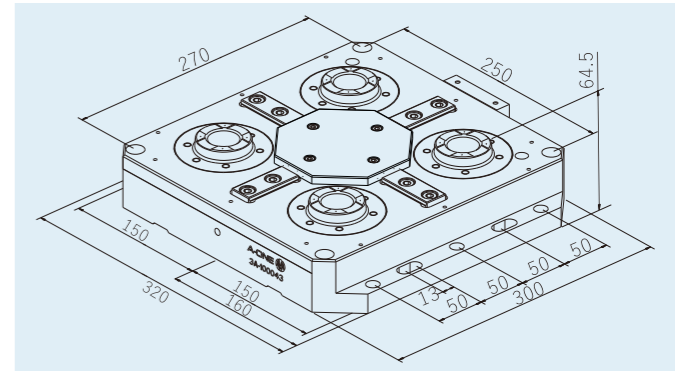
- ▶ 规格 铝质, 装有定位元件和夹紧拉钉。硬质 Z 支撑
- ▶ 应用 夹持工件及量具
- ▶ 注意 按需要钻孔
- ▶ Version Aluminum, centering segments and chucking spigots fitted. Hand Z-support
- ▶ Application To clamp workpieces and gauges
- ▶ Note Holes to be drilled as required

**3A-100045** UPC 校正托板 320 x 320 x 40mm  
Alignment pallet version UPC pallet with ground rail 320 x 320 x 40mm

- ▶ 应用 校正UPC卡盘的角度位置和定义UPC卡盘中心
- ▶ 注意 系统平行度 < 0.005 mm, 中心孔同心度 < 0.005 mm
- ▶ Application To align angular position and to determine the center of UPC chucks
- ▶ Note System parallelism < 0.005 mm  
Borehole concentricity < 0.005 mm

**3A-100046** UPC 定位元件 (U) 和夹紧拉钉  
UPC centering segments (U) and chucking spigots

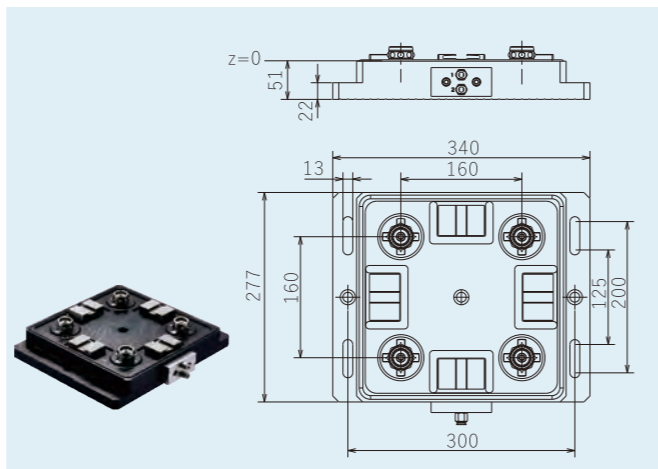
- ▶ 规格 用于UPC的4个定位元件和夹紧拉钉, 包括螺钉
- ▶ 应用 用于生产特制的UPC托板
- ▶ 安装 用螺钉从托板底面固定
- ▶ 注意 在UPC预调基座上容易安装
- ▶ Version Four segments and chucking spigots for UPC, including bolts
- ▶ Application To produce special UPC pallets.
- ▶ Mounting With bolts through the pallet from bottom
- ▶ Note Easy to assemble on the PreSet Basic UPC presetting station





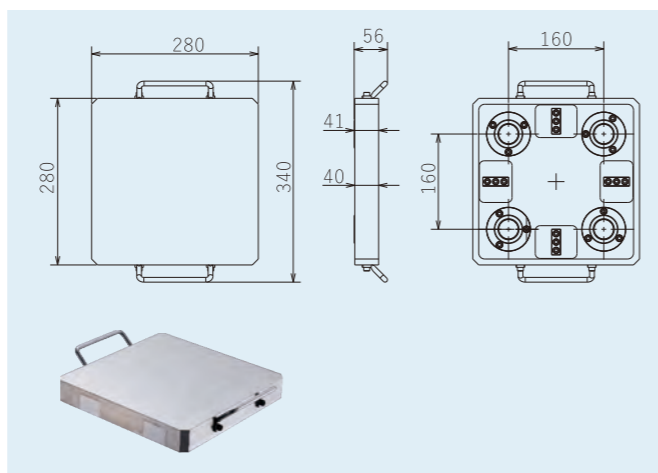
**3A-110096** 自动基准卡盘R  
R auto benchmark chuck

- ▶ 应用 适用于机床工作台
- ▶ 所需气压 0.55-0.75MPa
- ▶ 分度 固定4\*90°
- ▶ 夹紧力 60000N
- ▶ 重复定位精度 0.002mm
- ▶ 气喷清理 Z基准面
- ▶ Application Suitable for machine table
- ▶ Air pressure 0.55Mpa-0.7Mpa
- ▶ Index Fixed 4\*90°
- ▶ Clamping power 60000N
- ▶ Repeatability 0.002mm
- ▶ Air cleaning Z datum



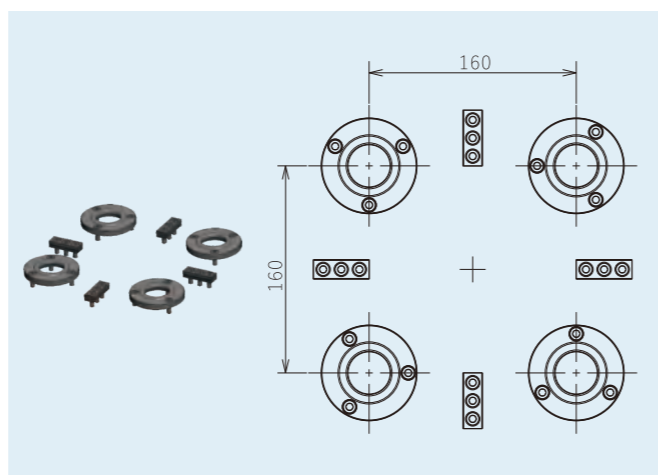
**3A-110097** 280x280铝托盘  
Aluminum pallet 280x280

- ▶ 应用 适用于手动更换
- ▶ 材质 铝制托盘
- ▶ 平面度 预制基准元件 0.02mm
- ▶ 厚度公差 ±0.2
- ▶ 注意 标准产品表面未做阳极氧化, 如有需求, 另行注明



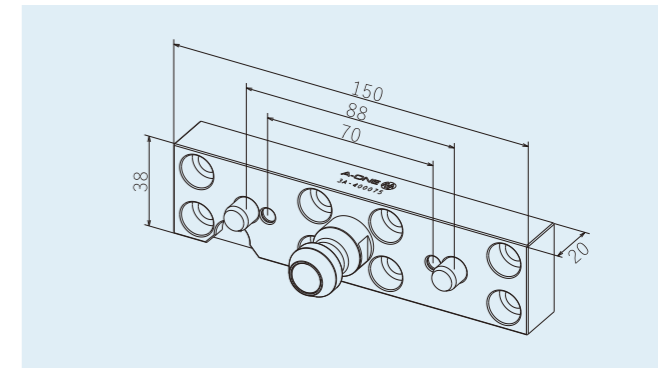
**3A-110098** 基准元件套装  
Reference component Kit

- ▶ 说明 基准元件套装
- ▶ 提供给自己制造托盘或夹具的用户
- ▶ 注意 购买时请向我司索取安装说明
- ▶ Description Reference component Kit
- ▶ For users who want to make their own pallets or fixtures
- ▶ Note Please ask us for installation instructions when purchasing



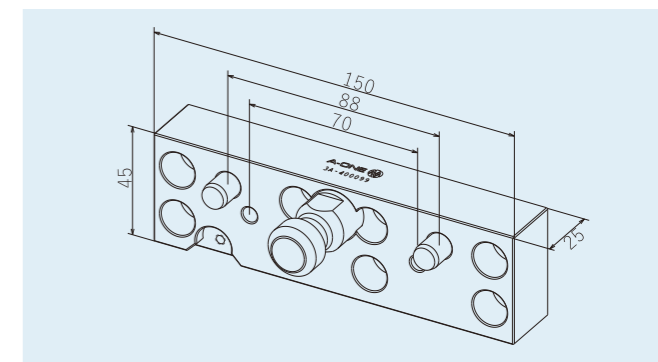
**3A-400075** 握爪柄  
Gripper link

- ▶ 规格 UPC铝托板连接柄, 包括安装附件
- ▶ 应用 适用于UPC铝托板搬运
- ▶ Version The connecting handle of UPC aluminum pallet, including mounting accessories
- ▶ Application Suitable for UPC aluminum pallet handling device



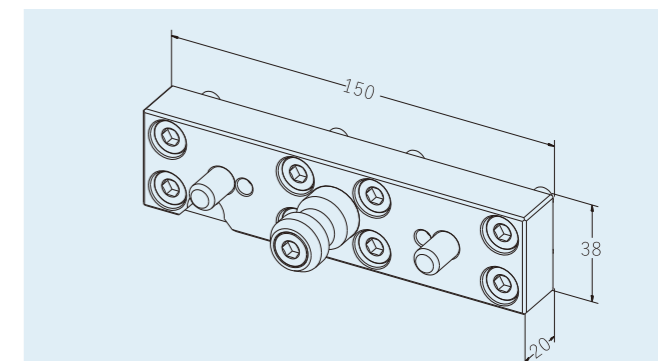
**3A-400099** 握爪柄  
Gripper link

- ▶ 规格 MTS托板联接柄, 包括安装附件
- ▶ 应用 适用于MTS托板搬运
- ▶ Version The connecting handle of MTS aluminum pallet, including mounting accessories
- ▶ Application Suitable for MTS aluminum pallet handling device



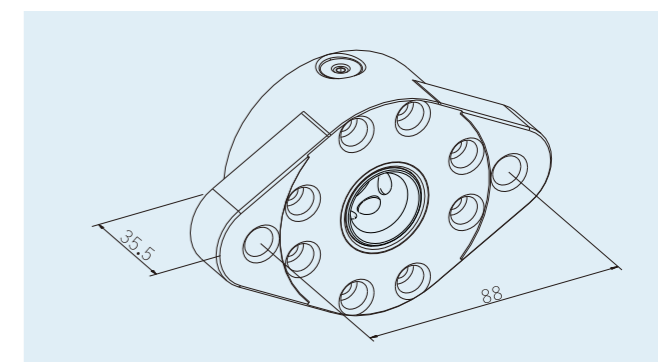
**3A-400069** 握爪柄  
Gripper link

- ▶ 规格 托板额定重量: 200kg, 托板厚度不小于40mm
- ▶ 用2-Φ6销钉定位, 附带的8-M8\*30螺钉紧固
- ▶ 接口: 3A-100047握爪卡盘
- ▶ 托板孔加工附图, 特殊要求可定制
- ▶ Version Pallet max weight: 200kg, Pallet thickness no less than 40mm, Locating with 2-Ø6 screw, With 8-M8\*30 screw fixing
- ▶ Connection: with 3A-100047 Gripper chuck
- ▶ Pallet hole processing as drawing, OEM service available



**3A-100047** 握爪卡盘  
Gripper chuck

- ▶ 规格 额定抓取重量: 200kg, 用附带的8-M6\*40螺钉紧固, 气动(0.6MPa)侧面进气
- ▶ 接口: 3A-400069握爪柄, 安装面加工附图, 特殊要求可定制
- ▶ Version Max grab weight: 200kg
- ▶ Assemble: With 8 pcs M6\*40 screw fixing
- ▶ Operation: pneumatic 0.6MPa, Connecting on the side
- ▶ Connection: with 3A-400069 Gripper link
- ▶ Processing on the assembling plate as drawing
- ▶ OEM service available



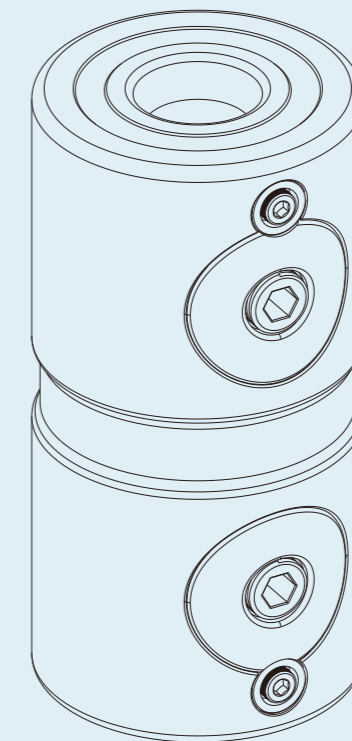


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## 下拉圆柱夹具

Pull down cylindrical fixture

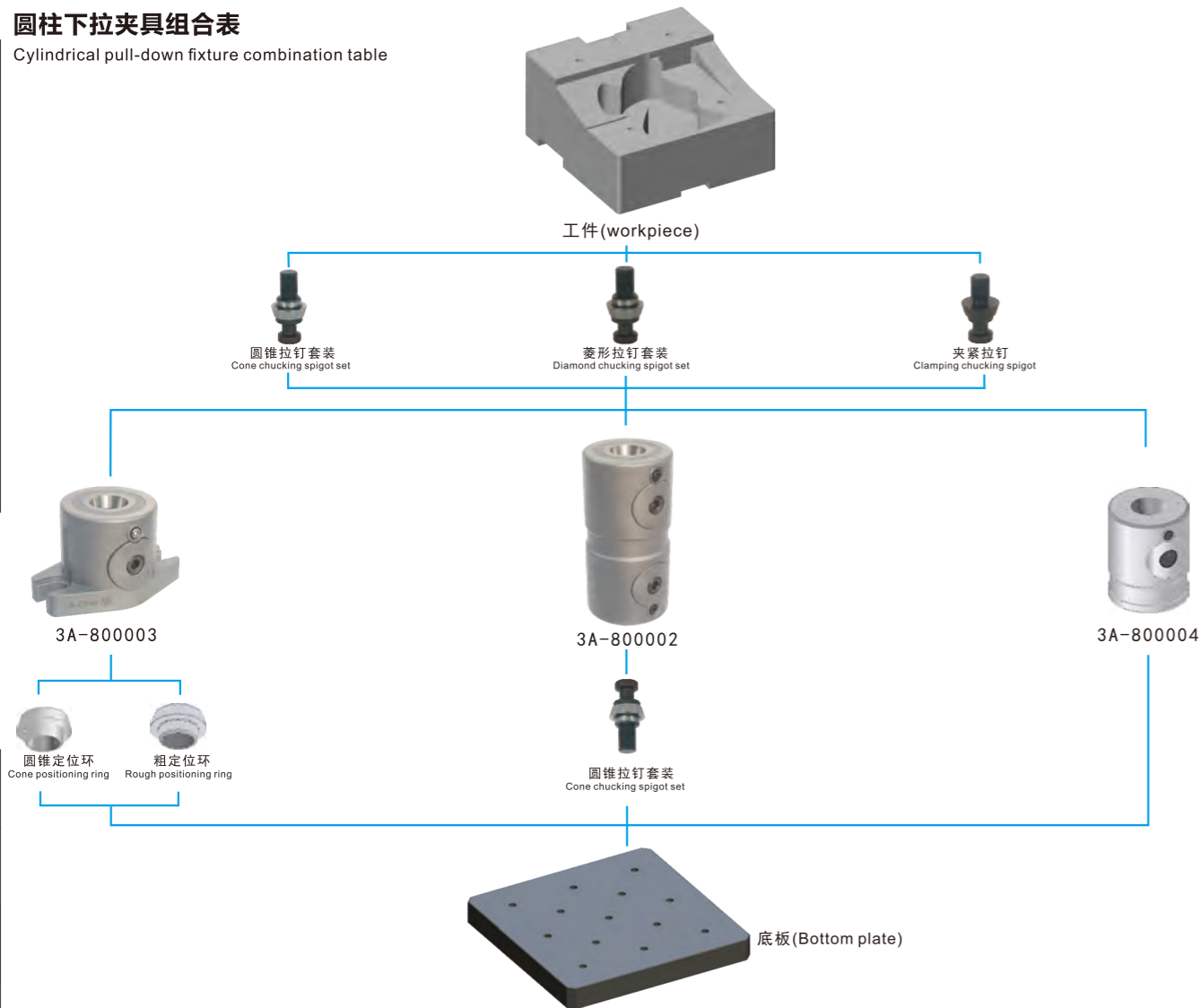


P.039~P.042



圆柱下拉夹具组合表

Cylindrical pull-down fixture combination table



应用示例

Application example

紧固顺序: 请按照1(圆锥拉钉套装)—2(菱形拉钉套装)—3(夹紧拉钉)—4(夹紧拉钉)的顺序紧固。  
Tightening sequence: please tighten in the order of 1 (Cone chucking spigot set) - 2 (Diamond chucking spigot set) - 3 (Clamping chucking spigot) - 4 (Clamping chucking spigot)

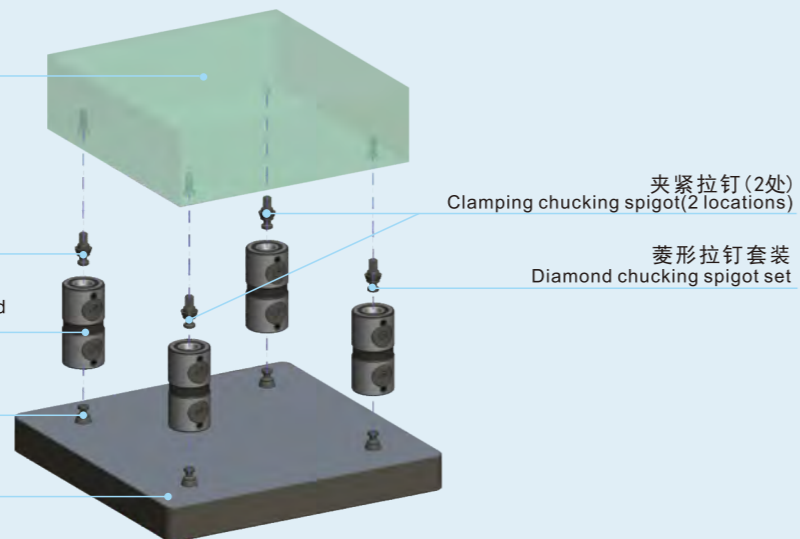
零件/托板  
Workpiece/pallet

圆锥拉钉套装  
Cone chucking spigot set

本体的方向可朝方便紧固的一面安装  
The direction the body can be installed that is convenient for fastening

圆锥拉钉套装(与底板相连x4)  
Cone chucking spigot set (x4)

底板  
Bottom plate



下拉圆柱夹具  
Pull down cylindrical fixture

- ▶ 特点 采用了能有效避免发生工具干涉的圆柱型设计, 从设计端考虑工艺, 减少夹具准备时间、夹具成本和库存
- ▶ 应用 可根据工件的类型组合使用, 适用于立加、卧加、五轴机床加工
- ▶ 连接 侧面锁紧/解锁
- ▶ 重复定位精度 小于0.01mm
- ▶ Characteristic A cylindrical design that can effectively avoid tool interference is adopted, and the process is considered from the design side, it reduces fixture preparation time, fixture cost and inventory.
- ▶ Application Can be used in combination according to the type of workpiece, suitable for vertical machining, horizontal machining, and five-axis machining
- ▶ Connection Side lock/unlock
- ▶ Resetting precision Less than 0.01mm

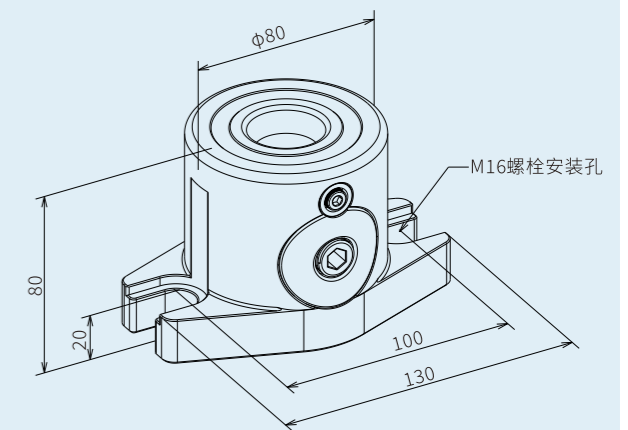
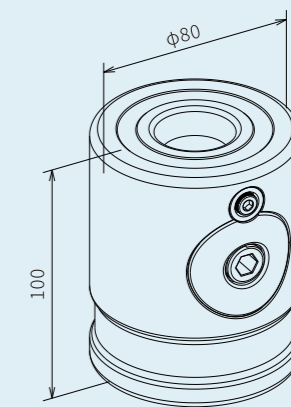
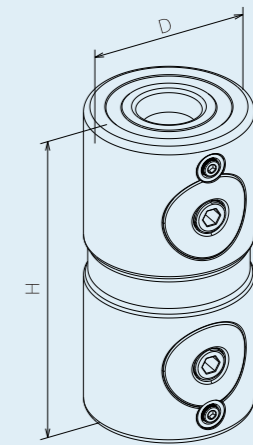
编号 Model NO	D(mm)	H(mm)	夹紧力(KN)	适配拉钉(编号)
3A-800001	Φ40	80	8	1216
3A-800002	Φ80	160	25	2232

3A-800004 下拉圆柱夹具  
Pull down cylindrical fixture

- ▶ 特点 采用了能有效避免发生工具干涉的圆柱型设计, 从设计端考虑工艺, 减少夹具准备时间、夹具成本和库存
- ▶ 应用 可根据工件的类型组合使用, 适用于立加、卧加、五轴机床加工
- ▶ 连接 侧面锁紧/解锁
- ▶ 重复定位精度 小于0.01mm
- ▶ 适配拉钉(编号) 2232
- ▶ Characteristic A cylindrical design that can effectively avoid tool interference is adopted, and the process is considered from the design side, it reduces fixture preparation time, fixture cost and inventory.
- ▶ Application Can be used in combination according to the type of workpiece, suitable for vertical machining, horizontal machining, and five-axis machining
- ▶ Connection Side lock/unlock
- ▶ Resetting precision Less than 0.01mm
- ▶ Chucking (Model NO) 2232

3A-800003 下拉圆柱夹具  
Pull down cylindrical fixture

- ▶ 特点 圆柱型下拉式夹具采用了能有效避免发生工具干涉的圆柱型设计, 从设计端考虑工艺, 减少夹具准备时间、夹具成本和库存
- ▶ 应用 可根据工件的类型组合使用, 适用于立加、卧加、五轴机床加工
- ▶ 连接 侧面锁紧/解锁
- ▶ 重复定位精度 小于0.01mm
- ▶ 适配拉钉(编号) 2232
- ▶ Characteristic A cylindrical design that can effectively avoid tool interference is adopted, and the process is considered from the design side, it reduces fixture preparation time, fixture cost and inventory.
- ▶ Application Can be used in combination according to the type of workpiece, suitable for vertical machining, horizontal machining, and five-axis machining
- ▶ Connection Side lock/unlock
- ▶ Resetting precision Less than 0.01mm
- ▶ Chucking (Model NO) 2232



下拉圆柱夹具

下拉圆柱夹具

零点定位系统  
UPC系统  
下拉圆柱夹具  
基准卡盘  
R型系列夹具  
自定心虎钳  
零点定位快锁  
夹紧装置  
其他夹具

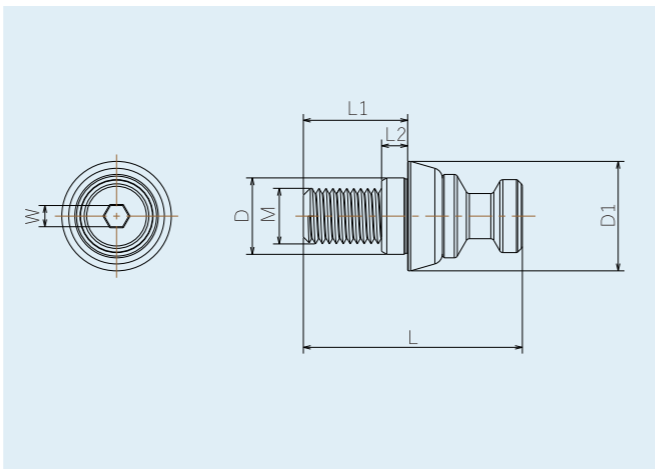
零点定位系统  
UPC系统  
下拉圆柱夹具  
基准卡盘  
R型系列夹具  
自定心虎钳  
零点定位快锁  
夹紧装置  
其他夹具



圆锥拉钉套装  
Cone chucking spigot set

- ▶ 规格 一个具有定位功能的夹紧拉钉(无定位间隙)
- ▶ 应用 用于托板的自动装载/卸载, 定位拉钉决定了基准点(无定位间隙)
- ▶ Version A clamping chucking spigot with positioning function (no positioning gap)
- ▶ Application Used for automatic loading/unloading of pallets, positioning chucking spigot determine the reference point (no positioning gap)

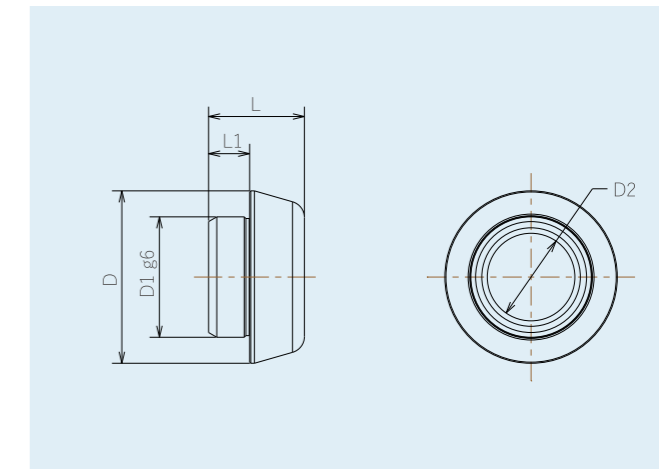
编号 Model NO	W	L	L1	L2	D	D1	M
1216	4	33.5	17	5	Φ12	Φ15.5	M8
2232	8	63	30	7.5	Φ22	Φ31.5	M16



圆锥定位环  
Cone positioning ring

- ▶ 规格 一个具有定位功能的圆锥定位环(无定位间隙)
- ▶ 应用 用于工件/托板的定位, 圆锥定位环决定了基准点(无定位间隙)
- ▶ Version A conical positioning ring with positioning function (no positioning gap)
- ▶ Application Used for positioning the workpiece/pallet, the conical positioning ring determines the datum point (no positioning gap)

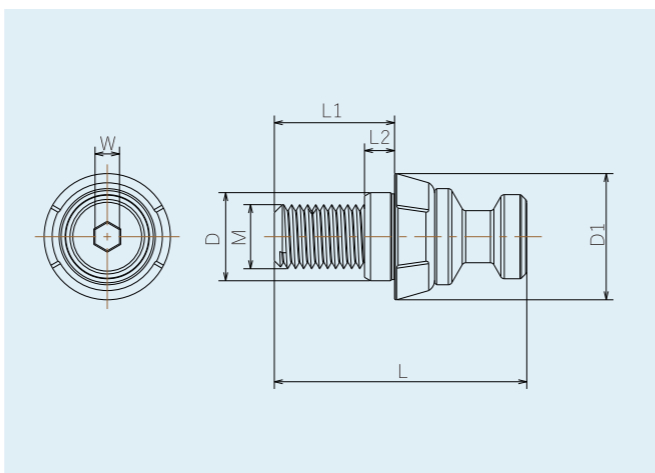
编号 Model NO	L	L1	D	D1	D2
1216	10	5	Φ16	Φ12	Φ8
2232	17.5	7.5	Φ31.5	Φ22	Φ16



菱形拉钉套装  
Diamond chucking spigot set

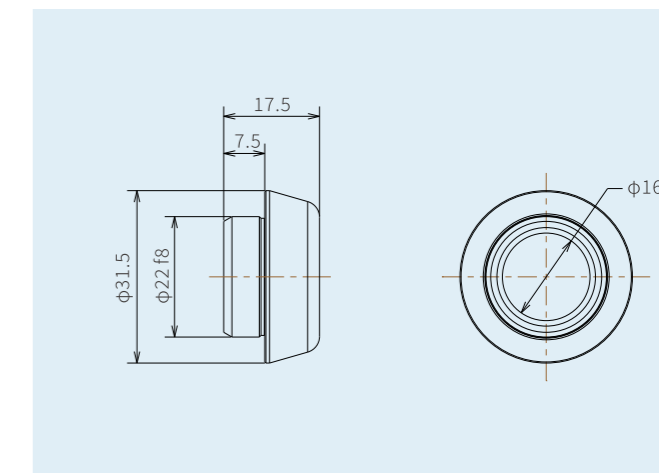
- ▶ 规格 用螺栓锁在工件托板上, 起补偿定位作用, 需配合定位拉钉、夹紧拉钉使用。确保轴向及径向定位精度0.005mm
- ▶ Version Use bolts to lock on the workpiece pallet for compensation and positioning. It needs to be used with positioning chucking spigot and clamping chucking spigot. Ensure the axial and radial positioning accuracy is 0.005mm.

编号 Model NO	W	L	L1	L2	D	D1	M
1216	4	33.5	17	5	Φ12	Φ15.5	M8
2232	8	63	30	7.5	Φ22	Φ31.5	M16



2232粗定位环  
2232Rough positioning ring

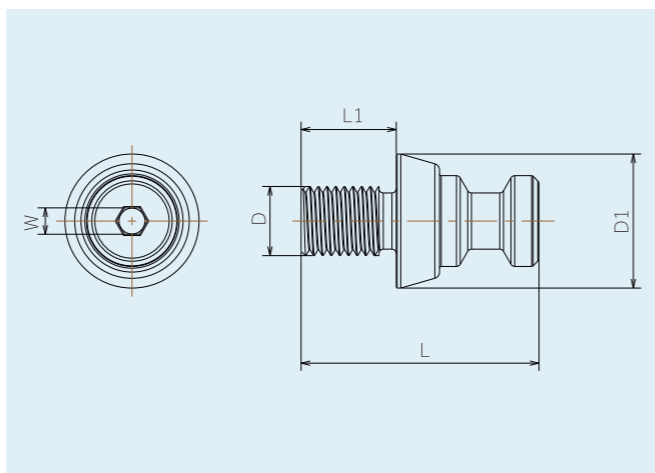
- ▶ 规格 一个具有粗定位功能的粗定位环(有定位间隙)
- ▶ 应用 用于工件/托板的粗定位, 粗定位环起着粗定位作用
- ▶ Version A rough positioning ring with rough positioning function (with positioning gap)
- ▶ Application Used for rough positioning of workpiece/pallet, rough positioning ring plays a role of rough positioning



夹紧拉钉  
Clamping chucking spigot

- ▶ 规格 一个具有锁紧功能的夹紧拉钉
- ▶ 应用 用于工件/托板的自动装载/卸载
- ▶ Version A clamping chucking spigot with locking function
- ▶ Application For automatic loading/unloading of workpieces/pallets

编号 Model NO	W	L	L1	D	M
1216	4	28.5	12	Φ11	M8
2232	8	55	22	Φ21	M16

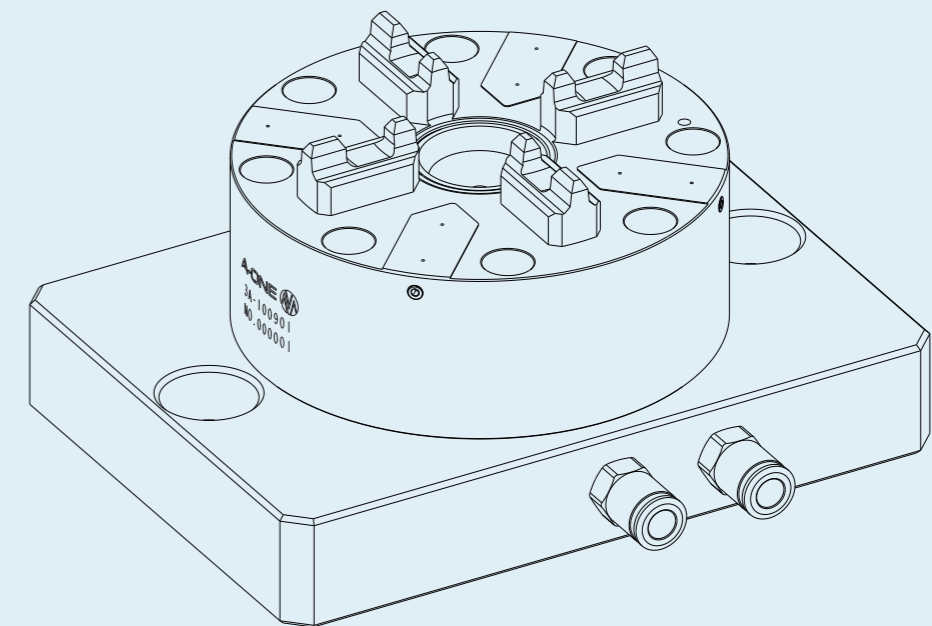


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## 基准卡盘

Benchmark chuck



P.045~P.060



基准卡盘

精密机械加工，为您的昂贵设备添加必备的装备，强力型卡盘以其夹紧力强、重复定位精度0.002mm、实现快速装夹，让您的爱机如虎添翼！



▲可根据实际加工需求选用100型气动卡盘,150型强力卡盘 ▲R型气动卡盘实现快速换装,重复定位精度0.002mm

灵活简单设计，可实现多面加工



▲使用A-ONE卡盘系列产品，在立式加工中心,卧式加工中心上,轻松实现多面加工提高生产效率

基准卡盘

零点定位系统

UPC系统

下拉圆柱夹具

基准卡盘

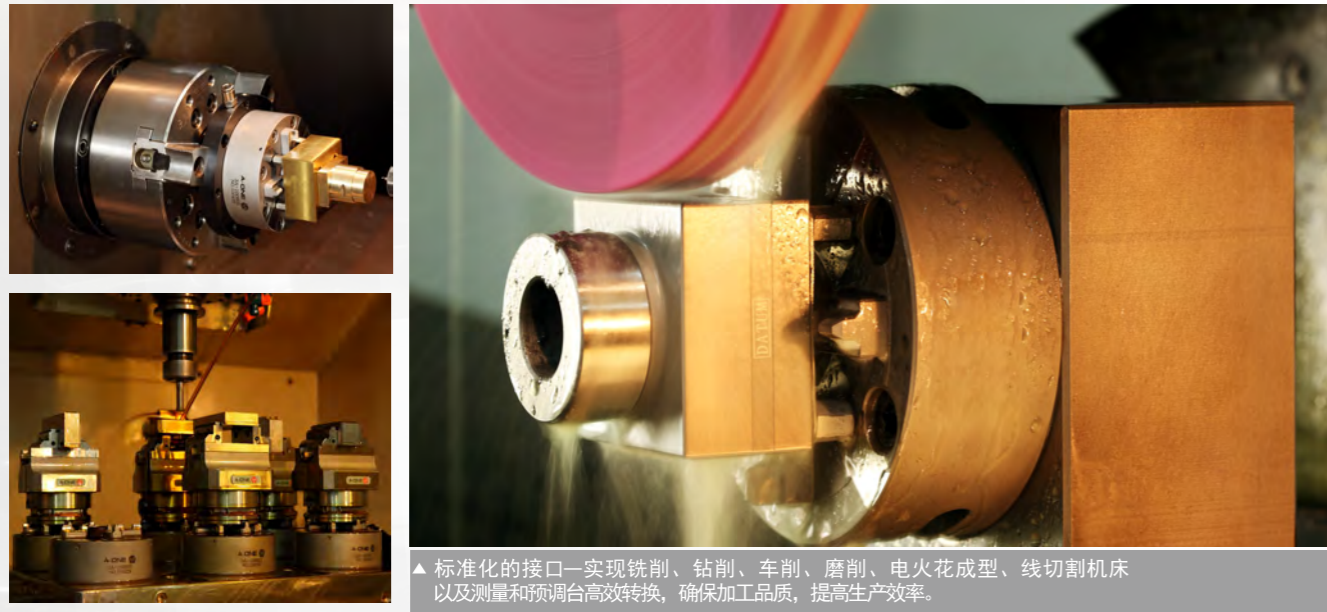
R型系列夹具

自定心虎钳

零点定位快锁

夹紧装置

其他夹具



▲标准化的接口—实现铣削、钻削、车削、磨削、电火花成型、线切割机床以及测量和预调台高效转换，确保加工品质，提高生产效率。

零点定位系统

UPC系统

下拉圆柱夹具

基准卡盘

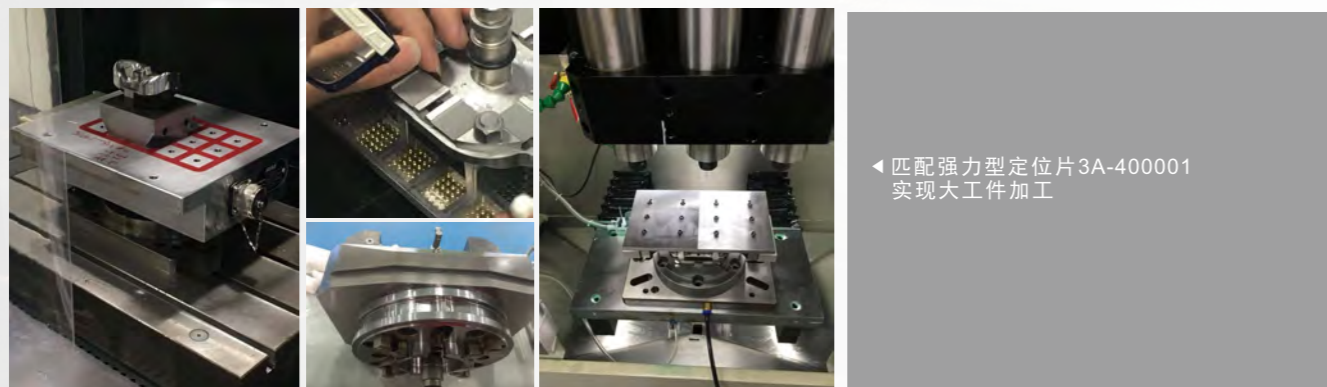
R型系列夹具

自定心虎钳

零点定位快锁

夹紧装置

其他夹具



◀匹配强力型定位片3A-400001实现大工件加工

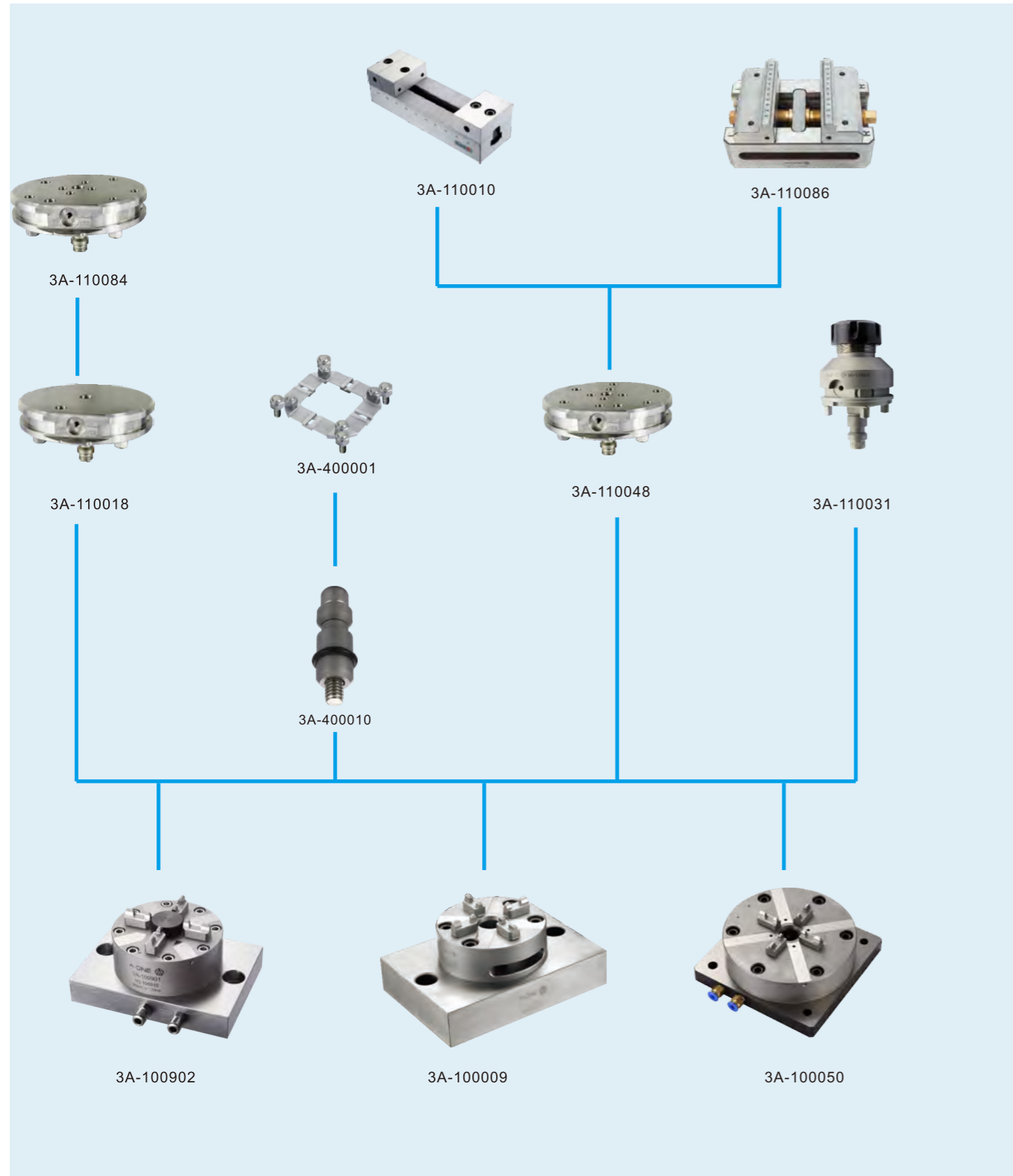


▲小型四轴五轴转台安装卡盘，在加工零件时便可机外安装，快速更换产品线



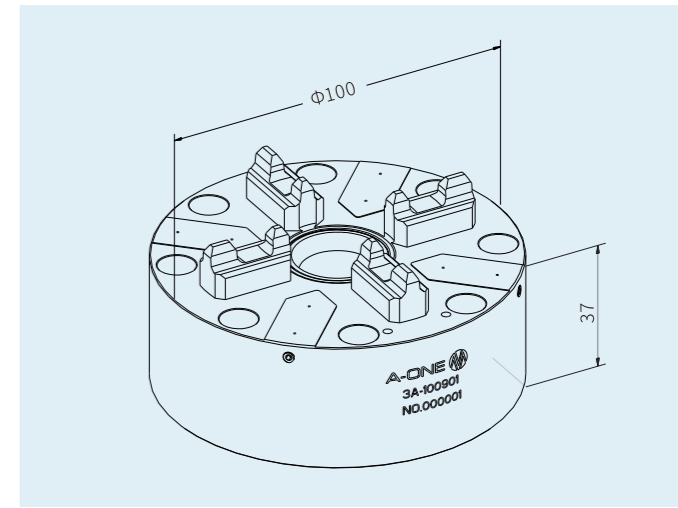
基准卡盘

基准卡盘



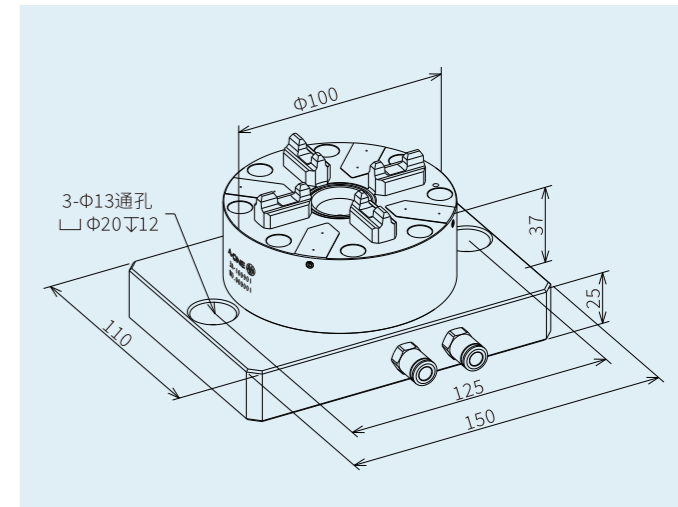
**3A-100901** 100型气动卡盘 (不含底板)  
ITS chuck 100 p (without plate)

- ▶ 规格 不锈钢, 硬质, 重复定位精度 0.002mm
  - ▶ 夹紧力 6000N
  - ▶ 连接 用两条气流管路从背面
  - ▶ 操作 气阀
  - ▶ 应用 用于客户自行设计的夹具
- 
- ▶ Version Stainless steel, hardened, Repeat positioning accuracy of 0.002 mm
  - ▶ Clamping Power 6000N
  - ▶ Connection At the rear with two lines
  - ▶ Operation Air valves
  - ▶ Application Can be used with customized tools



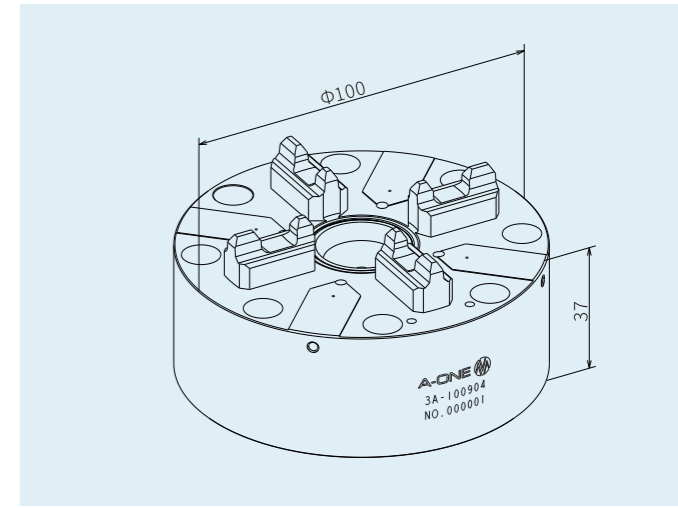
**3A-100902** 100型单中心气动卡盘 (含底板)  
ITS chuck 100 P (with plate)

- ▶ 规格 不锈钢, 硬质, 重复定位精度 0.002mm
  - ▶ 夹紧力 6000N
  - ▶ 操作 气阀
  - ▶ 应用 可装夹电极夹头、强力定位片承载的托板
- 
- ▶ Version Stainless steel, hardened, Repeat positioning accuracy of 0.002 mm
  - ▶ Clamping Power 6000N
  - ▶ Operation Air valves
  - ▶ Application Electrode holder and pallet with power centerig plate can be mounted.



**3A-100904** 100型气动卡盘  
Rapid-action chuck100 automatic

- ▶ 规格 不锈钢, 硬质, 重复定位精度 0.002mm
  - ▶ 夹紧力 6000N
  - ▶ 连接 带气检、防反功能、侧面/底面进气可选, 底面有定位精孔
  - ▶ 操作 气阀
- 
- ▶ Version Stainless steel, hardened, Repeat positioning accuracy of 0.002 mm
  - ▶ Clamping Power 6000N
  - ▶ Connection With air detection and anti reverse function, Side and bottom intake is available, Loction hole at bottom
  - ▶ Operation Air valves



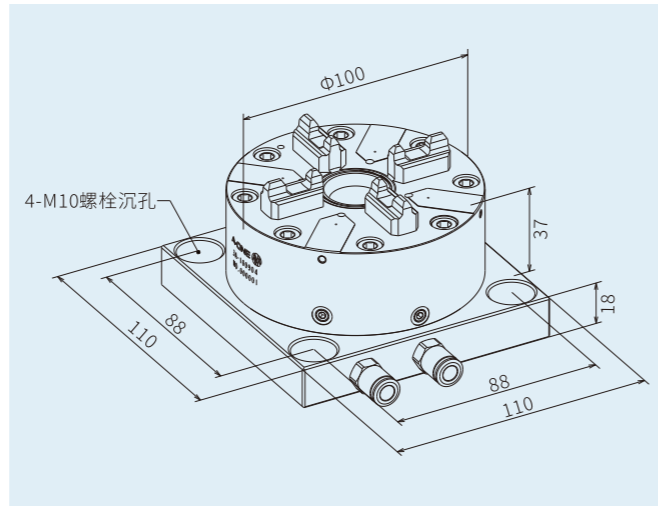
零点定位系统  
UPC系统  
下拉圆柱夹具  
基准卡盘  
R型系列夹具  
自定心虎钳  
零点定位快锁  
夹紧装置  
其他夹具

零点定位系统  
UPC系统  
下拉圆柱夹具  
基准卡盘  
R型系列夹具  
自定心虎钳  
零点定位快锁  
夹紧装置  
其他夹具



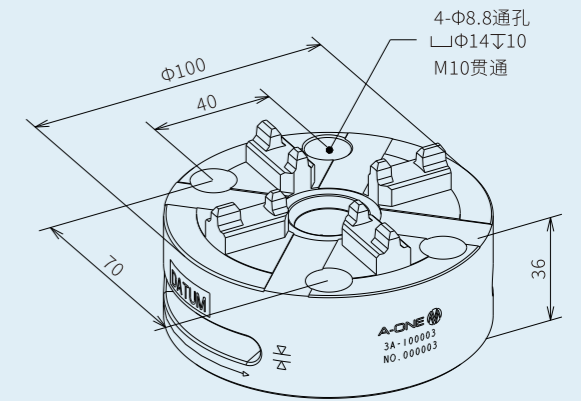
**3A-100057** 100型气动卡盘带底板  
Rapid-action chuck 100 automatic (with plate)

- ▶ 规格 不锈钢, 淬硬, 重复定位精度 0.002mm
- ▶ 夹紧力 6000N
- ▶ 连接 带气检、防反功能, 侧面/底面进气可选, 底面有定位精孔
- ▶ 操作 气阀
- ▶ Version Stainless steel, hardened, Repetition accuracy of 0.002 mm
- ▶ Clamping Power 6000N
- ▶ Connection With air detection and anti reverse function, Side and bottom intake is available, Location hole at bottom
- ▶ Operation Air valves



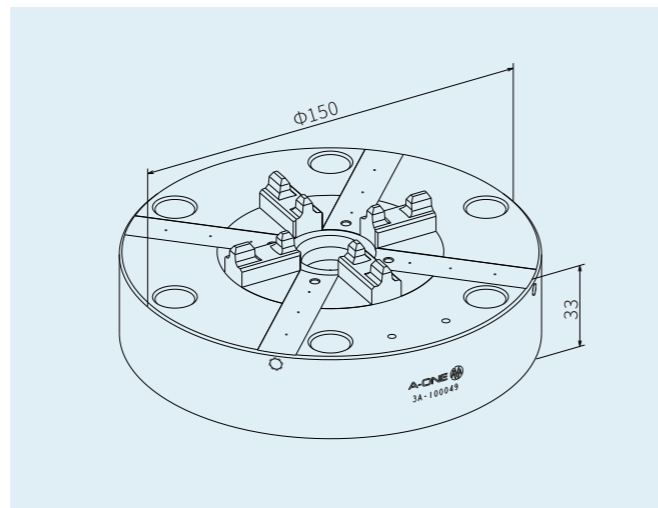
**3A-100003** 圆形手动卡盘  
Quick chuck 100 P

- ▶ 规格 系统尺寸100, 手动, 防腐蚀
- ▶ 夹紧力 10000N
- ▶ 安装 用所附的4个M8螺钉
- ▶ 应用 车床、铣床、磨床、电火花或线切割机床
- ▶ Version System size 100, manual, corrosion-resistant
- ▶ Clamping Power 10000N
- ▶ Mounting With four M8 bolts supplied
- ▶ Application Turning, milling, grinding or EDM/WEDM machines, in dividers and fixtures



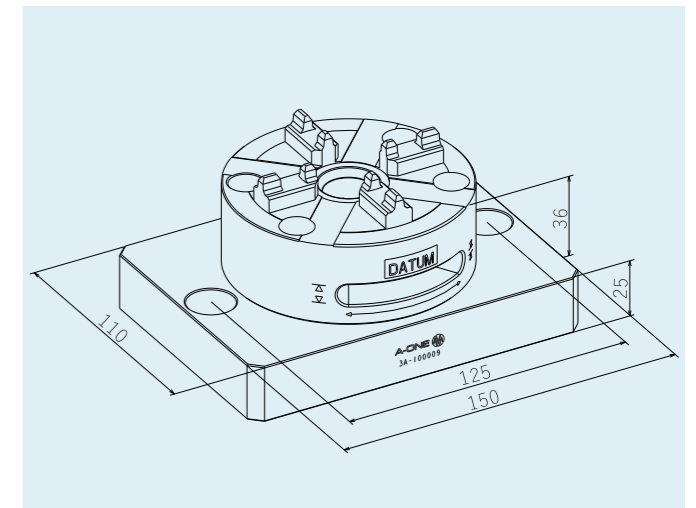
**3A-100049** 150强力卡盘  
Power chuck 150

- ▶ 规格 150强力型, 带底板, 4-M8螺丝安装过孔
- ▶ 夹紧力 10000N
- ▶ 连接 侧面二线连接
- ▶ 操作 气阀
- ▶ Version 150 Powerful type. With plate, Mounting 4-M8 screw on the plate
- ▶ Clamping Power 10000N
- ▶ Connection With 2 air tubes on the side
- ▶ Operation Air valve



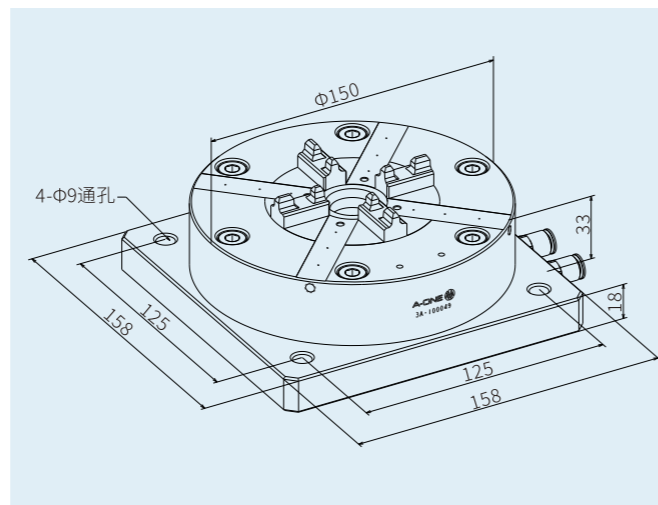
**3A-100009** 手动单中心卡盘  
Quick chuck 100 P with base plate

- ▶ 规格 防腐蚀, 带底板
- ▶ 夹紧力 10000N
- ▶ 安装 用螺丝或压板
- ▶ 应用 CNC加工中心用, 亦可用在铣床、磨床
- ▶ Version Corrosion-resistant, with plate
- ▶ Clamping Power 10000N
- ▶ Mounting With bolts or clamps
- ▶ Application To be used on CNC lathe, Milling or grinding machine



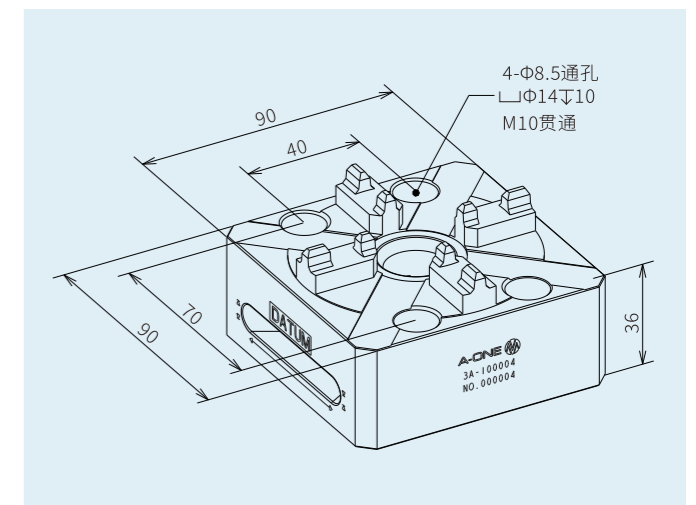
**3A-100050** 150强力卡盘带底板  
Power chuck 150 (with plate)

- ▶ 规格 150强力型, 带底板, 4-M8螺丝安装过孔
- ▶ 夹紧力 10000N
- ▶ 连接 侧面二线连接
- ▶ 操作 气阀
- ▶ Version 150 Powerful type. With plate, Mounting 4-M8 screw on the plate
- ▶ Clamping Power 10000N
- ▶ Connection With 2 air tubes on the side
- ▶ Operation Air valve



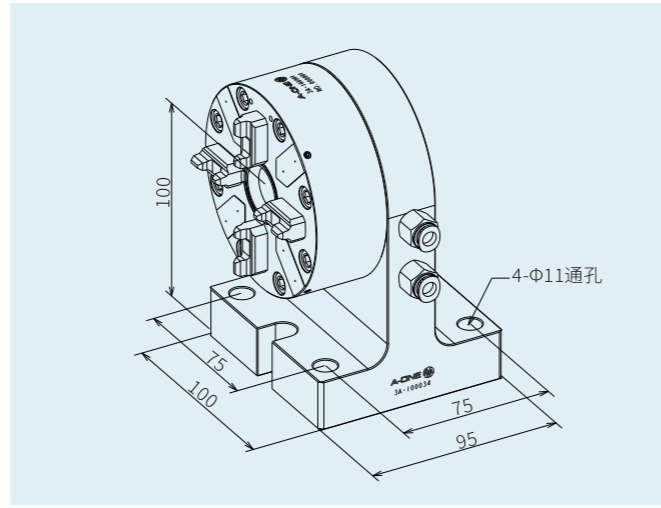
**3A-100004** 方型手动卡盘  
Square manual chuck

- ▶ 规格 系统尺寸90, 手动, 防腐蚀
- ▶ 夹紧力 10000N
- ▶ 安装 用所附的4个M8螺钉
- ▶ 应用 车床、铣床、磨床、电火花或线切割机床
- ▶ Version System size 90, manual, corrosion-resistant
- ▶ Clamping Power 10000N
- ▶ Mounting With four M8 bolts supplied
- ▶ Application Turning, milling, grinding or EDM/WEDM machines, in dividers and fixtures



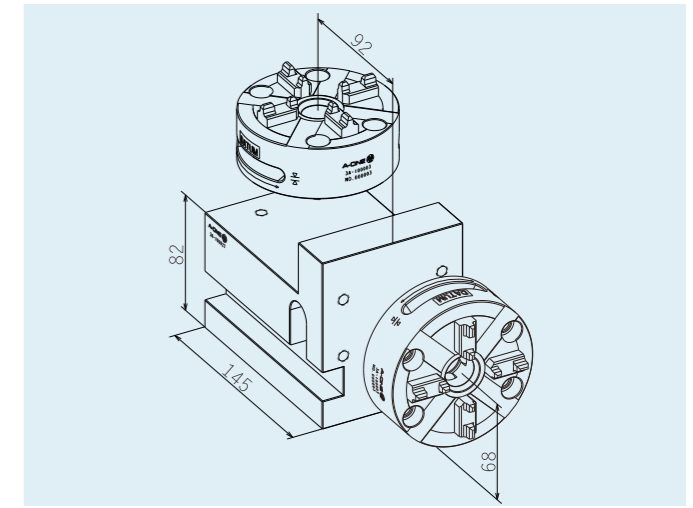
**3A-100034** 气动立式卡盘  
Single auto chuck-horizontal

- ▶ 规格 气动锁紧功能,可侧向四面加工,含卡盘
- ▶ 安装 直接安装在工作台上
- ▶ 应用 用于CNC加工中心
- ▶ Version Power pneumatic lock, four sides of workpiece can be machined, with chuck
- ▶ Mounting To be mounted directly on the table of machining center
- ▶ Application To be used on CNC machining center



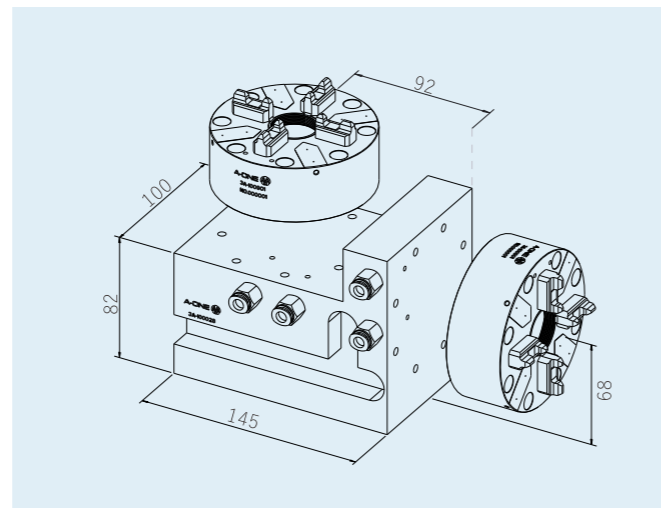
**3A-100027** 手动卡盘直角座  
Square block for manual chuck

- ▶ 规格 钢, 硬质, 防腐蚀
- ▶ 应用 既可在水平又可在垂直位置安装1至2个3A-100003
- ▶ 注意 卡盘需另购
- ▶ Version Steel, hardened, corrosion-resistant
- ▶ Application For attaching 1 or 2 chucks 3A-100003 in horizontal and vertical position
- ▶ Note Chuck supplied separately



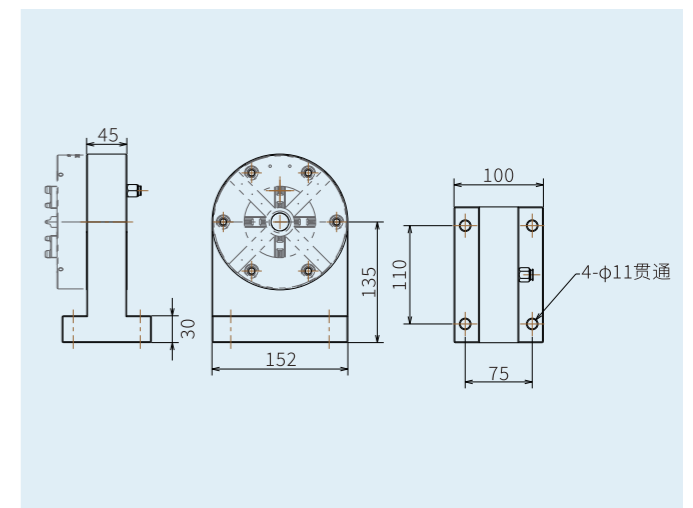
**3A-100028** 气动卡盘直角座  
Square block for auto chuck

- ▶ 规格 钢, 硬质, 防腐蚀
- ▶ 应用 既可在水平又可在垂直位置安装1至2个卡盘3A-100901
- ▶ 注意 卡盘需另购
- ▶ Version Steel, hardened, corrosion-resistant
- ▶ Application For attaching 1 or 2 chucks 3A-100901 in horizontal and vertical position
- ▶ Note Chuck supplied separately



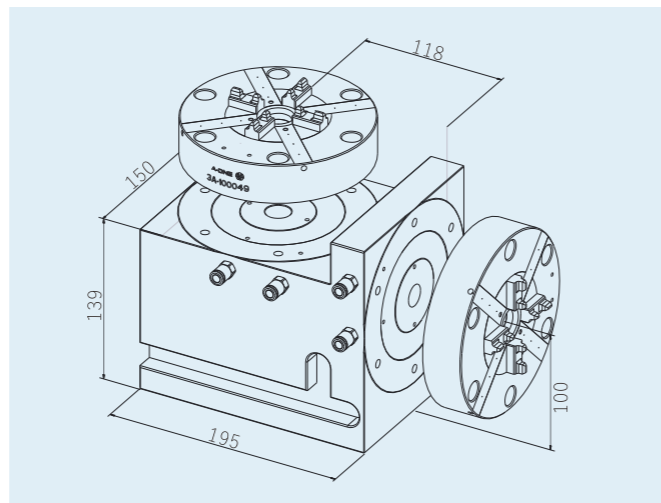
**3A-10000349** 强力T座  
Powerful T base plate

- ▶ 规格 钢, 硬质, 防腐蚀
- ▶ 安装 直接安装在工作台上
- ▶ 应用 用于CNC加工中心, 气动锁紧功能, 可侧向四面加工, 卡盘需另购
- ▶ Version Steel, hardened, corrosion-resistant
- ▶ Mounting To be mounted directly on the table of machining center
- ▶ Application To be used on CNC machining center, Power pneumatic lock, four sides of workpiece can be machined, Chuck supplied separately



**3A-100069** 强力气动卡盘直角座  
Square block for power auto chuck

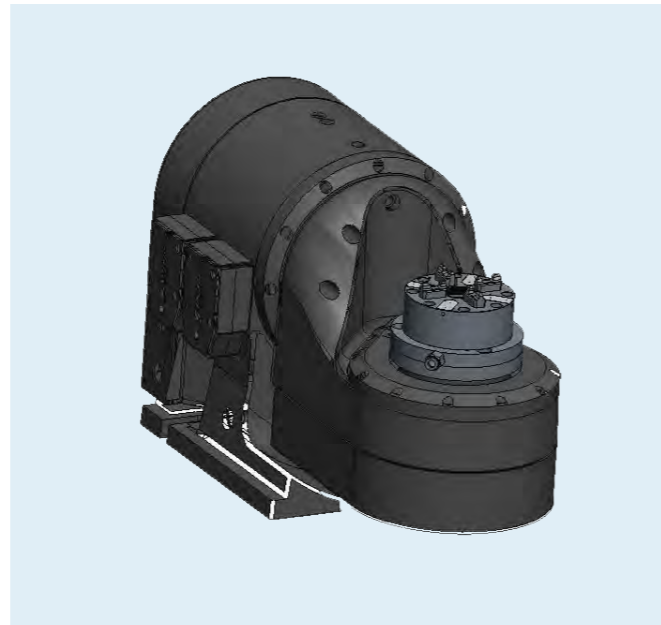
- ▶ 规格 钢, 硬质, 防腐蚀
- ▶ 应用 既可在水平又可在垂直位置安装1至2个3A-100049
- ▶ 注意 卡盘需另购
- ▶ Version Steel, hardened, corrosion-resistant
- ▶ Application For attaching 1 or 2 chucks 3A-100049 in horizontal and vertical position
- ▶ Note Chuck supplied separately



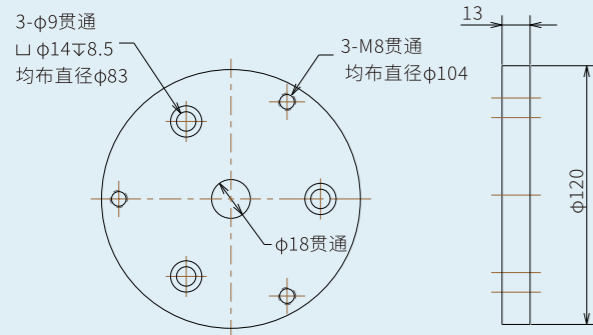


五轴转台安装板、进气板  
Five-axis table mounting plate, intake plate

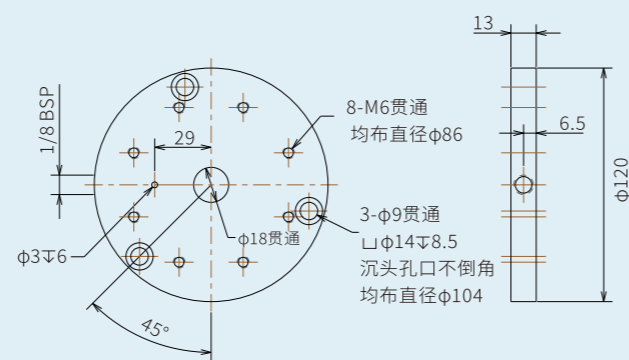
- ▶ **五轴安装板** 五轴安装板作为转接板安装于五轴工作台上
- ▶ **进气板** 气动卡盘通过进气板进行解锁/锁紧控制, 进气板作为卡盘安装板与五轴台安装板进行组装使用, 把气动卡盘安装于五轴工作台上。
- ▶ **注意** 五轴安装板可根据客户机台及需求定制, 卡盘需另购。
- ▶ **Five-axis table mounting plate** The five-axis mounting plate is installed on the five-axis workbench as an adapter plate.
- ▶ **Intake plate** The pneumatic chuck is controlled by the intake plate to unlock and lock; the intake plate is used as a combination of the chuck mounting plate and the five axis table mounting plate, and the pneumatic chuck is installed on the five-axis table.
- ▶ **Note** The five-axis mounting plate can be customized, and the chuck needs to be purchased separately.



安装板(mounting plate)

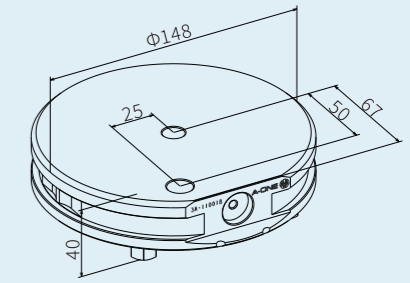


进气板(Intake plate)



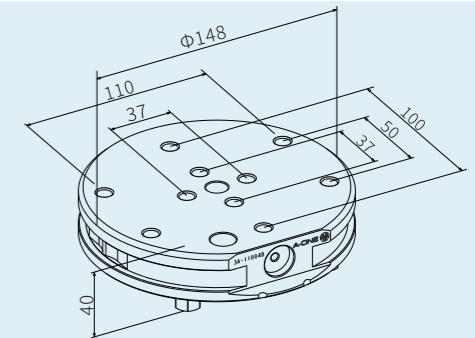
3A-110018 托板 Ø148  
Pallet Kit Ø148

- ▶ **规格** 钢, 耐腐蚀, 强力定位片, 中心孔周围无布孔, 有基准螺孔
- ▶ **应用** 在切削加工中适用于工件的加工
- ▶ **安装** 按需要
- ▶ **Version** Steel, corrosion-resistant, Centering plate G Inox, Without boreholders apart from center borehole and borehole for reference bolt.
- ▶ **Application** For workpieces machined in chip-cutting machining
- ▶ **Mounting** According to your preference



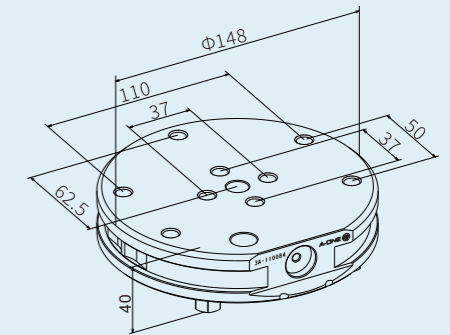
3A-110048 托板 Ø148  
Pallet Kit Ø148

- ▶ **规格** 钢, 耐腐蚀, 90型定位片, 托板集成中心定位系统
- ▶ **应用** 用于所有 A-one 强力卡盘和生产型卡盘。在切削加工过程中适用于工件和夹具
- ▶ **安装** 用M8螺钉穿过托板, 或用M10螺钉穿过坯料
- ▶ **Version** Steel, corrosion-resistant, Centering plate 90 M8, Centering integrated in the pallet
- ▶ **Application** For used on all A-one Power Chuck and Production Chuck To accommodate workpieces and fixtures in chip-cutting machining processes
- ▶ **Mounting** Through pallet with M8 bolts or through blank with M10 bolts



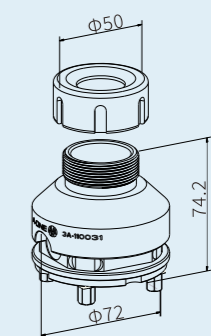
3A-110084 托板 Ø148  
Pallet Kit Ø148

- ▶ **规格** 钢, 耐腐蚀, 标准型, 强力定位片
- ▶ **应用** 适用于切削加工的工件和夹具
- ▶ **安装** 用M8螺钉穿过托板或用M10螺钉穿过坯料
- ▶ **Version** Steel, corrosion-resistant, Standard type, Centering plate G Inox
- ▶ **Application** To accommodate workpieces and fixtures in chip-cutting machining processes
- ▶ **Mounting** Through pallet with M8 bolts or through blank with M10 bolts



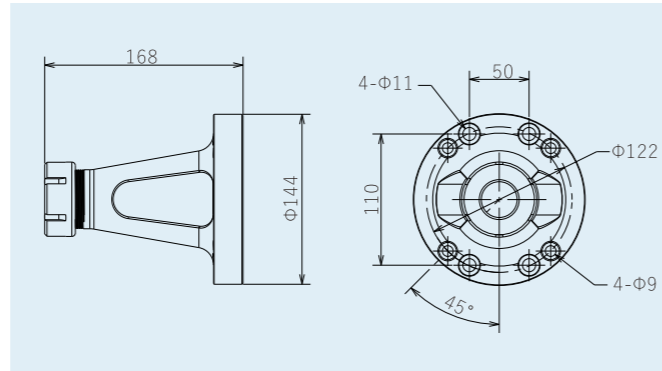
3A-110031 弹簧套筒夹头 Ø72  
Collet chuck holder Ø72

- ▶ **规格** 每个弹簧套筒夹头都配有夹紧拉钉, 系统尺寸 50
- ▶ **应用** 夹持圆柱形工件。夹持范围Ø2mm-Ø20mm
- ▶ **注意** 单独订购弹簧套筒
- ▶ **Version** One collet chuck holder with chucking spigot. System size 50
- ▶ **Application** To clamp cylindrical parts. Clamping range ø2 mm - ø20 mm
- ▶ **Note** Ordered collet chucks separately

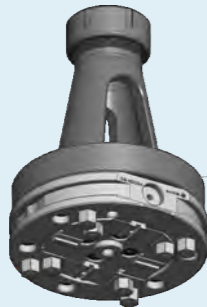


**3A-110099 ER40筒夹套**  
ER 40 collet

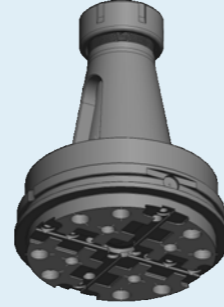
- ▶ 应用 适用圆形工件夹持, 可通过最大  $\phi 32\text{mm}$  的挂台
- ▶ 注意 托板需另购
- ▶ Application Suitable for circular workpieces clamping, Can pass the maximum  $\phi 32\text{mm}$  hanging platform
- ▶ Note Pallet kit supplied separately



应用案例  
Application case



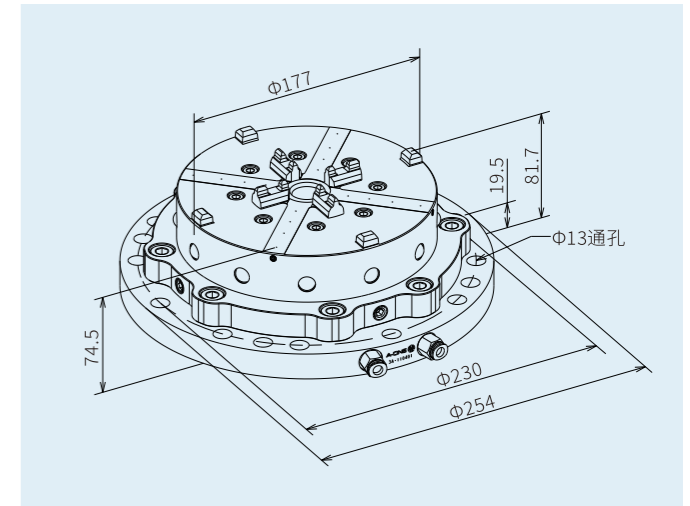
ER40筒夹套配ITS托板, 实现快速装夹  
Er40 collet sleeve is equipped with ITS pallet to realize rapid clamping



ER40筒夹套配R型托板, 实现快速装夹  
Er40 collet sleeve is equipped with R type pallet to realize rapid clamping

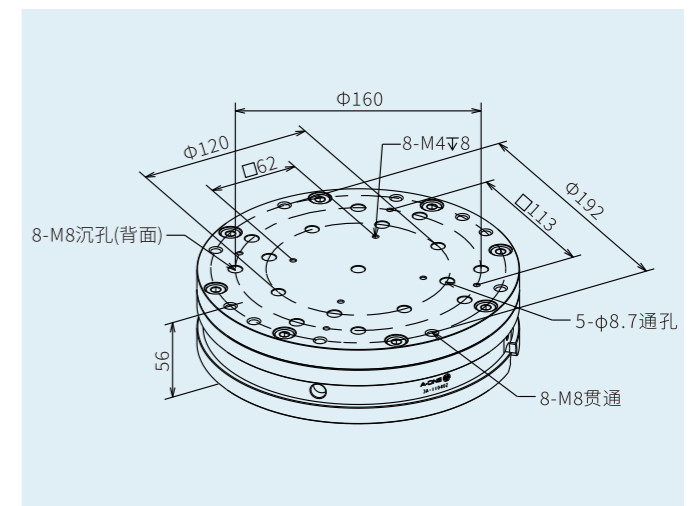
**3A-110401 210卡盘**  
Chuck 210

- ▶ 规格 用于强力切削领域
- ▶ 连接 用两条气流管路从侧面或底部连接
- ▶ 操作 用气枪, 侧面吹气
- ▶ 应用 车床、铣床、磨床、电火花加工中心。夹持210托盘、ITS  $\phi 148$ 托板。
- ▶ Version Used in the field of heavy cutting
- ▶ Connection From the side or bottom with two air flow lines
- ▶ Operation Blow from the side with an air gun
- ▶ Application Turning, milling, grinding and EDM machining center. Clamping pallet 210, ITS  $\phi 148$  pallet.



**3A-110402 210托盘**  
Pallet 210

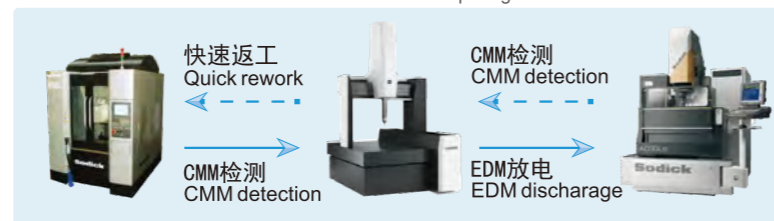
- ▶ 规格 钢质, 带定位元件
- ▶ 应用 夹持工件/夹具, 配合210卡盘使用
- ▶ Version Stainless steel, with centering segments
- ▶ Application Clamping workpiece/fixture, use with chuck 210



托盘在卡盘上快速装夹定位  
Quick clamping and positioning of pallet on chuck



侧面开口处打表校正零件基准边  
Calibrate the reference edge of the part at the side opening



筒夹定心、侧面打表校正基准边, 实现零件快速定位装夹。零件定位好后, 可随托盘快速进行工序衔接

Centering the collet, calibrate the reference edge on the side, to realize rapid positioning and clamping of the parts. The parts can be quickly connects process with the pallet after positioned.





- 1、可移动的上部用作误差补偿  
Movable upper part for error compensation
- 2、锁紧球槽  
Groove for ball lock
- 3、与料仓的接合平面  
Bonding plane with silo
- 4、O形密封圈  
Groove for O-ring seal
- 5、握爪平面  
Flats for gripper

**3A-400005** 拉钉组合  
Chucking spigot F/M production

- ▶ 规格 固定型, 手动。螺钉可带中心冲洗孔
- ▶ 应用 用于切削过程中的托板
- ▶ Version Fixed type, manual. Bolt 12.9, with flushing hole
- ▶ Application In Pallets for chip-cutting machining processes

**3A-400007** 拉钉组合  
Chucking spigot F/A Inox

- ▶ 规格 固定型, 自动。不锈钢螺钉, 无中心冲洗孔
- ▶ 应用 适用于电极库
- ▶ Version Fixed type, automatic. Bolt stainless, without flushing hole
- ▶ Application On all holders used on electrode library

**3A-400076** 拉钉组合  
Chucking spigot F/A Inox

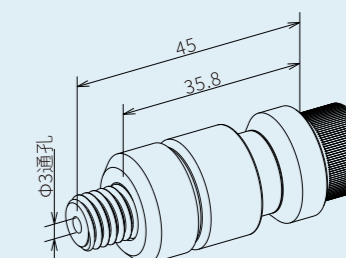
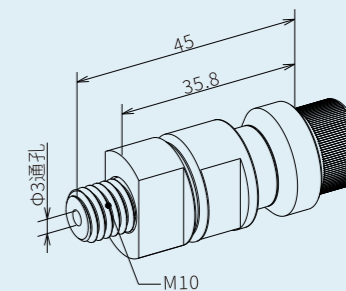
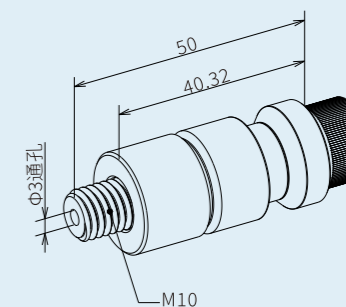
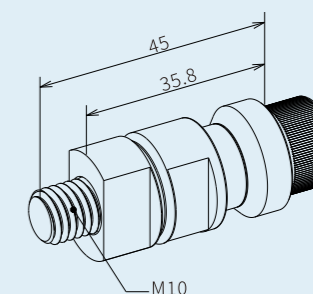
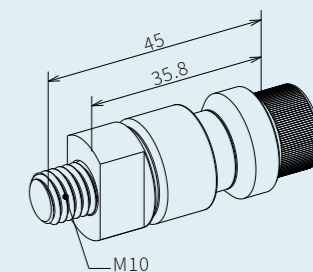
- ▶ 规格 固定型, 手动。螺钉可带中心冲洗孔
- ▶ 应用 用于带有强力定位片(非内嵌式)的托板
- ▶ Version Fixed type, manual. Bolt 12.9, with flushing hole
- ▶ Application For pallets with centering plate G (not built-in)

**3A-400038** 拉钉组合  
Chucking spigot F/A EDM M10\*45 for flushing

- ▶ 规格 固定型, 自动。螺钉有中心冲洗孔
- ▶ 应用 用于电极夹头, 用于电火花加工和轻型切削加工
- ▶ Version Fixed type, automatic. Bolt with flushing hole
- ▶ Application For electrode holder, for EDM-ing and machining with light cutting force

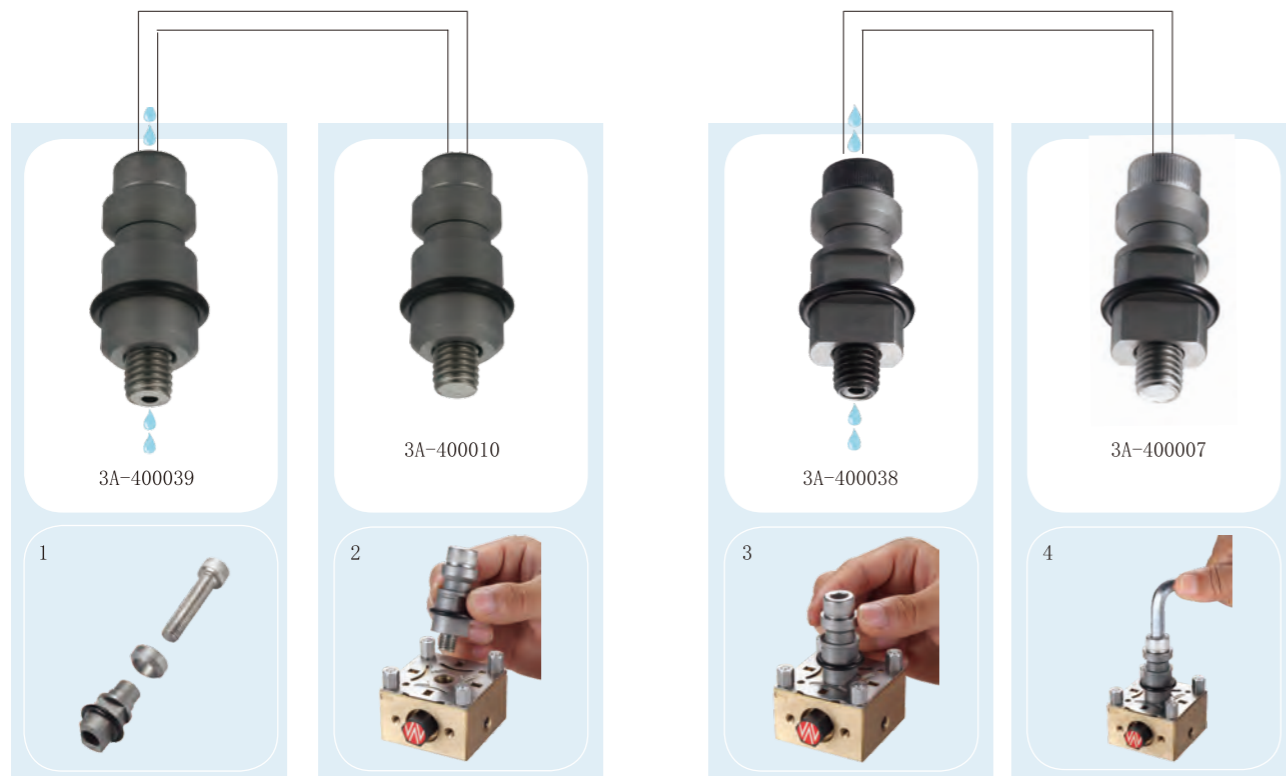
**3A-400039** 拉钉组合  
Chucking spigot F/M EDM for flushing

- ▶ 规格 固定型, 手动。螺钉带中心冲洗孔
- ▶ 应用 用于电极夹头, 用于电火花加工和轻型切削加工
- ▶ Version Fixed type, manual. Bolt with flushing hole
- ▶ Application For electrode holder, for EDM and easy machining with light cutting force



手动 Manual

自动 Automatic



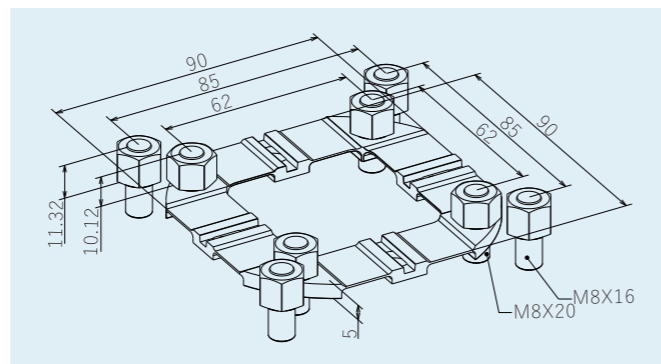
定位片是夹持电极的最经济的基础件。它可直接装于电极毛坯或托板上。这样，电极的夹具也与 ITS 匹配。安装孔的布孔只需简单的用钻孔模板或用 NC 编程的方法，直接在坯料上钻孔。

The centering plates are the most cost-effective base for clamping electrodes. They are mounted directly onto the blanks or pallets. This way, jigs and fixtures are also ITS compatible. The hole pattern for mounting is simply drilled into the blank with a drilling template, or by means of an NC program.

技术参数	Technical data	ITS 定位片	ITS centering plates
材料	Material	防腐蚀	corrosion-resistant
在卡盘上的系统精度	System accuracy in chuck	0.002mm	0.002mm
规格	Versions:		
定位片 50	Centering plate 50	小型电极	small electrode weights
定位片 100M8	Centering plate 100 M8	工件和电极	workpieces and electrodes
定位片 G	Centering plate 100 G	工件，切削加工中的夹具	workpieces, jigs and fixtures for chip-removal machining
操作	Handling	用 A-ONE 搬运系统或电极交换装置	with A-ONE handling systems or electrode changer.

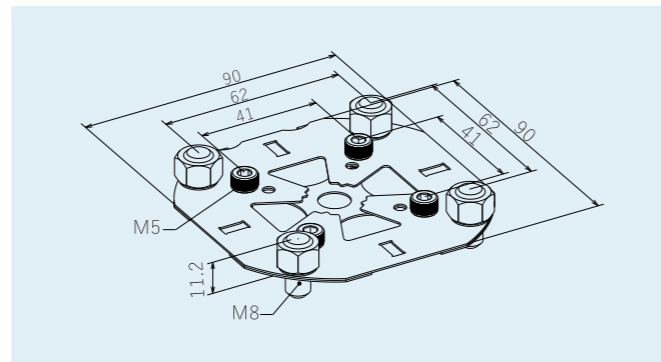
**3A-400001** 强力定位片  
Centering plate G Inox

- ▶ 规格 磨削，每组含8个M8的支撑脚
- ▶ 应用 工件切削加工中的夹具
- ▶ 安装 参考安装说明
- ▶ Version Ground, including 8 supporting feet M8
- ▶ Application For workpieces, jigs and fixtures in chip-removal machining
- ▶ Mounting Reference installation instructions



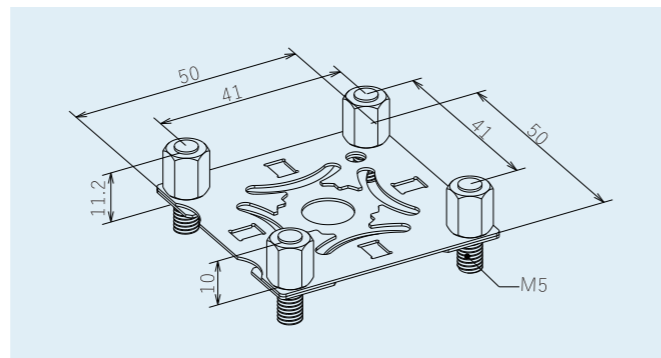
**3A-400002** 90型定位片  
Centering plate 90 M8

- ▶ 规格 防腐蚀，每组含4个M8的支撑脚和4个M5螺钉
- ▶ 应用 工件和电极
- ▶ 安装 装于电极或工件托板上，也可直接安装于毛坯表面上
- ▶ Version Corrosion-resistant, including 4 supporting feet M8 and 4 M5 screws per plate
- ▶ Application Workpieces and electrodes
- ▶ Mounting Mounted on the electrode plate or workpiece, or on plane surface blank too



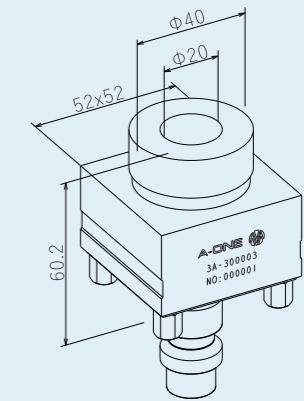
**3A-400003** 50型定位片  
Centering plate 50

- ▶ 规格 防腐蚀，每组含4个支撑脚
- ▶ 应用 工件和电极
- ▶ 安装 装于电极或工件托板上，也可直接安装于毛坯表面上
- ▶ Version Corrosion-resistant, including 4 supporting feet per plate
- ▶ Application Workpiece and electrode
- ▶ Mounting Mounted on the electrode plate or workpiece, or on plane surface blank too



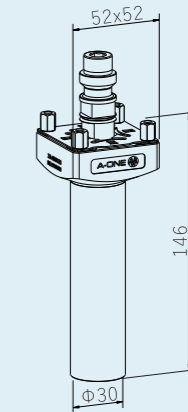
**3A-300003** CNC 零位基准  
CNC gauging pin

- ▶ 规格 系统尺寸 ITS 50，同时拥有圆形和方形两种规格基准
- ▶ 应用 ITS 卡盘零位找正或获得
- ▶ Version ITS system size 50, have both two specifications of gauges: circle and square
- ▶ Application ITS chucks datum alignment or obtain



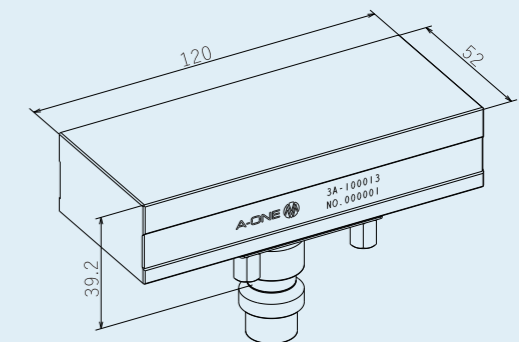
**3A-100031** 检测杆  
Checking pin Ø50

- ▶ 规格 系统尺寸 ITS50，硬质、磨削
- ▶ 应用 ITS 卡盘径向、轴向和角度位置的校正
- ▶ Version ITS system size 50. Hardened, ground
- ▶ Application Alignment of radial, axial and angular position of ITS chucks



**3A-100013** CNC 零位基准  
CNC zero point gauge

- ▶ 应用 用于卡盘X, Y, Z方向平行检测、校正
- ▶ Application Used to detect and correct the parallel of the X, Y, and Z directions of the chuck



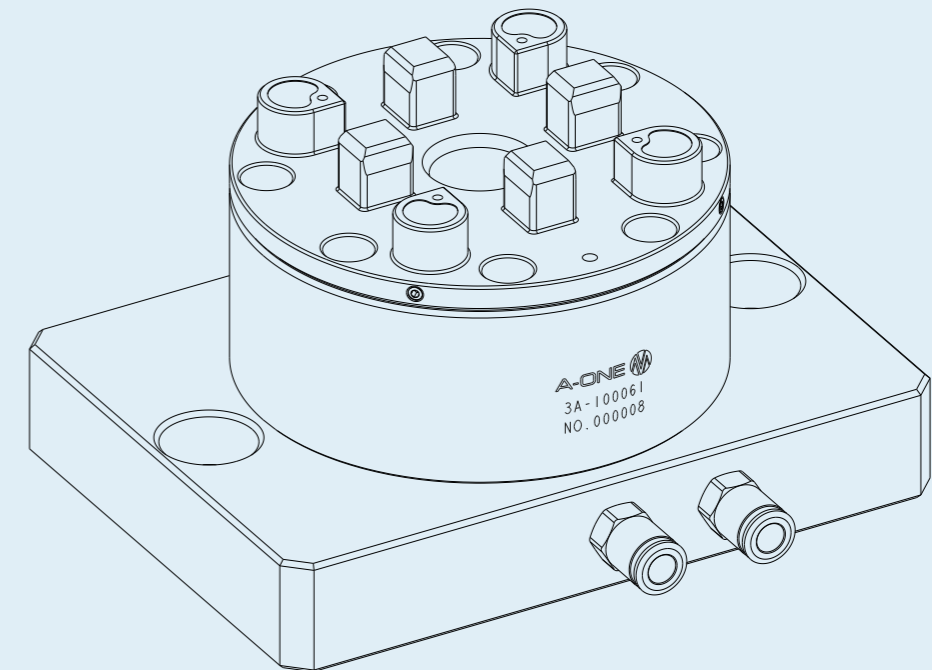


# R型系列夹具

## R Series fixture

<http://www.szjtools.com>  
<http://www.system3a.com>

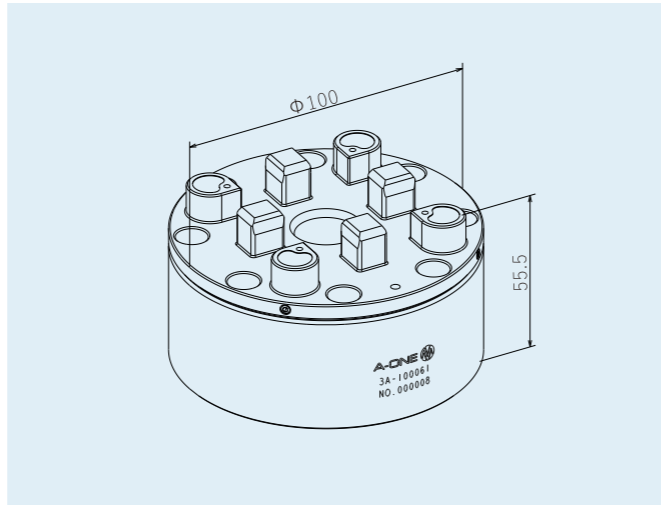
最新产品信息、公司资讯等敬请浏览本公司主页  
Please visit our homepage for the latest product information, company information, etc.



P.063~P.067

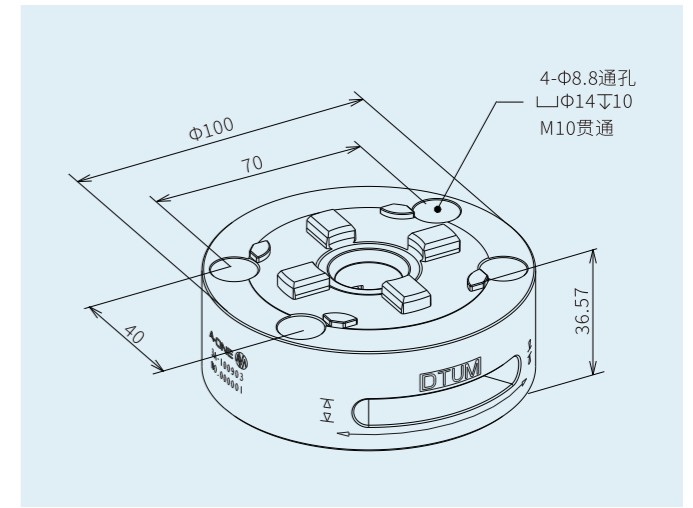
**3A-100061 R 型气动卡盘**  
R type automatic chuck

- ▶ 规格 解锁气压 0.6MPa  
固定分度位置 4\*90 度  
气喷清理 Z-M 基准面
- ▶ 夹紧力 6000N
- ▶ Version Unlocking air pressure is 0.6MPa  
Division value: 4\*90  
Air cleaning Z-M Datum side
- ▶ Clamping Power 6000N



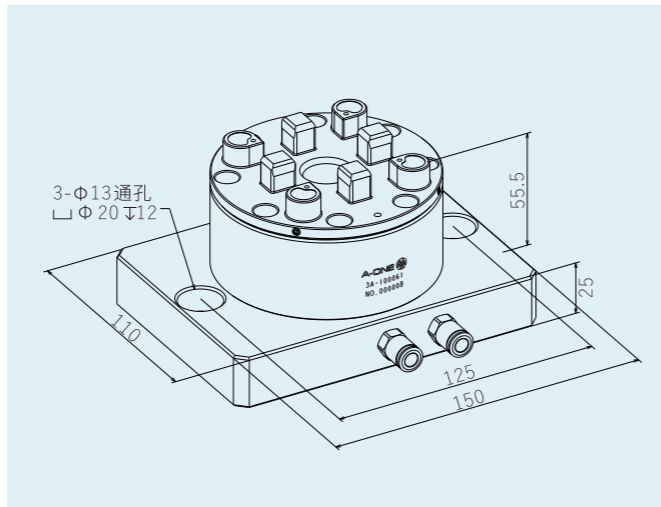
**3A-100903 R 型手动卡盘**  
R manual chuck

- ▶ 规格 不锈钢, 淬硬
- ▶ 夹紧力 8000N
- ▶ 应用 适用于加工中心、火花机、三坐标测量仪、磨床等加工和检测设备, 安装在工作台面或机床主轴上, 也可用于自动生产线
- ▶ Version Stainless steel, hardened
- ▶ Clamping Power 8000N
- ▶ Application To be used on cnc machining center, edm, coordinates measuring machine, grinding lathe etc processing and inspection equipment, mounted on work table or machine tool spindle, also can be used on automated production line



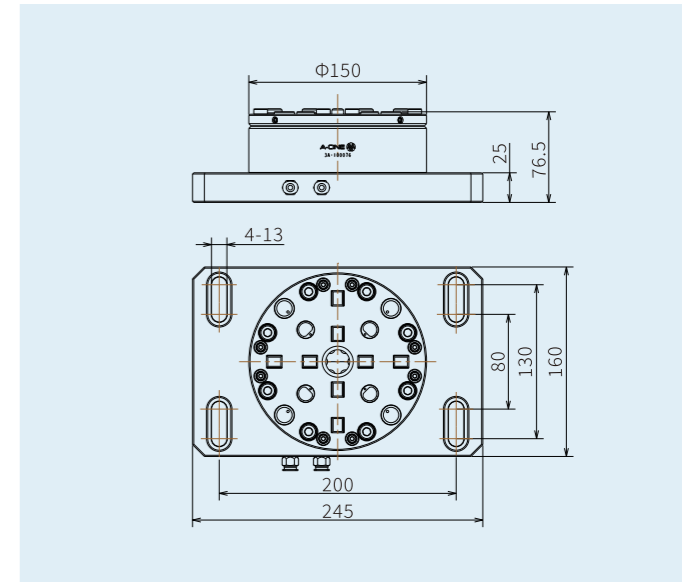
**3A-100062 R 型工作台卡盘**  
R Chuck with plate

- ▶ 规格 解锁气压 0.6MPa  
固定分度位置 4\*90 度  
气喷清理 Z-M 基准面  
侧面进气、防腐蚀
- ▶ 夹紧力 6000N
- ▶ Version Unlocking air pressure is 0.6MPa  
Division value: 4\*90  
Air cleaning Z-M Datum side  
Air connection on the side  
Resistant corrosion
- ▶ Clamping Power 6000N



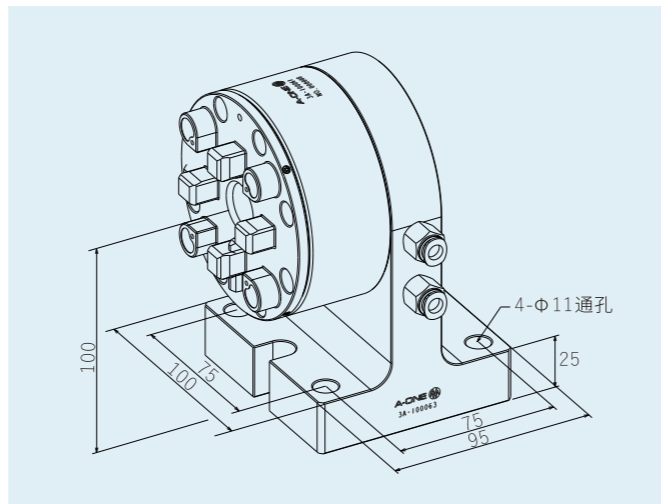
**3A-100076 R 150气动卡盘**  
**3A-100083 (不含底板) R 150 pneumatic chuck**

- ▶ 规格 解锁气压 0.6MPa、固定分度位置 4\*90 度  
气喷清理 Z-基准面
- ▶ 夹紧力 15000N
- ▶ 安装 带底板, 4-12螺丝安装过孔、适配 3A-400043 拉钉安装于机床工作台上
- ▶ 净重 12.39kg
- ▶ Version Unlocking air pressure is 0.6MPa,  
Division value: 4\*90  
Air cleaning Z-M Datum side
- ▶ Clamping Power 15000N
- ▶ Mounting With base plate, 4-12 screw mounting holes, used with drawbar 3A-400043, mounted on machine table
- ▶ Net weight 12.39kg



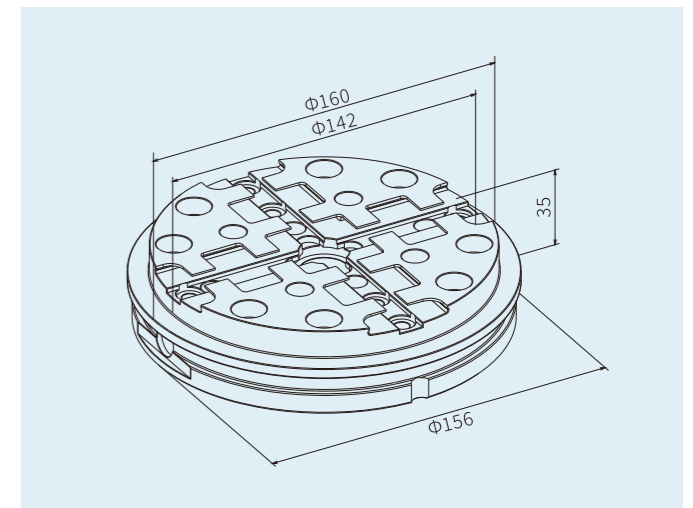
**3A-100063 R 型直角卡盘**  
R Vertical chuck

- ▶ 规格 气动锁紧功能, 可侧向四面加工, 含卡盘
- ▶ 夹紧力 6000N
- ▶ 安装 直接安装在工作台上
- ▶ 应用 用于 CNC 加工中心、磨床、铣床
- ▶ Version Power pneumatic lock, four sides of workpiece can be machined, with chuck
- ▶ Clamping Power 6000N
- ▶ Mounting To be mounted directly on the table of machining center
- ▶ Application Used on CNC grinding machine and milling machine



**3A-110088 R型托盘 Φ156**  
R type Plate Φ156

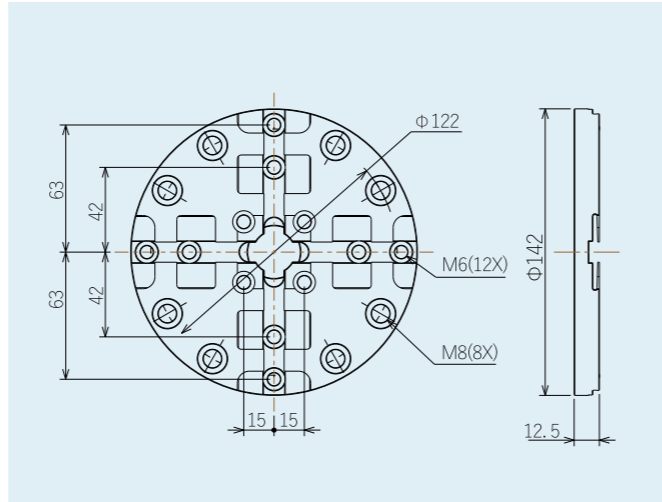
- ▶ 规格 钢, 耐腐蚀
- ▶ 应用 适用于自动更换
- ▶ 安装 带螺纹和通孔, 可安装 8 或 10 个固定螺丝
- ▶ 净重 5kg
- ▶ Version Steel, corrosion-resistant
- ▶ Application Adapted for automatic changing
- ▶ Mounting With threads and clearance holes for eight and ten fixing screws
- ▶ Net weight 5kg





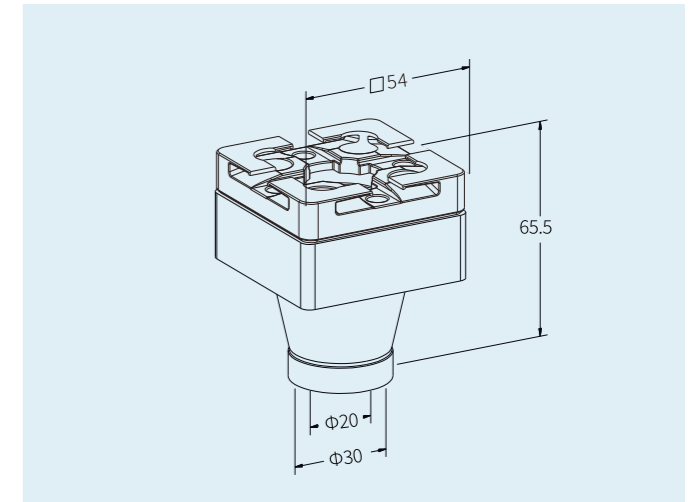
**3A-400141** R 强力定位片  
R power centering plate

- ▶ 规格 硬质基准片, 防锈
- ▶ 应用 先固定于工件或夹具的底部, 然后锁定在卡盘中
- ▶ 重量 1kg
- ▶ Version Hardened, rust-resistant
- ▶ Application Must be mounted on the workpiece/fixture before it is locked in a chuck
- ▶ Net weight 1kg



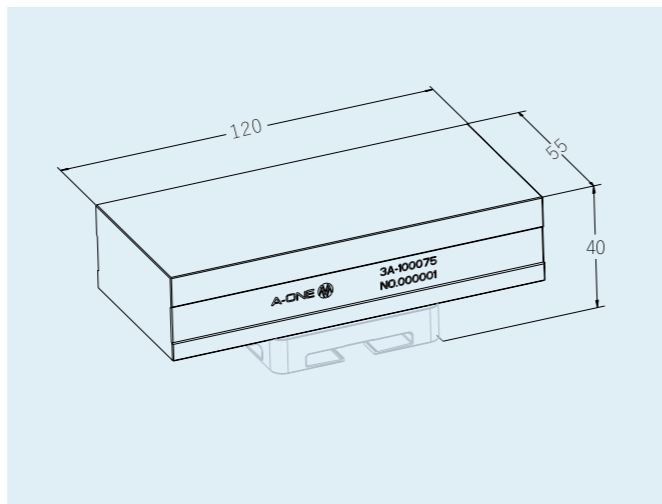
**3A-300027** R 型校正规  
R alignment rail

- ▶ 规格 测量长度为50mm
- ▶ 应用 用于调整角位, 磨削外径做中心调整之用
- ▶ Version Measuring length 50mm
- ▶ Application Used to adjust angle, grinding outside diameter for center adjustment



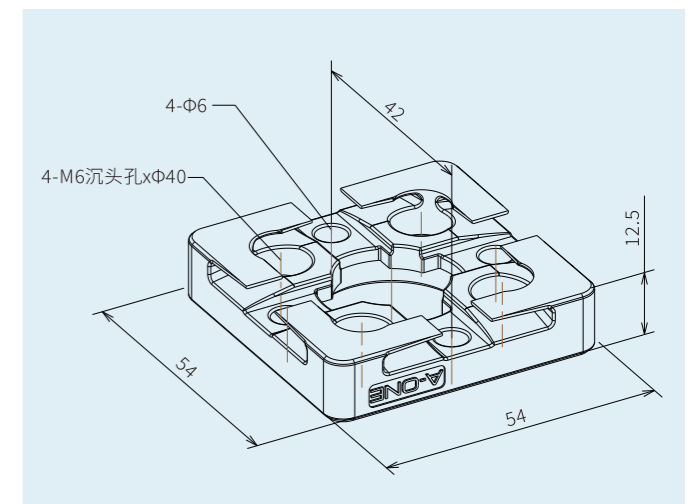
**3A-100075** R型平直规  
R type flat calibration gauge

- 应用 用于卡盘X、Y、Z方向平行检测, 校正
- Application Used for detection and correction of parallel X,Y and Z directions of the chuck



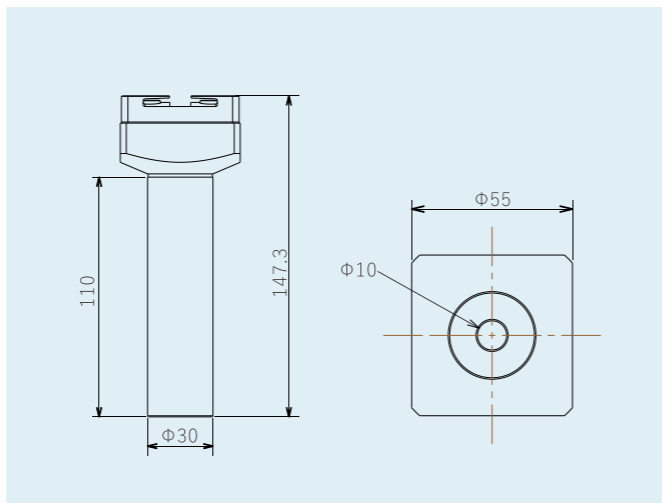
**3A-400008** R 型定位片  
R Centering plate

- ▶ 规格 用于铜电极和工件 54x54mm 淬火基准元件  
必须先安装在铜坯件/工件上
- ▶ 注意 对于石墨电极, 需使用垫板  
必须先被安装在工件或夹具上再夹入卡盘
- ▶ Version Reference Element 54\*54  
Side faces for copper electrodes and workpieces  
Must used plate if you clamp graphite
- ▶ Note Must be mounted on a workpiece/fixture before being clamped in the chuck



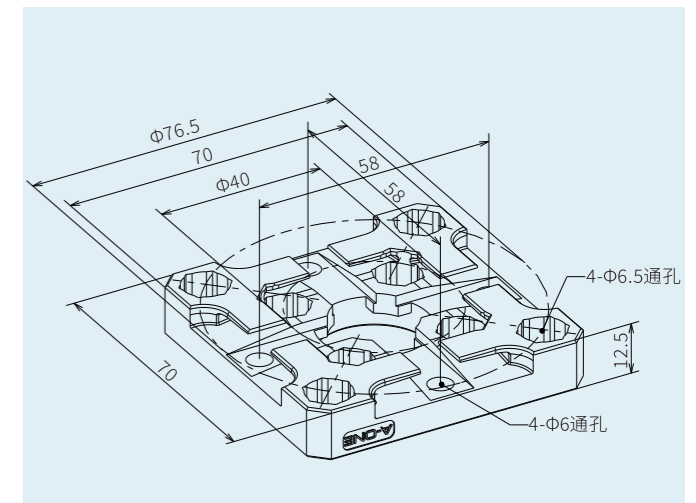
**3A-100056** R 型检测杆  
R type Checking pin

- ▶ 规格 测量长度 110mm
- ▶ 应用 适用于R型卡盘的校正和检测
- ▶ 基准 X、Y 外圆及中心孔
- ▶ Version Measuring length up to 110mm
- ▶ Application Alignment and measurement of R type chuck
- ▶ Benchmark X、Y axis, cylindrical and center hole



**3A-400090** R 型定位片 70X70  
R Centering Plate 70\*70

- ▶ 规格 用于铜电极和工件, 70x70mm, 淬火基准元件  
必须先安装在铜坯件/工件上
- ▶ 注意 对于石墨电极, 需使用垫板  
必须被安装在工件/夹具的卡盘被夹持前
- ▶ Version Reference Element 70\*70mm  
Side faces for copper electrodes and workpieces  
Must used plate if you clamp graphite
- ▶ Note Must be mounted on a workpiece/fixture before being clamped in the chuck

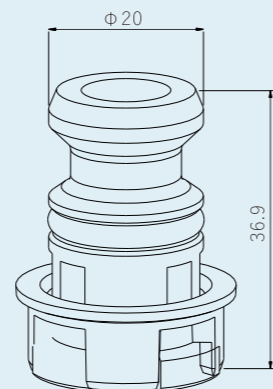


- 零点定位系统
- UPC系统
- 下拉圆柱夹具
- 基准卡盘
- R型系列夹具
- 自定心虎钳
- 零点定位快锁
- 夹紧装置
- 其他夹具

- 零点定位系统
- UPC系统
- 下拉圆柱夹具
- 基准卡盘
- R型系列夹具
- 自定心虎钳
- 零点定位快锁
- 夹紧装置
- 其他夹具

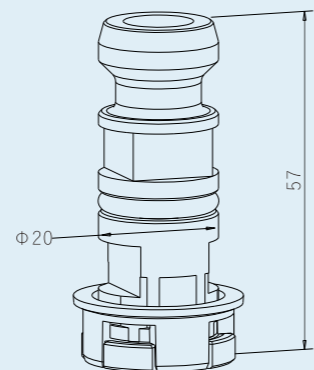
3A-400006 R型拉钉  
R Type drawbar

- ▶ 规格 Ø20 x36.9 mm, 带有 Ø7mm冲洗孔  
防锈  
单独供应
- ▶ 应用 可兼容R型产品, 配合手动卡盘使用
- ▶ Version Ø20\*36.9 mm with flushing holes Ø7 mm  
Rust-resistant  
Supply separately
- ▶ Application Compatible with R product, used with manual chuck



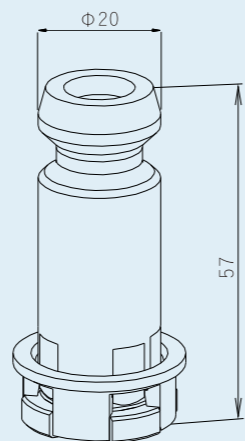
3A-400043 R型拉钉  
R Type drawbar

- ▶ 规格 Ø20 x 57mm 带有Ø7 mm冲洗孔  
防锈  
单独供应
- ▶ 应用 可兼容R型产品, 配合气动卡盘使用
- ▶ Version Ø20\*57 mm with flushing holes Ø7 mm  
Rust-resistant  
Supply separately
- ▶ Application Compatible with R product, used with pneumatic chuck



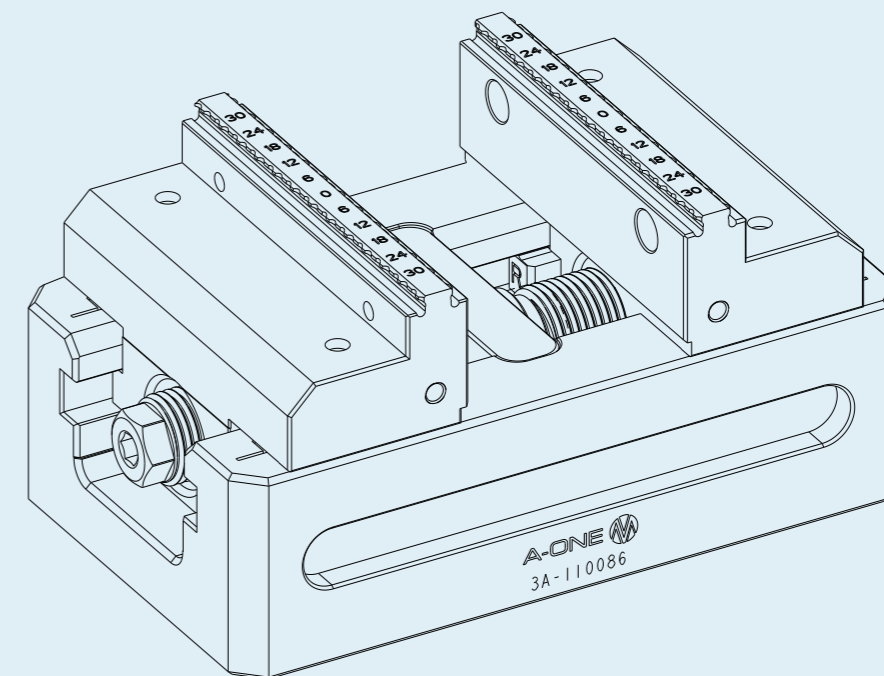
3A-400143 R型拉钉  
R Type drawbar

- ▶ 规格 Ø20 x 57mm 带有Ø10mm冲洗孔  
防锈  
单独供应
- ▶ 应用 可兼容R型产品, 配合气动卡盘使用
- ▶ Version Ø20\*57 mm with flushing holes Ø10mm  
Rust-resistant  
Supply separately
- ▶ Application Compatible with R product, used with pneumatic chuck



# 自定心虎钳

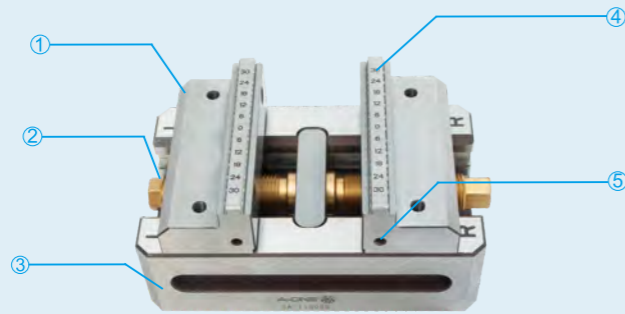
## Self Centering Vise



P.069~P.077



五轴咬合式硬爪虎钳  
Makro.Grip



特点:

Characteristics:

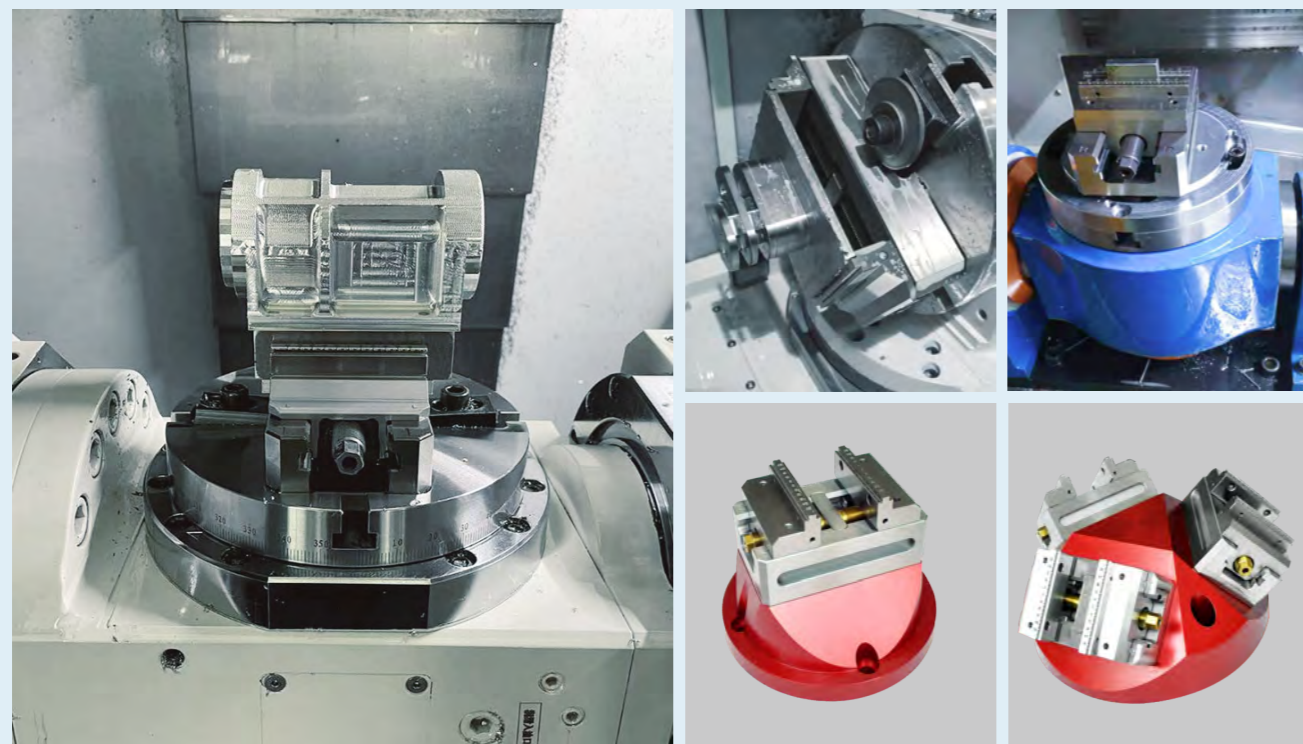
- 卡爪的光面可以用于无咬痕工件的夹持或已加工面的夹持;  
The smooth surface of the jaws can be used for clamping of workpieces without biting or clamping of machined surfaces
- 双导向长行程导轨, 丝杆螺母副驱动卡爪;  
Double guide long stroke guide, screw nut vice drive jaw
- 基体结构稳固, 经久耐用; 同时自重较轻, 方便手工上下料;  
The base structure is stable and durable; at the same time, the weight is light, and it is convenient for manual loading and unloading.
- 卡爪上端两面均带有咬齿, 能够在夹持3mm的高度上可靠夹紧工件;  
The upper end of the claw has a tooth on both sides, which can reliably clamp the workpiece at a height of only 3mm
- 预留螺纹底孔用于安装辅助定位装置; 可安装于A-ONE148托板或零点托板  
Reserved threaded bottom hole for mounting auxiliary positioning device; can be mounted on A-ONE ø148 pallet or zero point pallet

注意:

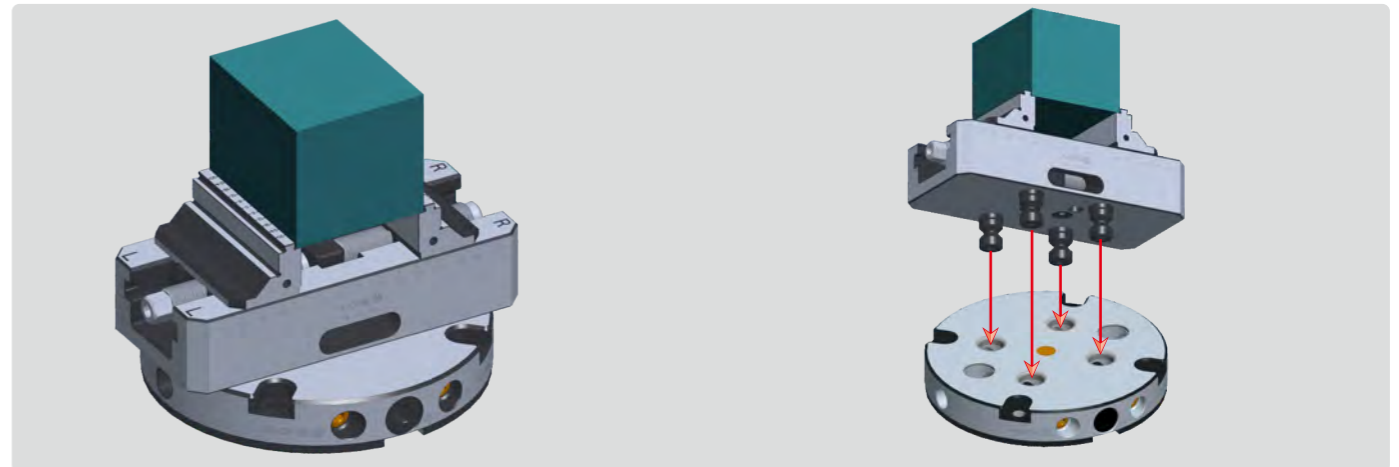
Note:

选配钳口时, 请注明虎钳型号及钳口名称, 不同型号虎钳的钳口不能互换使用!

When selecting jaws, please indicate the vise model and jaw name. The jaws of different types of vise cannot be used interchangeably!

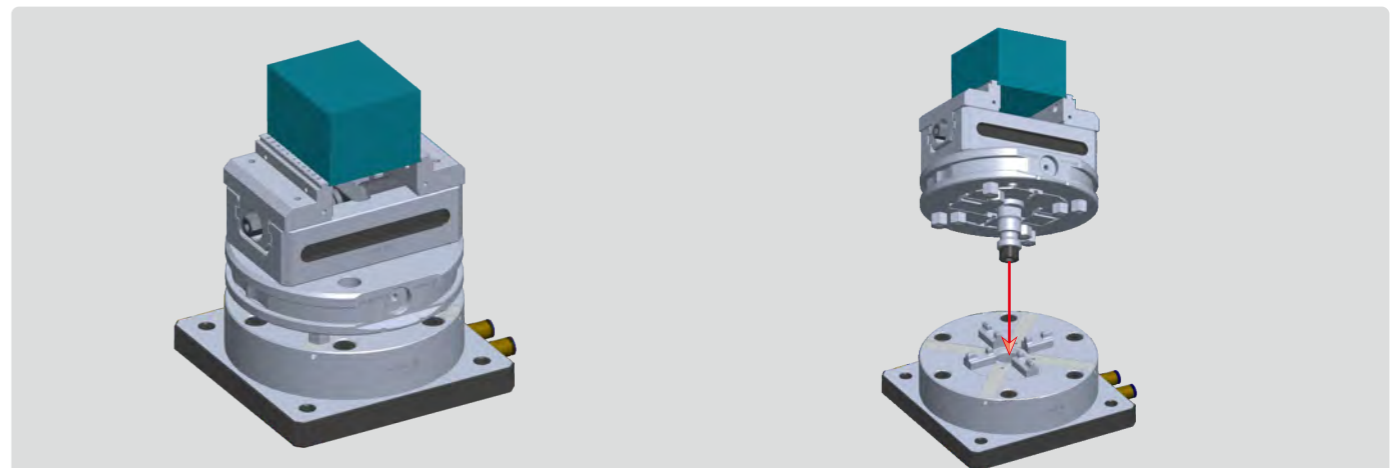


1 匹配组合零定位快锁系统运用  
Application of matching combination zero point quick locking system

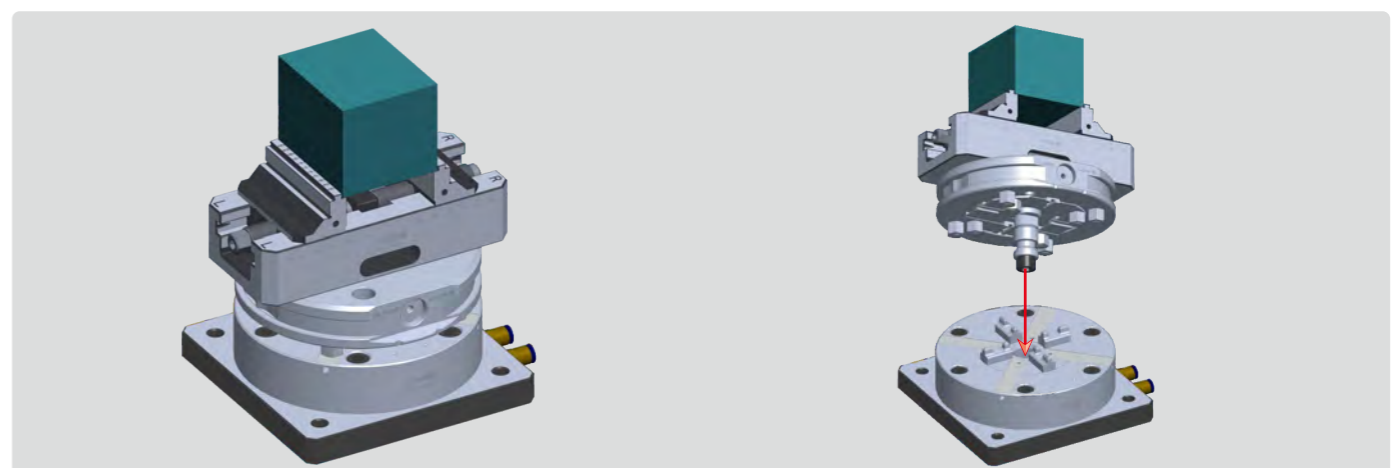


3A-110160自定心虎钳匹配3A-110165零点定位单工位板组合运用  
Application of Self centering vise 3A-110160 matching zero point single plate 3A-110165

2 匹配组合ITS系列卡盘运用  
Application of matching combination ITS series chuck

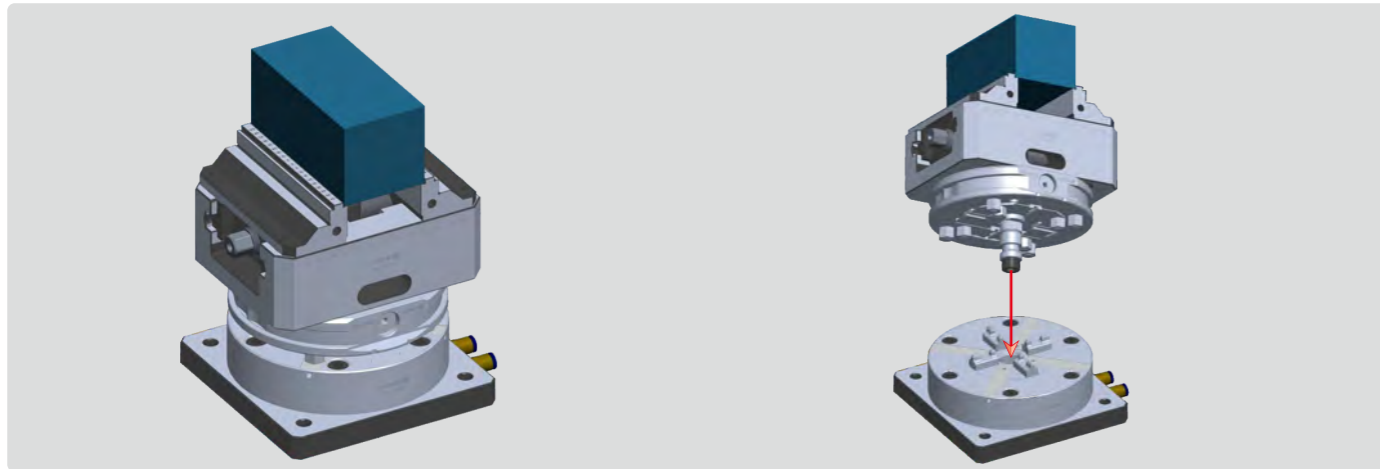


3A-110086自定心虎钳匹配3A-100050强力卡盘组合运用  
Application of Self centering vise 3A-110086 matching Power chuck 3A-100050



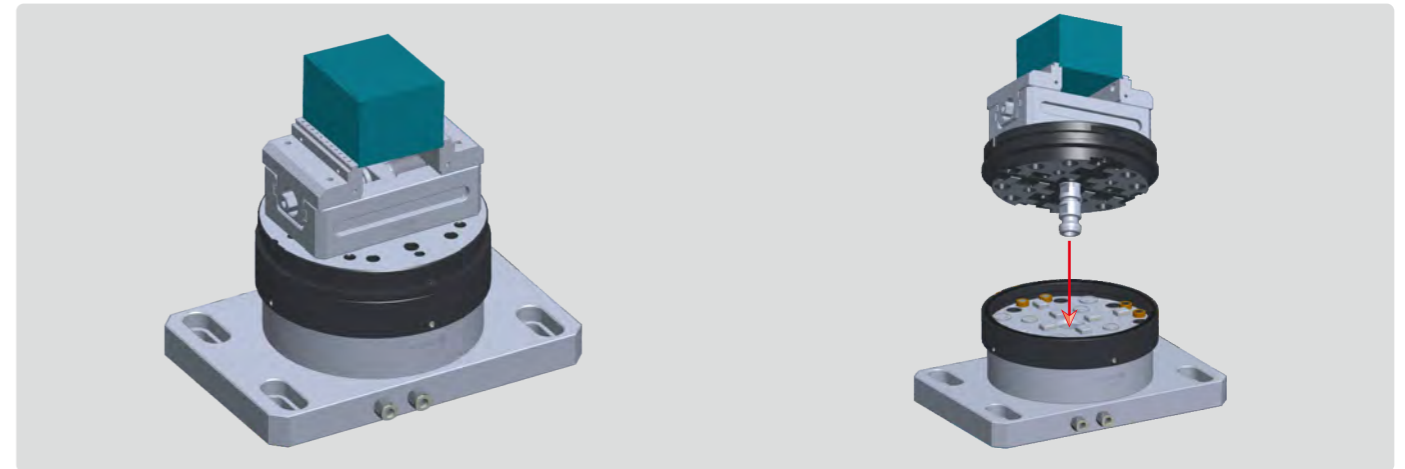
3A-110160自定心虎钳匹配3A-100050强力卡盘组合运用(定制)  
Application of Self centering vise 3A-110160 matching Power chuck 3A-100050(customize)

自定心虎钳



3A-110185自定心虎钳匹配3A-100050强力卡盘组合运用(定制)  
Application of Self centering vise 3A-110185 matching Power chuck 3A-100050(customize)

2 匹配组合R型系列卡盘运用  
Application of matching combination R type series chuck



3A-110086自定心虎钳匹配3A-100076 R150气动卡盘组合运用(定制)  
Application of Self centering vise 3A-110086 matching R150 pneumatic chuck 3A-100076(customize)

自定心虎钳

零点定位系统

UPC系统

下拉圆柱夹具

基准卡盘

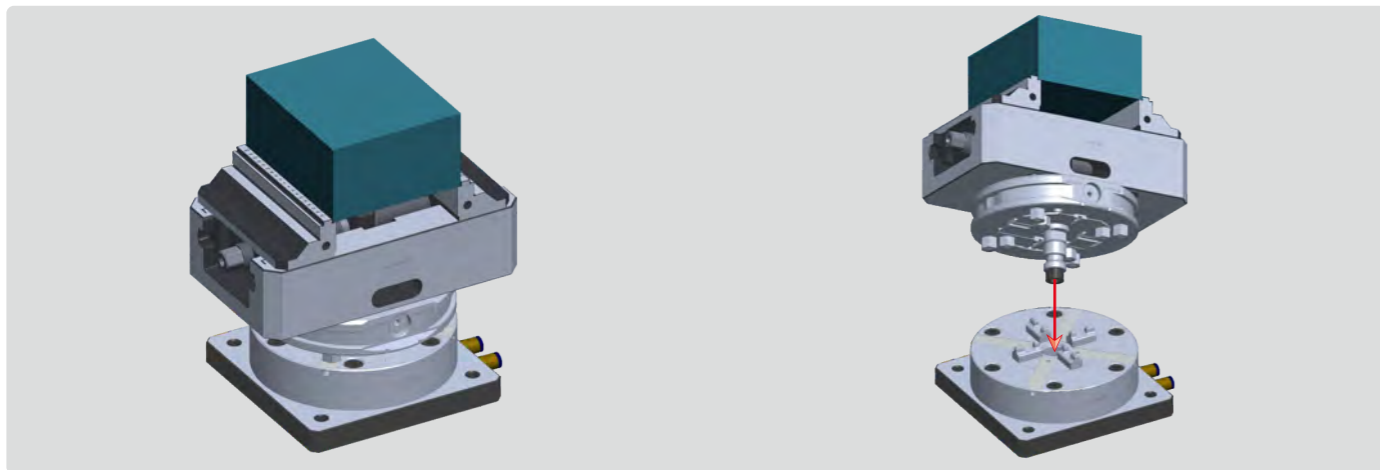
R型系列夹具

自定心虎钳

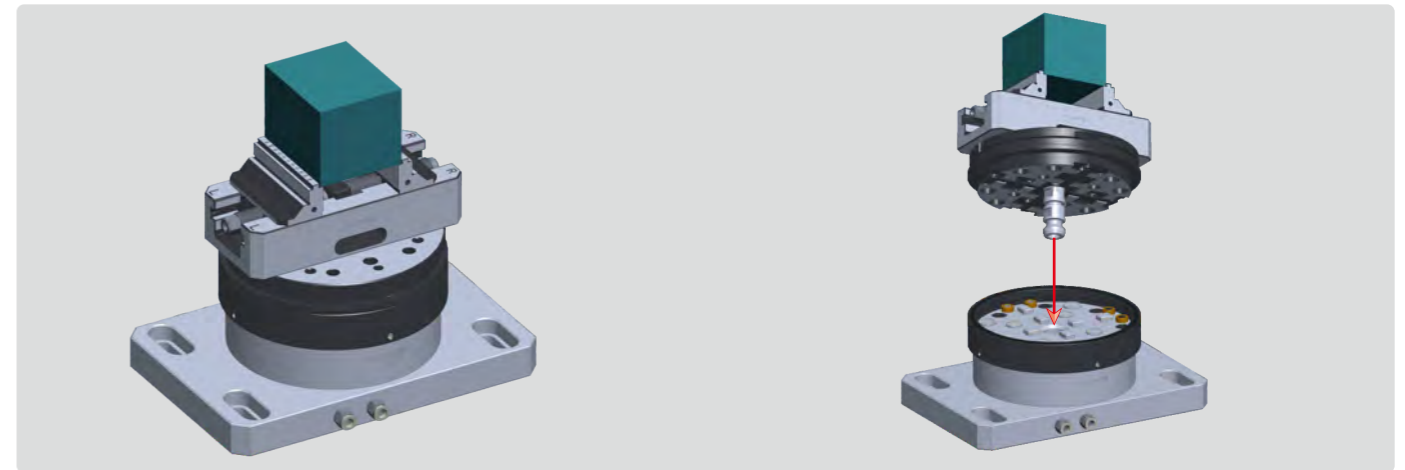
零点定位快锁

夹紧装置

其他夹具



3A-110186自定心虎钳匹配3A-100050强力卡盘组合运用(定制)  
Application of Self centering vise 3A-110186 matching Power chuck 3A-100050(customize)



3A-110160自定心虎钳匹配3A-100076 R150气动卡盘组合运用(定制)  
Application of Self centering vise 3A-110160 matching R150 pneumatic chuck 3A-100076(customize)

零点定位系统

UPC系统

下拉圆柱夹具

基准卡盘

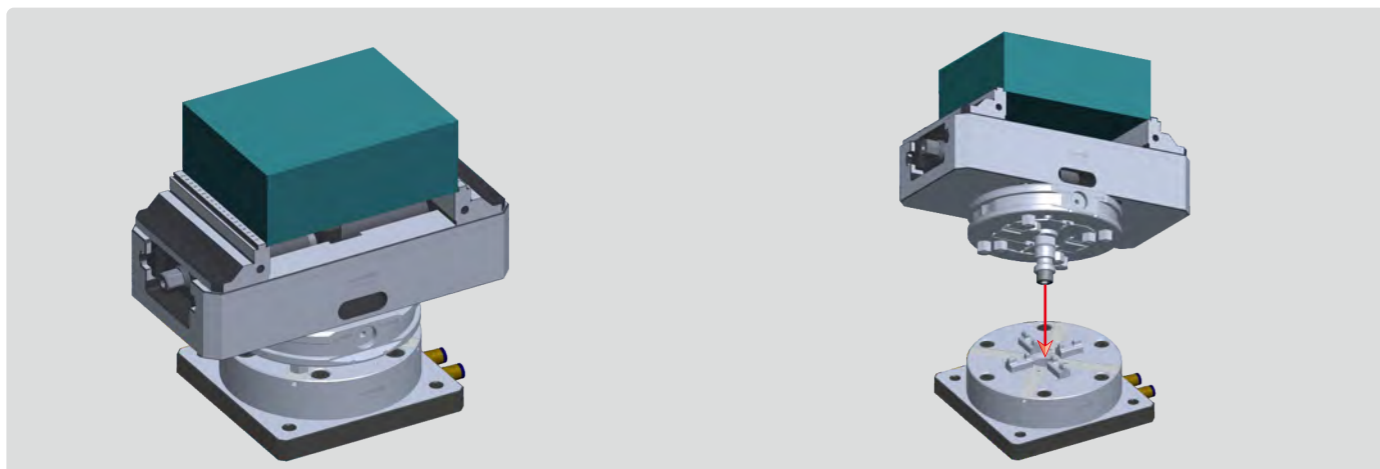
R型系列夹具

自定心虎钳

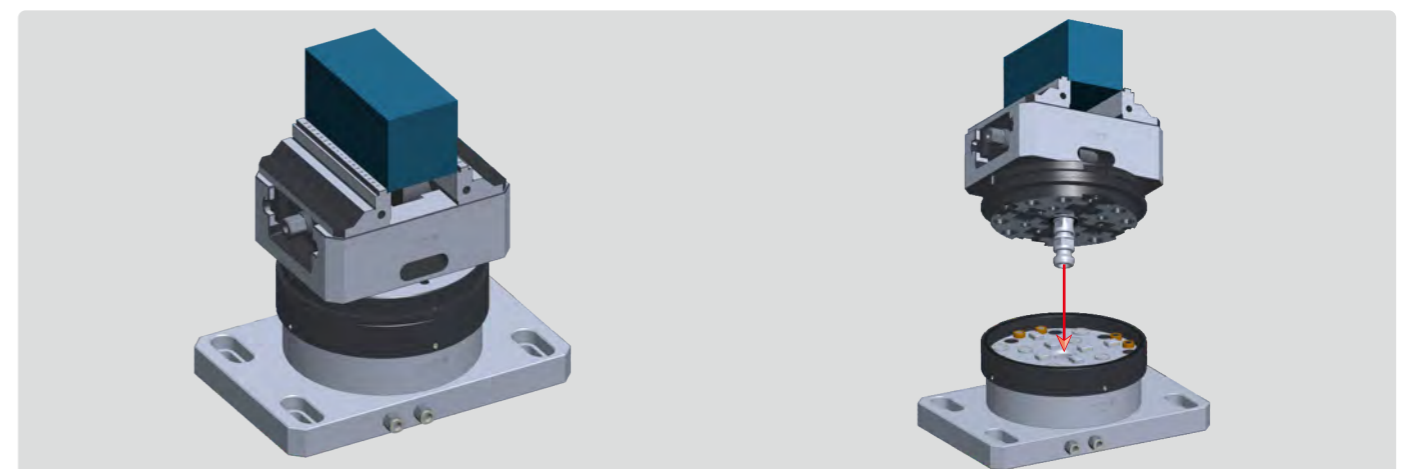
零点定位快锁

夹紧装置

其他夹具



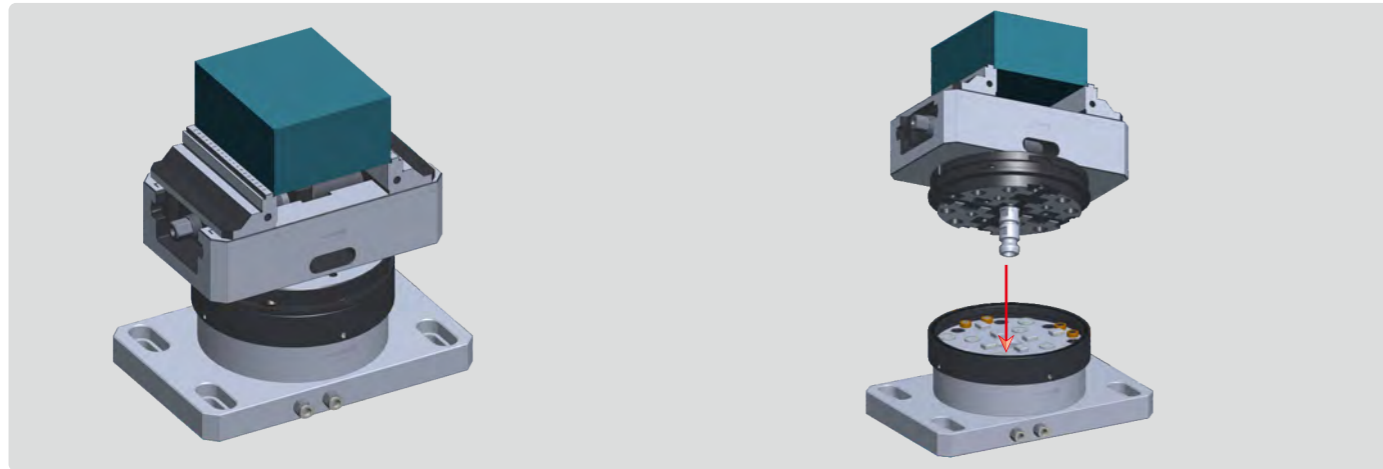
3A-110187自定心虎钳匹配3A-100050强力卡盘组合运用(定制)  
Application of Self centering vise 3A-110187 matching Power chuck 3A-100050(customize)



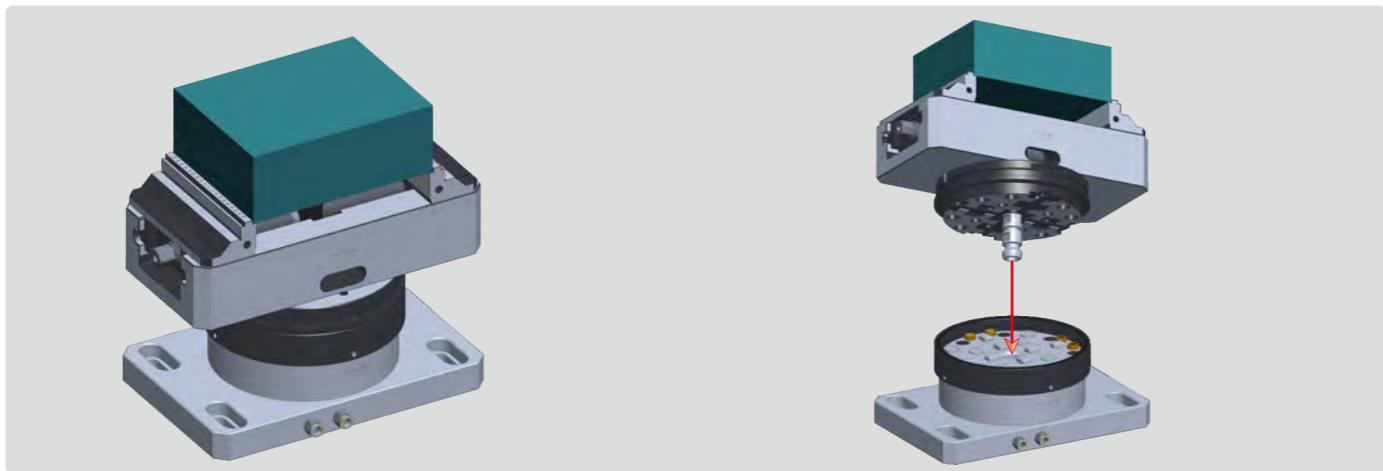
3A-110185自定心虎钳匹配3A-100076 R150气动卡盘组合运用(定制)  
Application of Self centering vise 3A-110185 matching R150 pneumatic chuck 3A-100076(customize)



自定心虎钳

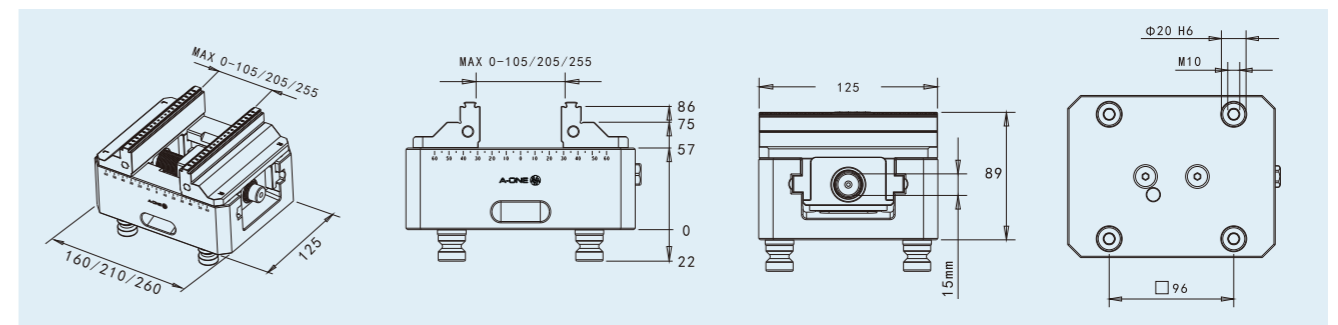
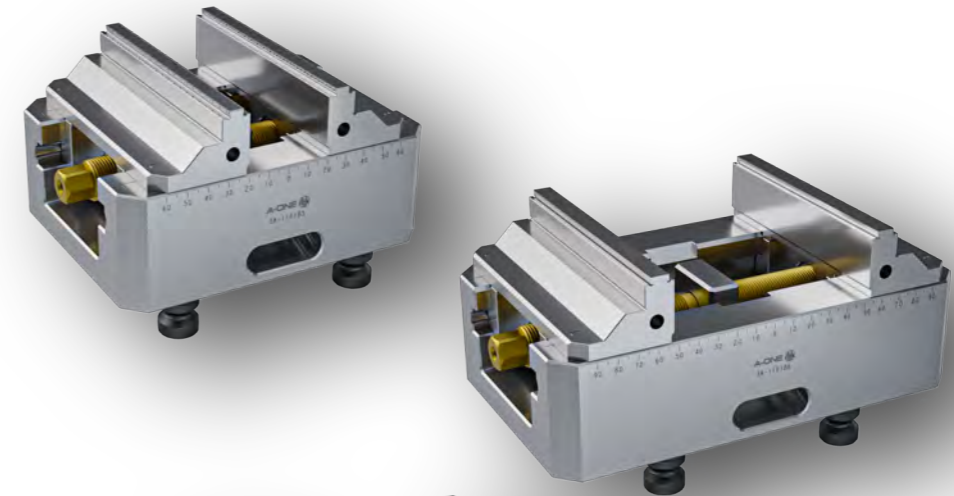


3A-110186自定心虎钳匹配3A-100076 R150气动卡盘组合运用(定制)  
Application of Self centering vise 3A-110186 matching R150 pneumatic chuck 3A-100076(customize)



3A-110187自定心虎钳匹配3A-100076 R150气动卡盘组合运用(定制)  
Application of Self centering vise 3A-110187 matching R150 pneumatic chuck 3A-100076 (customize)

自定心虎钳



编号 Model NO.	基座长度 Base Length	夹持尺寸 Clamping Range	最大扭矩 Max. driving torque
3A-110185	160mm	0 - 155mm	100Nm
3A-110186	210mm	0 - 205mm	100Nm
3A-110187	260mm	0 - 255mm	100Nm

零点定位系统

UPC系统

下拉圆柱夹具

基准卡盘

R型系列夹具

自定心虎钳

零点定位快锁

夹紧装置

其他夹具

零点定位系统

UPC系统

下拉圆柱夹具

基准卡盘

R型系列夹具

自定心虎钳

零点定位快锁

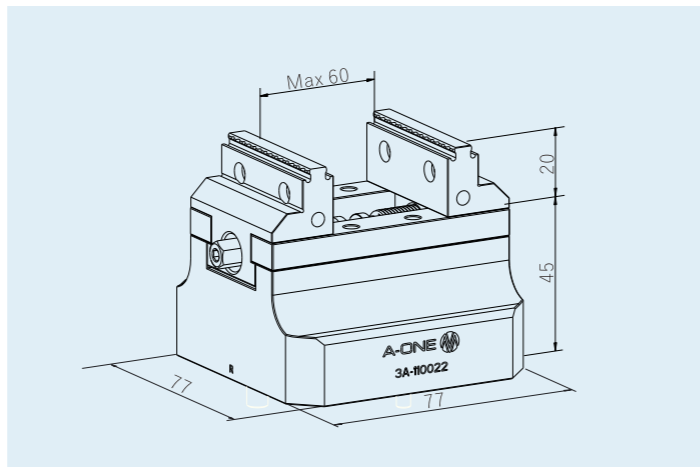
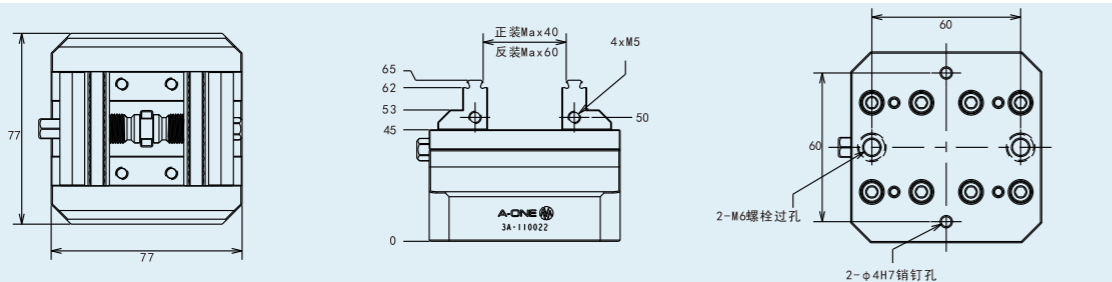
夹紧装置

其他夹具

**3A-110022** 小虎钳  
Small vise

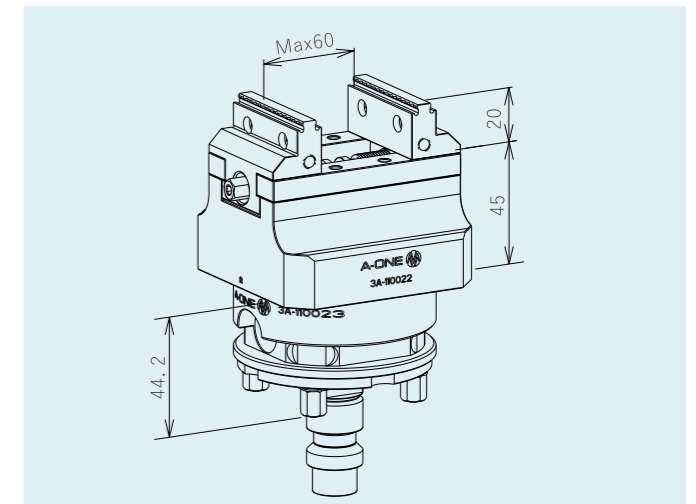
- ▶ 规格 双向自定中心, 重复精度小于0.01mm, 两个M6螺丝连接工作台或托板, 最大可夹持工件尺寸60mm, 最大夹持力为6000N, 驱动扭矩最大为20Nm
- ▶ 应用 适用于立式和卧式精密加工设备, 一次加工五个面, 特殊钳口可定制
- ▶ Version Double action self centered and repeating accuracy less than 0.01mm, To be fixed on the machine table or base plate with 2-M6 bolts, Maximum work piece size 60mm, Max. clamping force 6000N, Max. driving torque is 20Nm
- ▶ Application Suitable for vertical and horizontal precision processing machine, for 5-axis machining per time, Special jaw can be customized

安装孔位尺寸图 Mounting hole size diagram



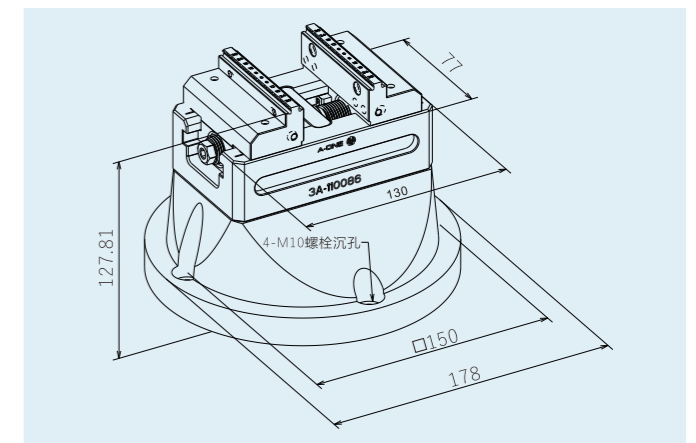
**3A-110036** 小虎钳套装  
Small vise set

- ▶ 规格 系统尺寸 ITS 50,  $\phi 72$ 机械握爪位, 含夹紧拉钉
- ▶ 应用 适用于 ITS 接口的精密加工设备及自动化生产线
- ▶ Version System size ITS 50,  $\phi 72$  machining for gripper, including bolt
- ▶ Application For ITS interface of precision machining equipment and automated production line



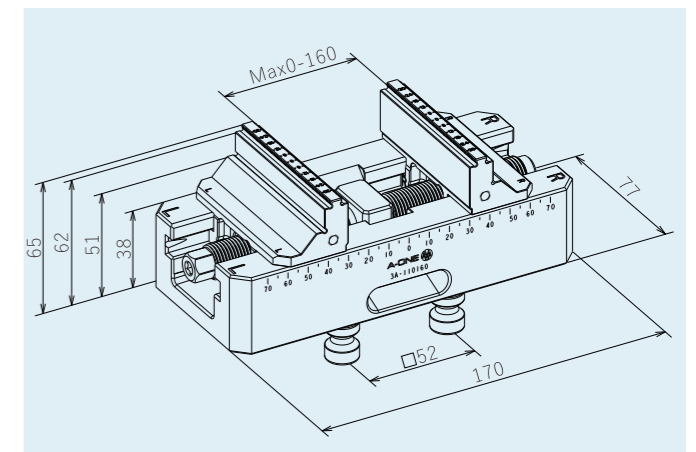
**3A-110150** 单虎钳台座  
Single vise base

- ▶ 规格 标配3A-110086自定心虎钳, 台座可根据工作台尺寸定制
- ▶ 应用 适用于五轴加工, 一次可加工五个面
- ▶ 注意 虎钳需另购
- ▶ Version Standard self-centering vise 3A-110086, the base can be customized according to the size of the worktable
- ▶ Application Suitable for 5-axis machining, five axis can be machined at one time
- ▶ Note Vise supplied separately



**3A-110160** 自定心虎钳  
Self centering vise

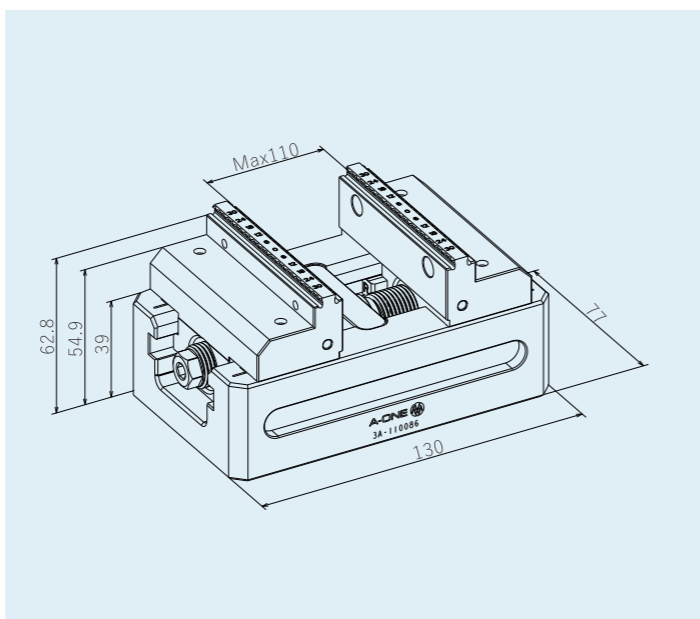
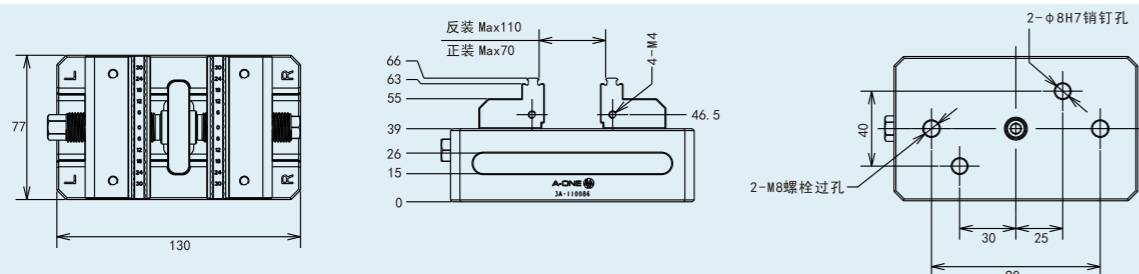
- ▶ 规格 双向自定中心, 重复精度小于0.02mm, 最大夹持力为14000N, 固定中心距为52mm, 使用 $\phi 16$ 拉钉固定于工作台或托板上, 驱动扭矩最大70Nm
- ▶ 应用 适用于立式和卧式精密加工设备, 一次加工五个面, 特殊钳口可定制。
- ▶ Version Double action self centered, repeating accuracy less than 0.02mm, Max. clamping force 14000N, fixed center distance is 52mm, to be fixed on the machine table or pallet with  $\phi 16$  spigots, Max. driving torque is 70Nm.
- ▶ Application Suitable for vertical and horizontal precision processing machine, for 5-axis machining per time, Special jaws can be customized.



**3A-110086** L130求心虎钳  
L130 Self centering vise

- ▶ 规格 双向自定中心, 重复精度小于0.01mm, 两个M8螺丝连接工作台或托板, 最大可夹持工件尺寸110mm, 最大夹持力为14000N, 驱动扭矩最大为70Nm
- ▶ 应用 适用于立式和卧式精密加工设备, 一次加工五个面, 特殊钳口可定制
- ▶ 注意 可搭配托板 $\phi 148$ 配合强力卡盘3A-100050使用, 托板 $\phi 148$ 搭配自定心虎钳使用时, 托板 $\phi 148$ 需添加安装孔
- ▶ Version Double action self centered and repeating accuracy less than 0.01mm, To be fixed on the machine table or base plate with 2-M8 bolts, Maximum work piece size 110mm, Max. clamping force 14000N, Max. driving torque is 70Nm.
- ▶ Application Suitable for vertical and horizontal precision processing machine, for 5-axis machining per time, Special jaw can be customized.
- ▶ Note Hexagonal wrench is supplied separately. It can be used with pallet  $\phi 148$  and powerful chuck 3A-100050. When pallet  $\phi 148$  is used with self centering vise, mounting holes should be added for pallet  $\phi 148$ .

安装孔位尺寸图 Mounting hole size diagram





自定心虎钳

左右爪(左端夹爪+右端夹爪)  
Jaws (Left jaw + Right jaw)

- ▶ 应用 (3A-110160-02左爪、3A-110160-03右爪)与3A-110160配合使用  
(3A-110185-02左爪、3A-110185-03右爪)与3A-110185/3A-110186/  
3A-110187配合使用
- ▶ Application (3A-110160-02 left jaw、3A-110160-03 right jaw) used in  
conjunction with 3A-110160  
  
(3A-110185-02 left jaw、3A-110185-03 right jaw) used in  
conjunction with 3A-110185/3A-110186/3A-110187

爪宽 Claw width	编号 Model NO	重量 Weight	单位 Unit
77mm	3A-110160-02	0.8kg	1对(1set)
	3A-110160-03		
125mm	3A-110185-02	2.6kg	1对(1set)
	3A-110185-03		

丝杆基座(自定心丝杆+定心基座)  
Screw base(Self-centering screw + Centering base)

- ▶ 规格 搭配自定心虎钳3A-110160、3A-110185、3A-110186、  
3A-110187使用
- ▶ Version Use with Self centering vise 3A-110160、3A-110185、  
3A-110186、3A-110187

编号 Model NO	丝杆长度 Screw length	装配 Assembly	重量 Weight	单位 Unit
3A-110160-04	169mm	3A-110160	0.3kg	1套(1set)
3A-110160-05				
3A-110160-06				
3A-110185-04	164mm	3A-110185	0.7kg	1套(1set)
3A-110185-05				
3A-110185-06				
3A-110186-02	214mm	3A-110186	0.7kg	1套(1set)
3A-110185-05				
3A-110185-06				
3A-110187-02	264mm	3A-110187	0.9kg	1套(1set)
3A-110185-05				
3A-110185-06				

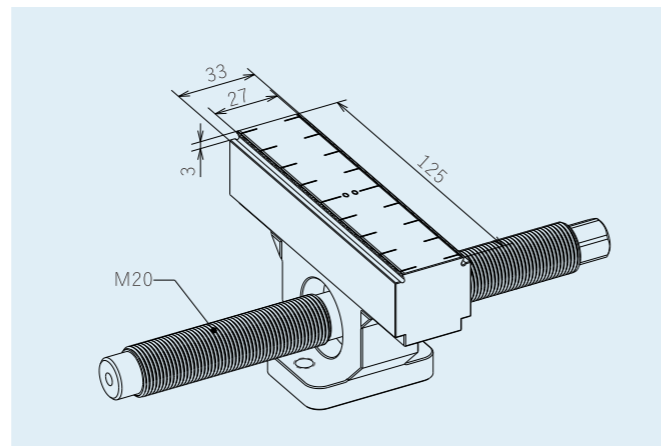
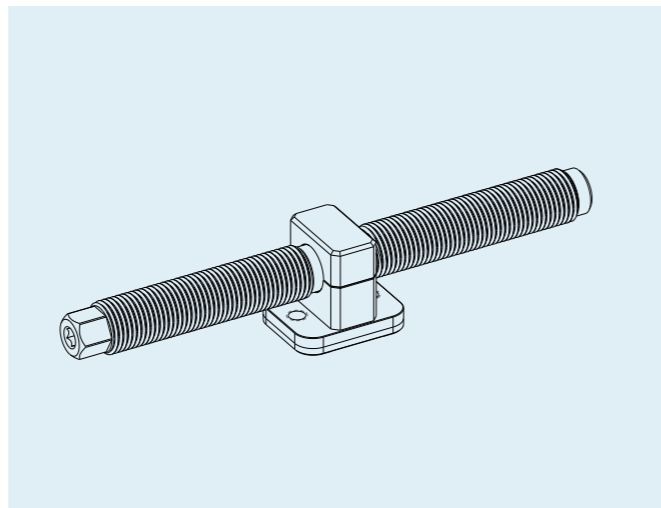
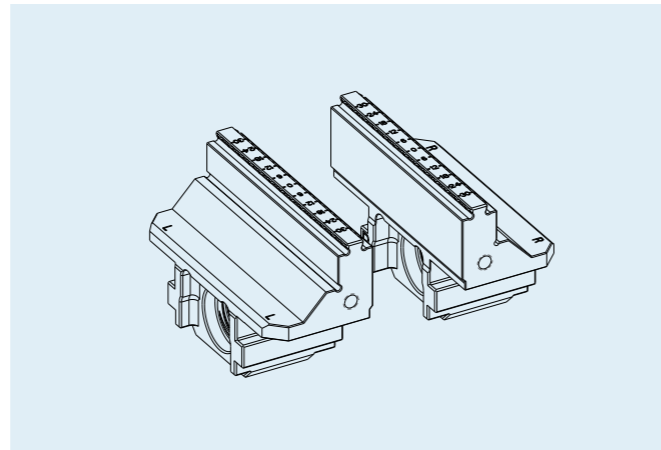
3A-110197 中心钳口(含丝杆)  
Center jaw (with screw rod)

- ▶ 规格 搭配自定心虎钳3A-110185、3A-110186、3A-110187使用
- ▶ Version Use with Self centering vise 3A-110185、3A-110186、  
3A-110187

编号 Model NO	丝杆长度 Screw length	装配 Assembly	重量 Weight	单位 Unit
3A-110197-01	164mm	3A-110185	1.75kg	1套(1set)
3A-110185-04				
3A-110197-01	214mm	3A-110186	1.86kg	1套(1set)
3A-110186-02				
3A-110197-01	264mm	3A-110187	1.97kg	1套(1set)
3A-110187-02				

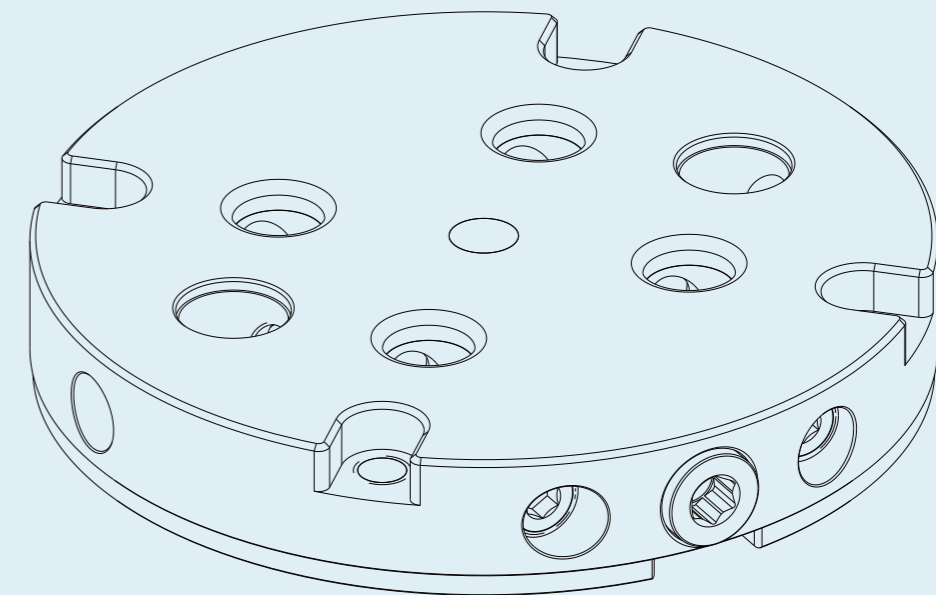
六角扳手  
Hexagon bar wrench

内六角规格 Insider hexagonal specifications	外六角规格 Outer hexagonal specifications	对应虎钳 Corresponding vise	单位 Unit
4mm	8mm	3A-110022	1套(1set)
5mm	12mm	3A-110086	1套(1set)
		3A-110160	
5mm	15mm	3A-110185	1套(1set)
		3A-110186	
		3A-110187	
-	15mm	3A-110226	1件(1piece)

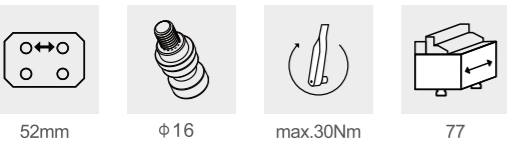
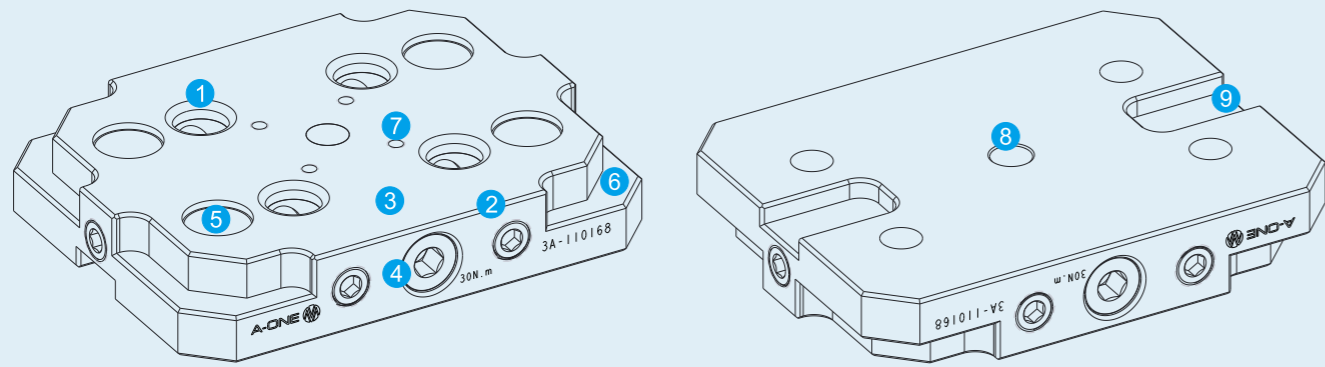


# 零定位快锁系统

## Zero Point Quick Locking System



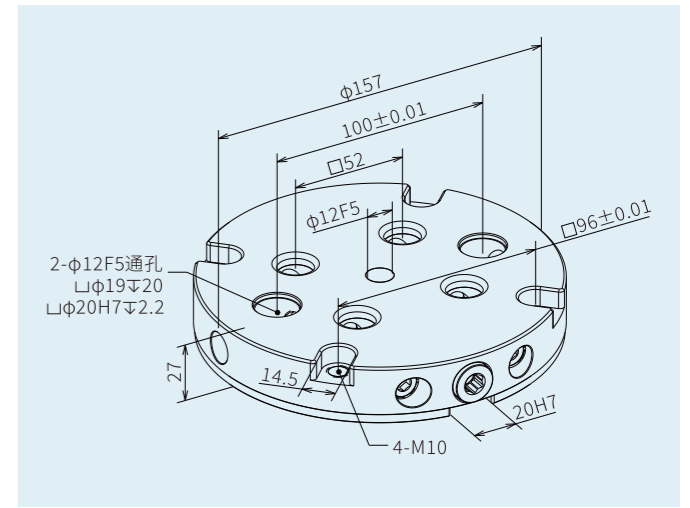
P.079~P.090



- ▶ 1. 中心距为52mm, 扭矩30Nm, 适用于 φ16拉钉,配合77mm钳口宽的自定心虎钳使用  
1. The center distance is 52mm and the torque is 30nm, which is suitable for φ 16 spigt, used with self centering vice with 77mm jaw width.
- ▶ 2. 厚度为27mm的零点系统  
2. Zero point system with thickness of 27mm.
- ▶ 3. 坚固的夹具主体, 热处理后表面磨削成型, 坚固耐磨的机械结构, 经久耐用  
3. Solid fixture body, surface grinding after heat treatment, solid and wear-resistant mechanical structure, durable.
- ▶ 4. 通过拧紧螺丝或快速锁定, 快速释放, 实现强大的机械张力  
4. Strong mechanical tension is achieved by tightening screws or quick locking and quick release.
- ▶ 5. 安装孔位  
5. Mounting bores position.
- ▶ 6. 边缘压板位, 可使用压板将其固定在工作台上  
6. The edge pressing plate can be fixed on the workbench by pressing plate.
- ▶ 7. 4×M5螺纹作为夹紧装置的定位辅助工具  
7. 4× M5 thread as positioning aid of clamping devices.
- ▶ 8. φ 12F5精孔  
8. φ 12F5 fine hole.
- ▶ 9. 机床工作台上用于轴向对准的20H7键槽(预留加工余量0.4mm)  
9. 20H7 keyway for axial alignment on machine tool workbench(with a reserved machining allowance of 0.4mm) .

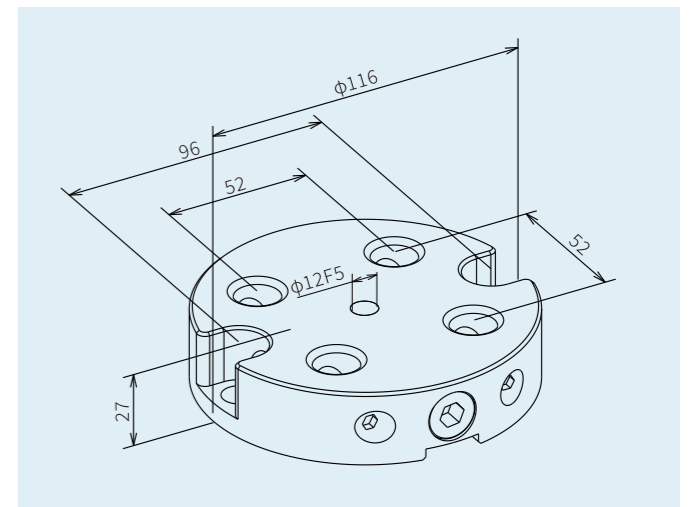
**3A-110165** 零点定位单工位板  
Zero point positioning single station plate

- ▶ 规格 φ157x27mm,使用φ16拉钉  
中心距52mm, 扭矩30Nm, 安装孔距离为100 mm
- ▶ 净重 3.5kg
- ▶ Version φ157x27mm,use with φ16 drawbar  
Set-up distance 52mm,Torque 30Nm  
with mounting bores at a distance of 100 mm
- ▶ Net weight 3.5kg



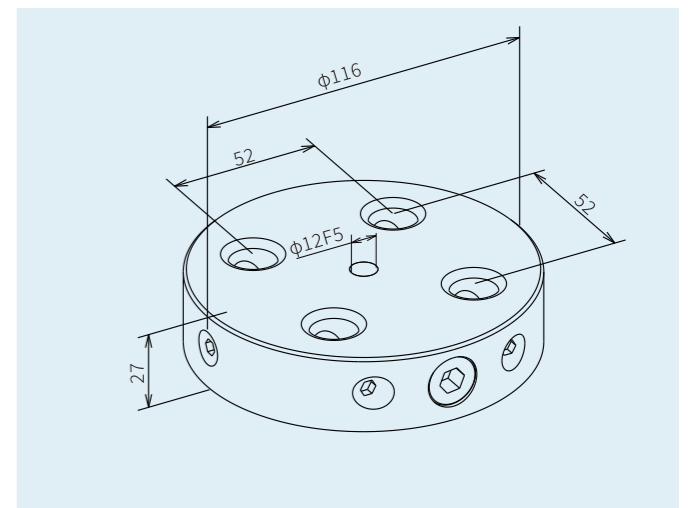
**3A-110170** 零点定位单工位板  
Zero point positioning single station plate

- ▶ 规格 φ116x27mm,使用φ16拉钉  
中心距52mm, 扭矩30Nm, 安装孔距离为96 mm
- ▶ 净重 1.9kg
- ▶ Version φ116x27mm,use with φ16 drawbar, Set-up distance 52mm,  
Torque 30Nm,with mounting bores at a distance of 96 mm
- ▶ Net weight 1.9kg



**3A-110171** 零点定位单工位板  
Zero point positioning single station plate

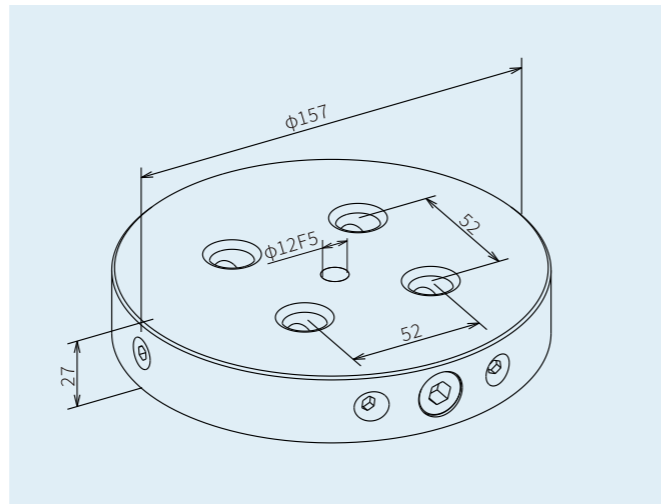
- ▶ 规格 φ116x27mm,使用φ16拉钉  
中心距52mm, 扭矩30Nm, 不带安装孔
- ▶ 注意 可根据客户要求设计安装孔和键槽
- ▶ 净重 2.1kg
- ▶ Version φ116x27mm,use with φ16 drawbar,  
Set-up distance 52mm,Torque 30Nm  
without mounting bores
- ▶ Note Mounting holes and keyways can be designed  
according to customer requirements
- ▶ Net weight 2.1kg





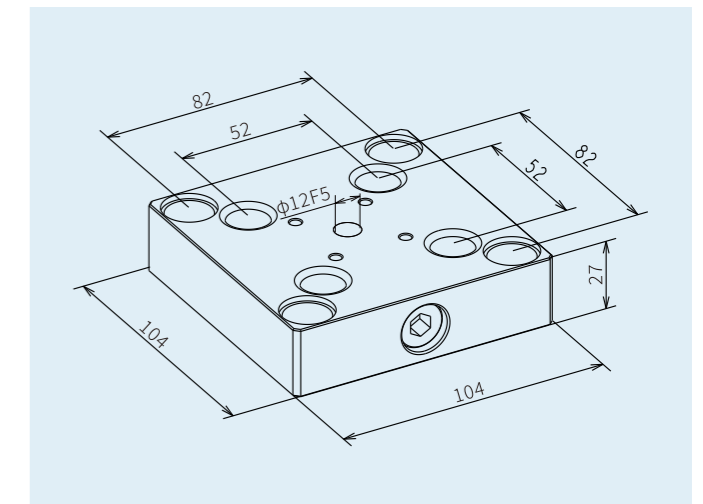
**3A-110172** 零点定位单工位板  
Zero point positioning single station plate

- ▶ 规格  $\phi 157 \times 27$ mm, 使用 $\phi 16$ 拉钉  
中心距52mm, 扭矩30Nm, 不带安装孔
- ▶ 注意 可根据客户要求设计安装孔和键槽
- ▶ 净重 3.8kg
- ▶ Version  $\phi 157 \times 27$ mm, use with  $\phi 16$  drawbar,  
Set-up distance 52mm, Torque 30Nm, without mounting bores
- ▶ Note Mounting holes and keyways can be designed  
according to customer requirements
- ▶ Net weight 3.8kg



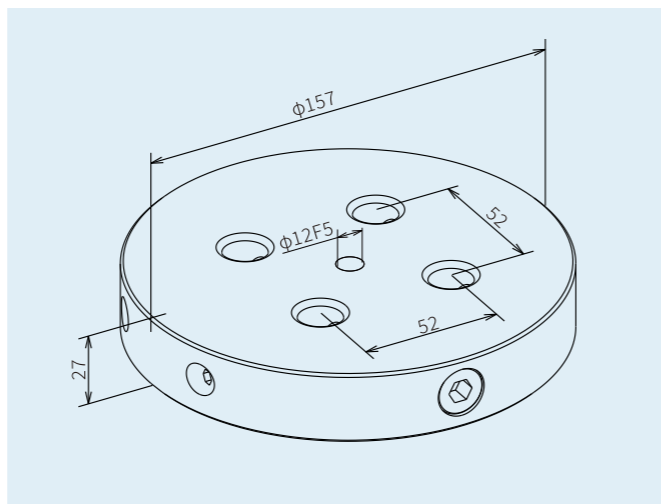
**3A-110167** 零点定位单工位板  
Zero point positioning single station plate

- ▶ 规格 104x104x27mm, 使用 $\phi 16$ 拉钉  
中心距52mm, 扭矩30Nm, 带有安装孔
- ▶ 净重 1.8kg
- ▶ Version 104x104x27mm, use with  $\phi 16$  drawbar,  
Set-up distance 52mm, Torque 30Nm  
with mounting bores
- ▶ Net weight 1.8kg



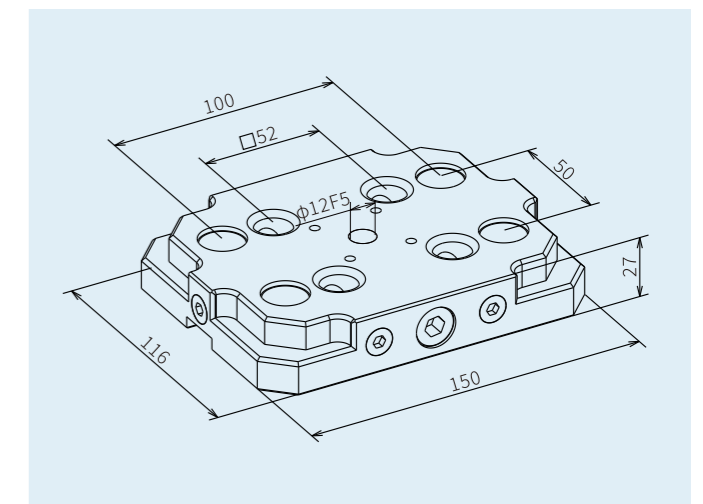
**3A-110173** 零点定位单工位板  
Zero point positioning single station plate

- ▶ 规格  $\phi 157 \times 27$ mm, 使用 $\phi 16$ 拉钉  
中心距52mm, 扭矩30Nm, 不带安装孔
- ▶ 注意 可根据客户要求设计安装孔、键槽和中心孔
- ▶ 净重 3.7kg
- ▶ Version  $\phi 157 \times 27$ mm, use with  $\phi 16$  drawbar,  
Set-up distance 52mm, Torque 30Nm,  
without mounting bores
- ▶ Note Mounting holes, keyways and central hole can be  
designed according to customer requirements
- ▶ Net weight 3.7kg



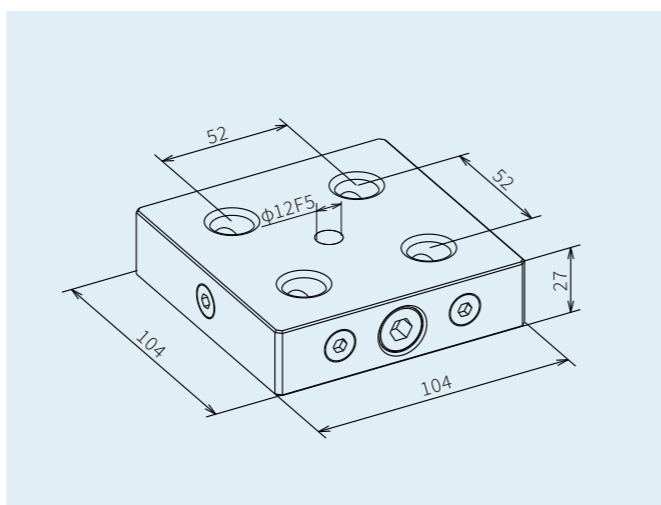
**3A-110168** 零点定位单工位板  
Zero point positioning single station plate

- ▶ 规格 150x116x27mm, 使用 $\phi 16$ 拉钉  
中心距52mm, 扭矩30Nm, 带有边缘压板位和安装孔
- ▶ 净重 2.9kg
- ▶ Version 150x116x27mm, use with  $\phi 16$  drawbar,  
Set-up distance 52mm, Torque 30Nm  
with clamping edge & mounting bores
- ▶ Net weight 2.9kg



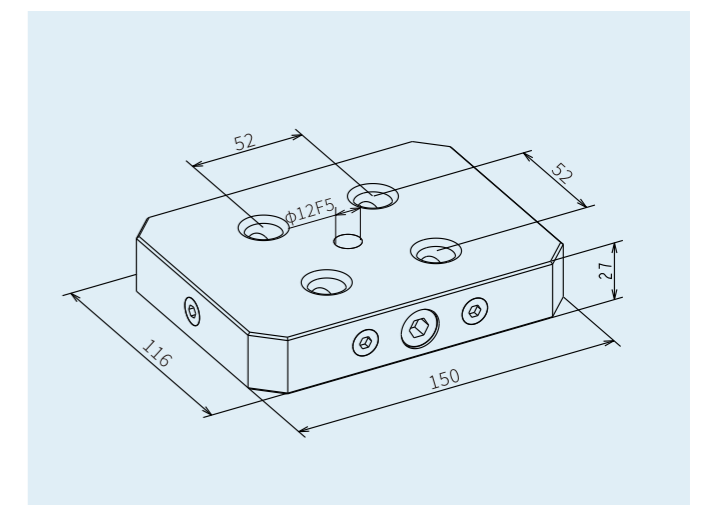
**3A-110166** 零点定位单工位板  
Zero point positioning single station plate

- ▶ 规格 104x104x27mm, 使用 $\phi 16$ 拉钉  
中心距52mm, 扭矩30Nm, 不带安装孔
- ▶ 注意 可根据客户要求设计安装孔和键槽
- ▶ 净重 2.0kg
- ▶ Version 104x104x27mm, use with  $\phi 16$  drawbar,  
Set-up distance 52mm, Torque 30Nm  
without mounting bores
- ▶ Note Mounting holes and keyways can be designed  
according to customer requirements
- ▶ Net weight 2.0kg



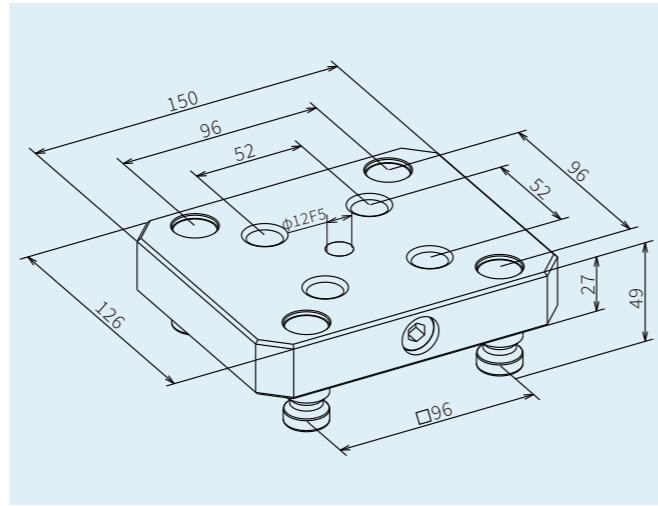
**3A-110169** 零点定位单工位板  
Zero point positioning single station plate

- ▶ 规格 150x116x27mm, 使用 $\phi 16$ 拉钉  
中心距52mm, 扭矩30Nm, 不带安装孔
- ▶ 注意 可根据客户要求设计安装孔和键槽
- ▶ 净重 3.4kg
- ▶ Version 150x116x27mm, Resetting precision less than 0.005mm,  
use with  $\phi 16$  drawbar, Set-up distance 52mm, Torque 30Nm  
without mounting bores
- ▶ Note Mounting holes and keyways can be designed  
according to customer requirements
- ▶ Net weight 3.4kg



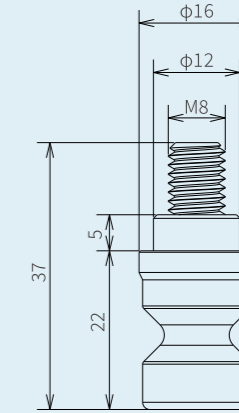
**3A-110174 过渡板**  
Adaptor Plate

- ▶ 规格 150x126x27mm, 使用 $\phi 16$ 拉钉  
中心距52mm, 扭矩30Nm, 带有 $\phi 20$ 拉钉  
可以方便、快速的实现拉钉位置52mm和96mm孔位之间的转换
- ▶ 净重 3.4kg
- ▶ Version 150x126x27mm, use with  $\phi 16$  drawbar, Set-up distance 52mm, Torque 30Nm, with  $\phi 20$  drawbar  
It can easily and quickly realize the conversion between the 52mm and 96mm hole positions of the spigot
- ▶ Net weight 3.4kg



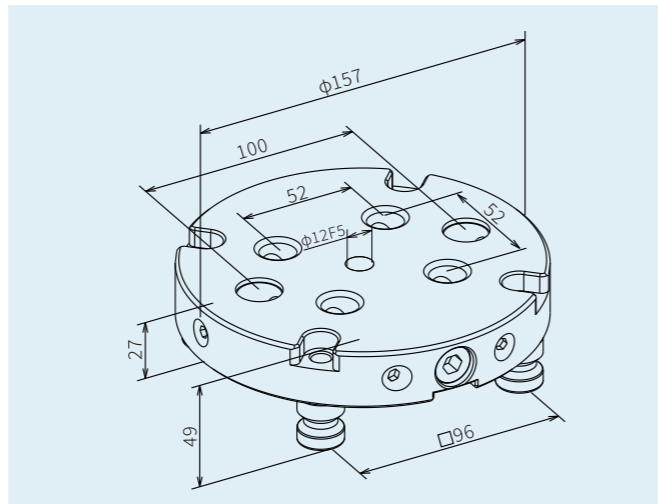
**3A-110164 快速手动零点拉钉**  
Fast manual zero point spigot

- ▶ 应用 3A-110164(直径16mm)的拉钉适用于间距52mm的零定位快锁系统, 包含M8螺钉
- ▶ 注意 一个零定位快锁系统需要四个拉钉(3A-110164)
- ▶ Application 3A-110164 ( $\phi 16$ ) for 52mm distance, incl. M8 threaded pin.
- ▶ Note 4 spigots (3A-110164) are required for one Quick-point plate.



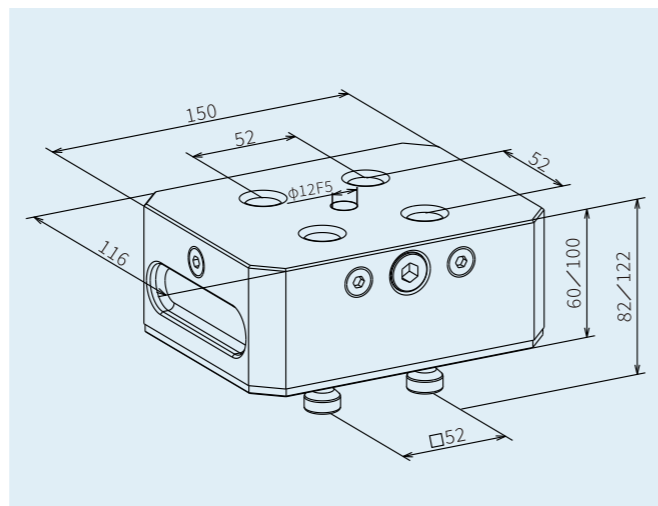
**3A-110175 过渡板**  
Adaptor Plate

- ▶ 规格  $\phi 157 \times 27$ mm, 使用 $\phi 16$ 拉钉  
中心距52mm, 扭矩30Nm, 带有 $\phi 20$ 拉钉  
可以方便、快速的实现拉钉位置52mm和96mm孔位之间的转换
- ▶ 净重 3.7kg
- ▶ Version  $\phi 157 \times 27$ mm, use with  $\phi 16$  drawbar, Set-up distance 52mm, Torque 30Nm, with  $\phi 20$  drawbar  
It can easily and quickly realize the conversion between the 52mm and 96mm hole positions of the spigot
- ▶ Net weight 3.7kg

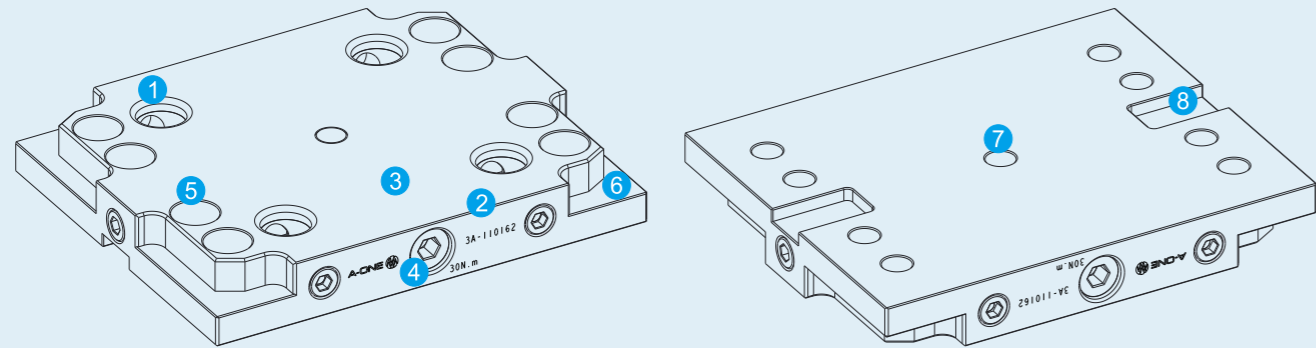


**3A-110176/3A-110177 垫高块**  
Riser

- ▶ 规格 (3A-110176:150x116x60mm)  
(3A-110177:150x116x100mm)  
使用 $\phi 16$ 拉钉  
中心距52mm, 扭矩30Nm, 带有 $\phi 16$ 拉钉
- ▶ 净重 6.1/10kg
- ▶ Version 150x116x60/150x116x100mm  
use with  $\phi 16$  drawbar, Set-up distance 52mm, Torque 30Nm with  $\phi 16$  drawbar
- ▶ Net weight 6.1/10kg

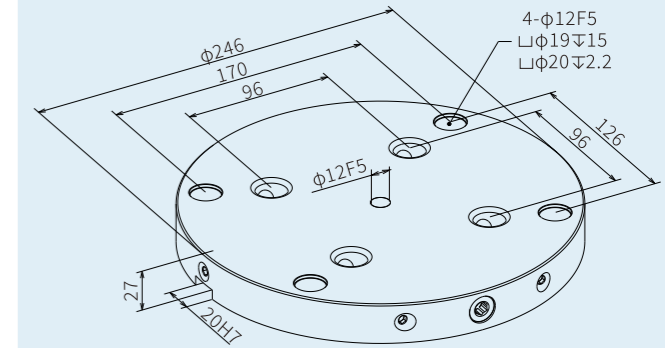






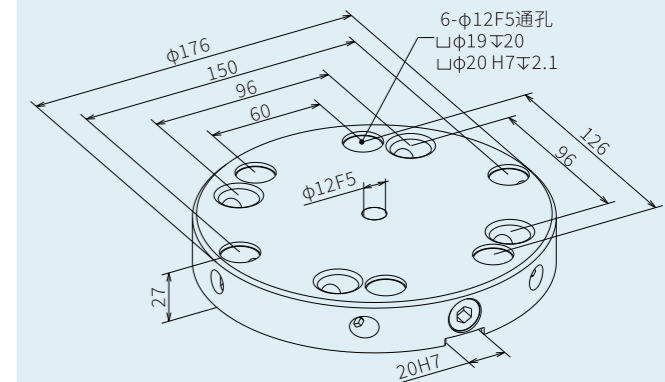
**3A-110243** 零点定位单工位板  
Zero point positioning single station plate

- ▶ 规格  $\phi 246 \times 27 \text{mm}$ , 使用 $\phi 20$ 拉钉, 中心距 $96 \text{mm}$ , 扭矩 $30 \text{Nm}$  带有用于 $63 \text{mm}$  T型槽的安装孔
- ▶ 净重  $9.3 \text{kg}$
- ▶ Version  $\phi 246 \times 27 \text{mm}$ , use with  $\phi 20$  drawbar, Set-up distance  $52 \text{mm}$ , Torque  $30 \text{Nm}$  with mounting bores for  $63 \text{mm}$  T-slot distance.
- ▶ Net weight  $9.3 \text{kg}$



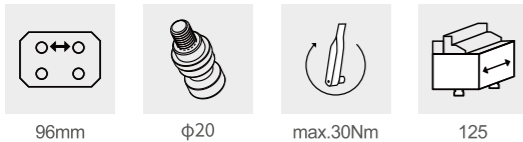
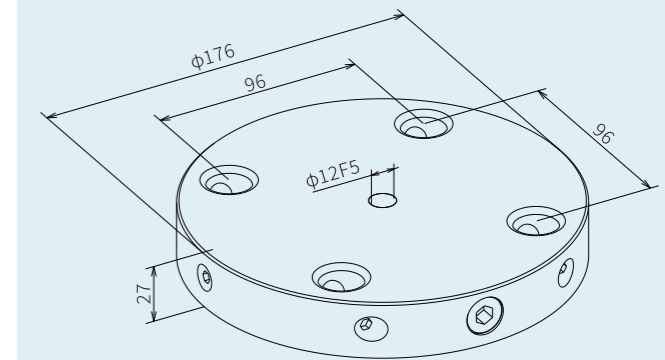
**3A-110247** 零点定位单工位板  
Zero point positioning single station plate

- ▶ 规格  $\phi 176 \times 27 \text{mm}$ , 使用 $\phi 20$ 拉钉, 中心距 $96 \text{mm}$ , 扭矩 $30 \text{Nm}$  带 $63 \text{mm}$ 和 $150 \text{mm}$  T型槽的安装孔
- ▶ 净重  $4.7 \text{kg}$
- ▶ Version  $\phi 176 \times 27 \text{mm}$ , use with  $\phi 20$  drawbar, Set-up distance  $52 \text{mm}$ , Torque  $30 \text{Nm}$  with mounting bores for  $63 \text{mm}$  T-slot distance and  $150 \text{mm}$  distance
- ▶ Net weight  $4.7 \text{kg}$



**3A-110248** 零点定位单工位板  
Zero point positioning single station plate

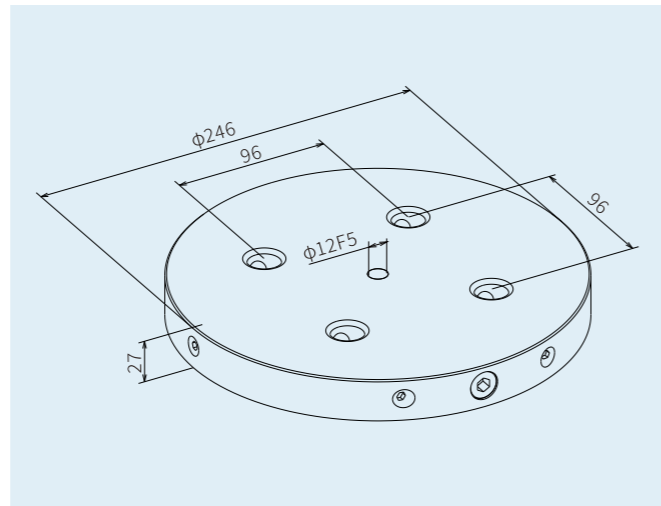
- ▶ 规格  $\phi 176 \times 27 \text{mm}$ , 使用 $\phi 20$ 拉钉, 中心距 $96 \text{mm}$ , 扭矩 $30 \text{Nm}$  不带安装孔
- ▶ 注意 可根据客户要求设计安装孔和键槽
- ▶ 净重  $4.8 \text{kg}$
- ▶ Version  $\phi 176 \times 27 \text{mm}$ , use with  $\phi 20$  drawbar, Set-up distance  $96 \text{mm}$ , Torque  $30 \text{Nm}$  without mounting bores
- ▶ Note Mounting holes and keyways can be designed according to customer requirements
- ▶ Net weight  $4.8 \text{kg}$



- 1. 中心距为 $96 \text{mm}$ , 扭矩 $30 \text{Nm}$ , 适用于 $\phi 20$ 拉钉, 配合 $125 \text{mm}$ 钳口宽的自定心虎钳使用  
1. The center distance is  $96 \text{mm}$  and the torque is  $30 \text{Nm}$ , which is suitable for  $\phi 20$  spigt, used with self centering vice with  $125 \text{mm}$  jaw width.
- 2. 厚度为 $27 \text{mm}$ 的零点系统  
2. Zero point system with thickness of  $27 \text{mm}$ .
- 3. 坚固的夹具主体, 热处理后表面磨削成型, 坚固耐磨的机械结构, 经久耐用  
3. Solid fixture body, surface grinding after heat treatment, solid and wear-resistant mechanical structure, durable.
- 4. 通过拧紧螺丝或快速锁定, 快速释放, 实现强大的机械张力  
4. Strong mechanical tension is achieved by tightening screws or quick locking and quick release.
- 5. 安装孔位  
5. Mounting bores position.
- 6. 边缘压板位, 可使用压板将其固定在工作台上  
6. The edge pressing plate can be fixed on the workbench by pressing plate.
- 7.  $\phi 12 \text{F5}$ 精孔  
7.  $\phi 12 \text{F5}$  fine hole.
- 8. 机床工作台上用于轴向对准的 $20 \text{H7}$ 键槽(预留加工余量 $0.4 \text{mm}$ )  
8.  $20 \text{H7}$  keyway for axial alignment on machine tool workbench (with a reserved machining allowance of  $0.4 \text{mm}$ ).

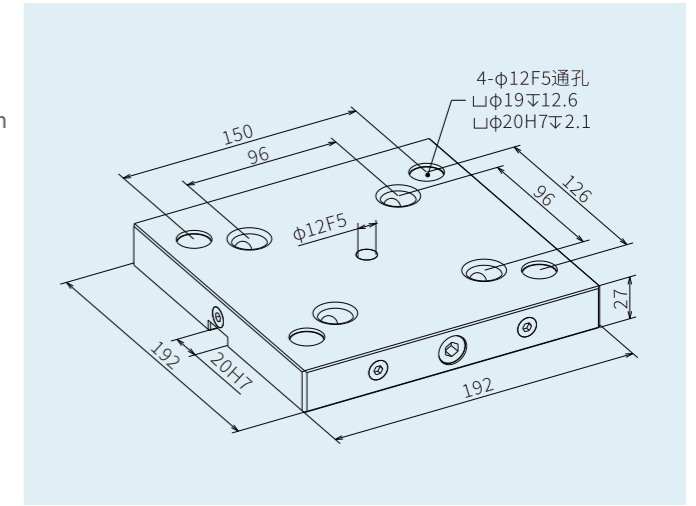
**3A-110249** 零点定位单工位板  
Zero point positioning single station plate

- ▶ 规格  $\phi 246 \times 27$ mm, 使用 $\phi 20$ 拉钉, 中心距96mm, 扭矩30Nm
- ▶ 注意 不带安装孔, 可根据客户要求设计安装孔和键槽
- ▶ 净重 9.5kg
- ▶ Version  $\phi 246 \times 27$ mm, use with  $\phi 20$  drawbar, Set-up distance 96mm, Torque 30Nm, without mounting bores
- ▶ Note Mounting holes and keyways can be designed according to customer requirements
- ▶ Net weight 9.5kg



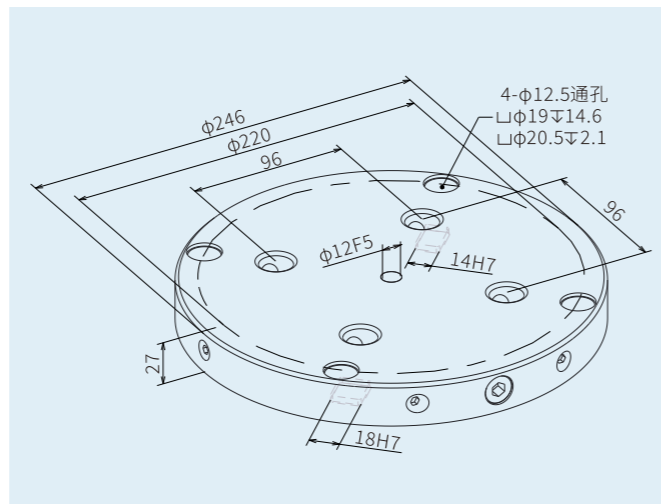
**3A-110242** 零点定位单工位板  
Zero point positioning single station plate

- ▶ 规格 192x192x27mm, 使用 $\phi 20$ 拉钉, 中心距96mm, 扭矩30Nm 带有用于63mm T型槽的安装孔
- ▶ 净重 7.0kg
- ▶ Version 192x192x27mm, use with  $\phi 20$  drawbar, Set-up distance 96mm, Torque 30Nm with mounting bores for 63mm T-slot distance
- ▶ Net weight 7.0kg



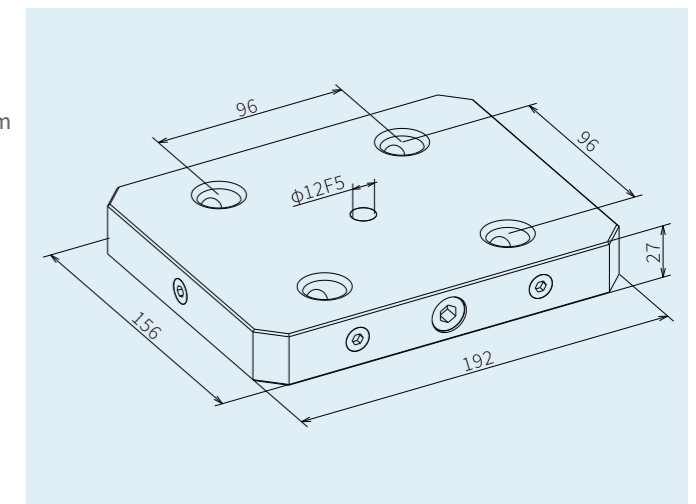
**3A-110250** 零点定位单工位板  
Zero point positioning single station plate

- ▶ 规格  $\phi 246 \times 27$ mm, 使用 $\phi 20$ 拉钉, 中心距96mm, 扭矩30Nm 带安装孔, 用于带有T型槽的机床工作台
- ▶ 净重 9.3kg
- ▶ Version  $\phi 246 \times 27$ mm, use with  $\phi 20$  drawbar, Set-up distance 96mm, Torque 30Nm, with mounting bores for machine tables with T-slot
- ▶ Net weight 9.3kg



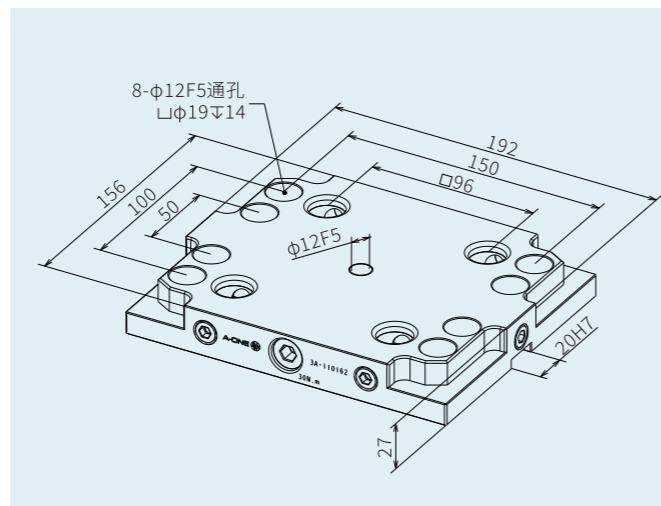
**3A-110246** 零点定位单工位板  
Zero point positioning single station plate

- ▶ 规格 192x156x27mm, 使用 $\phi 20$ 拉钉, 中心距96mm, 扭矩30Nm 不带边缘压紧位和安装孔
- ▶ 注意 可根据客户要求设计和键槽
- ▶ 净重 6.0kg
- ▶ Version 192x156x27mm, use with  $\phi 20$  drawbar, Set-up distance 96mm, Torque 30Nm without clamping edge and mounting bores
- ▶ Note Mounting holes and keyways can be designed according to customer requirements
- ▶ Net weight 6.0kg



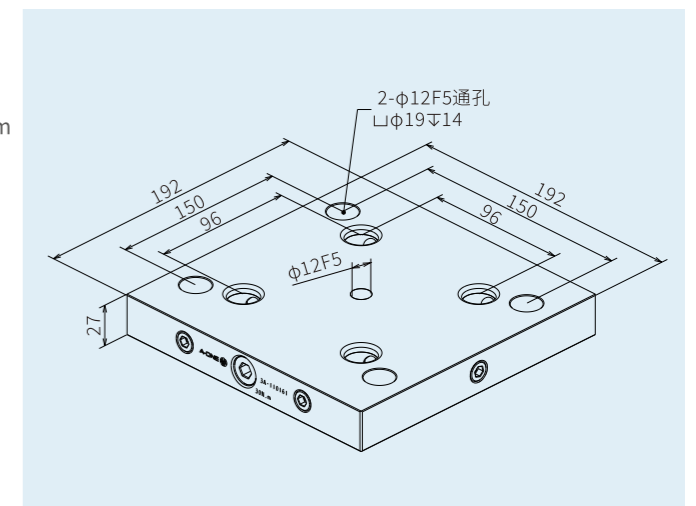
**3A-110162** 零点定位单工位板  
Zero point positioning single station plate

- ▶ 规格 192x156x27mm, 使用 $\phi 20$ 拉钉, 中心距96mm, 扭矩30Nm 带边缘压板位和安装孔
- ▶ 净重 5.5kg
- ▶ Version 192x156x27mm, use with  $\phi 20$  drawbar, Set-up distance 96mm, Torque 30Nm with clamping edge & mounting bores
- ▶ Net weight 5.5kg



**3A-110161** 零点定位单工位板  
Zero point positioning single station plate

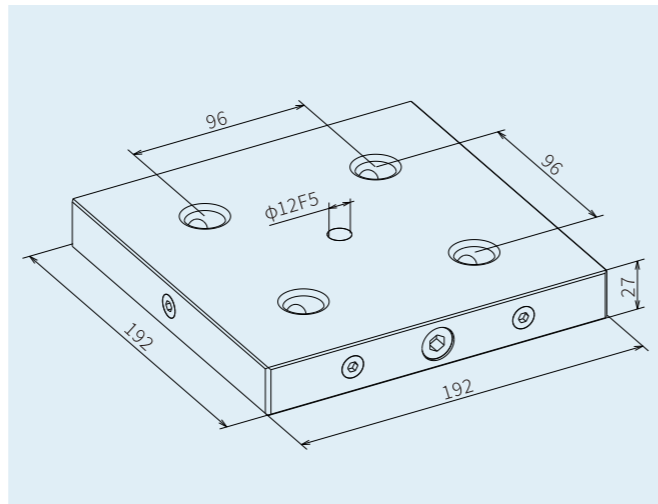
- ▶ 规格 192x192x27mm, 使用 $\phi 20$ 拉钉, 中心距96mm, 扭矩30Nm 带有安装孔
- ▶ 净重 7.0kg
- ▶ Version 192x192x27mm, use with  $\phi 20$  drawbar, Set-up distance 96mm, Torque 30Nm with mounting bores
- ▶ Net weight 7.0kg





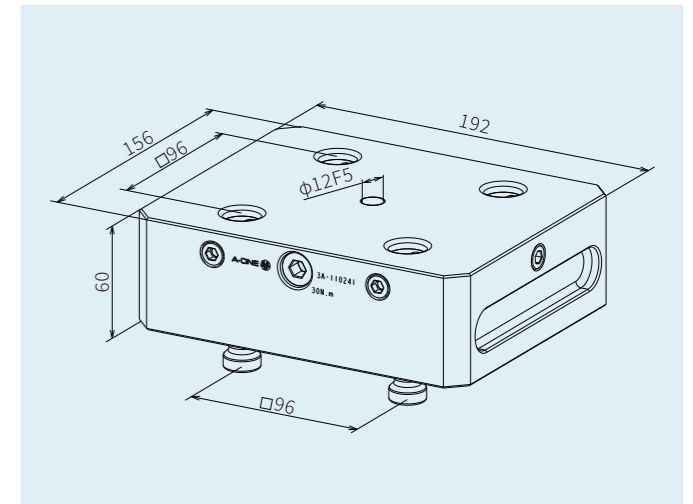
**3A-110251** 零点定位单工位板  
Zero point positioning single station plate

- ▶ 规格 192x192x27mm, 使用  $\phi 20$  拉钉, 中心距96mm, 扭矩30Nm 不带安装孔
- ▶ 注意 可根据客户要求设计安装孔和键槽
- ▶ 净重 7.2kg
- ▶ Version 192x192x27mm, use with  $\phi 20$  drawbar, Set-up distance 96mm, Torque 30Nm without mounting bores
- ▶ Note Mounting holes and keyways can be designed according to customer requirements
- ▶ Net weight 7.2kg



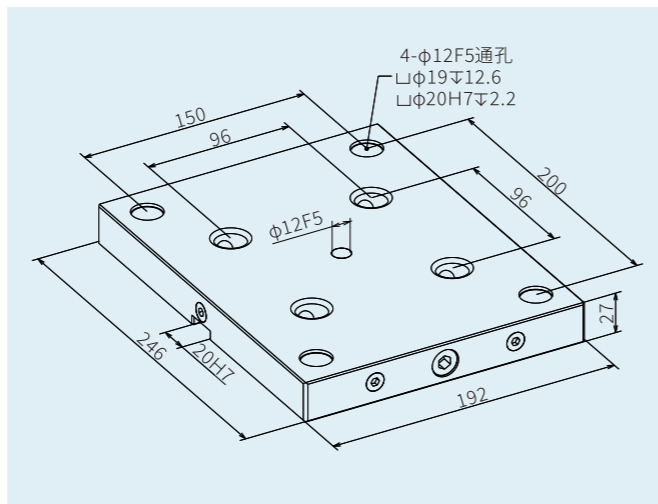
**3A-110241** 垫高块  
Riser

- ▶ 规格 192x156x60mm, 使用  $\phi 20$  拉钉, 中心距96mm, 扭矩30Nm 带有  $\phi 20$  拉钉
- ▶ 净重 11.2kg
- ▶ Version 192x156x60mm, use with  $\phi 20$  drawbar, Set-up distance 96mm, Torque 30Nm with  $\phi 20$  drawbar,
- ▶ Net weight 11.2kg



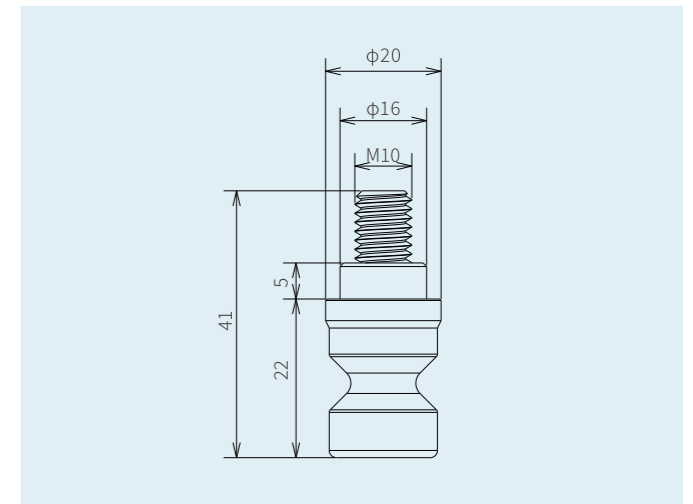
**3A-110244** 零点定位单工位板  
Zero point positioning single station plate

- ▶ 规格 246x192x27mm, 使用  $\phi 20$  拉钉, 中心距96mm, 扭矩30Nm 带有用于100mm T型槽的安装孔
- ▶ 净重 9.2kg
- ▶ Version 246x192x27mm, use with  $\phi 20$  drawbar, Set-up distance 96mm, Torque 30Nm with mounting bores for 100mm T-slot distance
- ▶ Net weight 9.2kg



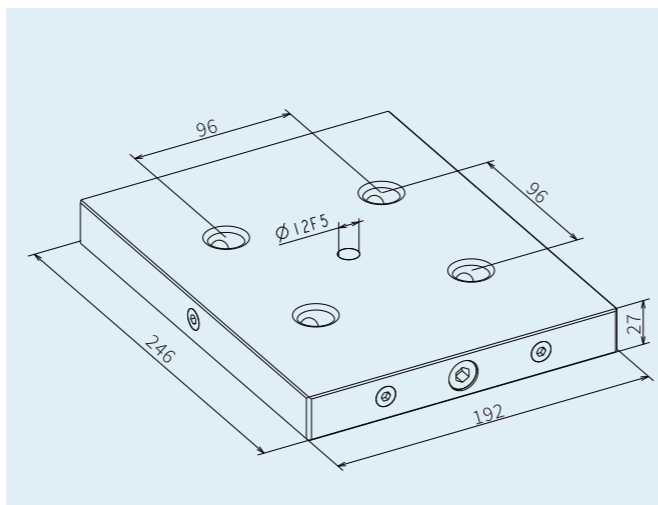
**3A-110194** 快速手动零点拉钉  
Fast manual zero point spigot

- ▶ 应用 3A-110194 (直径20mm) 的拉钉适用于间距96mm的零点定位快锁系统, 包含M10螺钉
- ▶ 注意 一个零点定位快锁系统需要四个拉钉 (3A-110194)
- ▶ Application 3A-110194 ( $\phi 20$ ) for 96mm distance, incl. M10 threaded pin.
- ▶ Note 4 spigots (3A-110194) are required for one Quick-point plate.



**3A-110245** 零点定位单工位板  
Zero point positioning single station plate

- ▶ 规格 246x192x27mm, 使用  $\phi 20$  拉钉, 中心距96mm, 扭矩30Nm 不带安装孔
- ▶ 注意 可根据客户要求设计安装孔和键槽
- ▶ 净重 9.4kg
- ▶ Version 246x192x27mm, use with  $\phi 20$  drawbar, Set-up distance 96mm, Torque 30Nm without mounting bores
- ▶ Note Mounting holes and keyways can be designed according to customer requirements
- ▶ Net weight 9.4kg

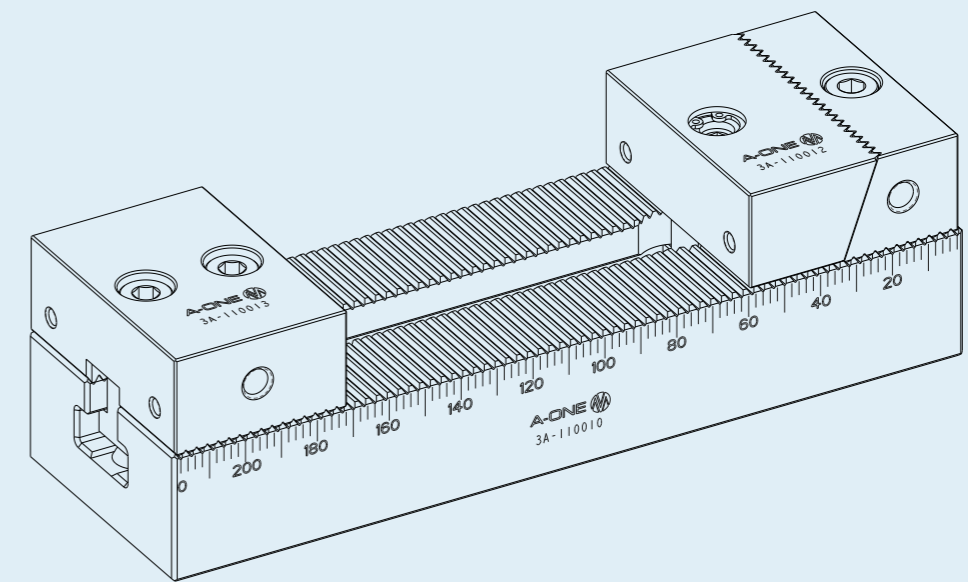


# A-ONE夹紧装置

## A-ONE Clampset

<http://www.szjztools.com>  
<http://www.system3a.com>

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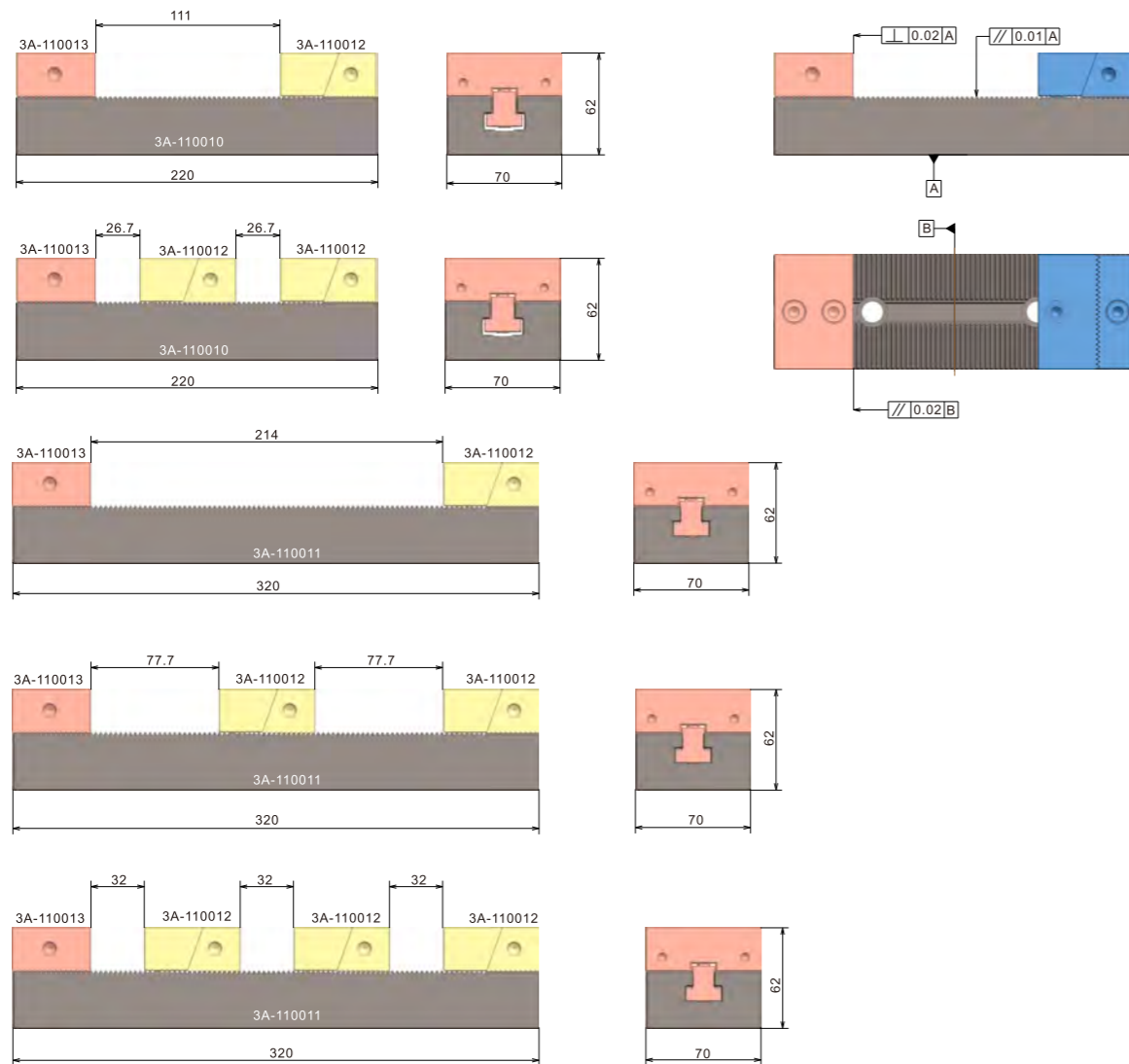


应用, 标准挡块 Application, standard clamp block

3A-110012	标准挡块 standard clamp block
3A-110013	F挡块 Clamp block F
3A-110010	底座220 Clamp set base 220
3A-110011	底座320 Clamp set base 320
标准挡块 standard clamp block	夹紧力kg=10% Clamping force kg=10%
球面压力螺钉数量 Number of spherical pressure screws	扭矩 Torque
2	5 Nm      10 Nm      15 Nm
4	900      1750      2500
	1450      2750      3900

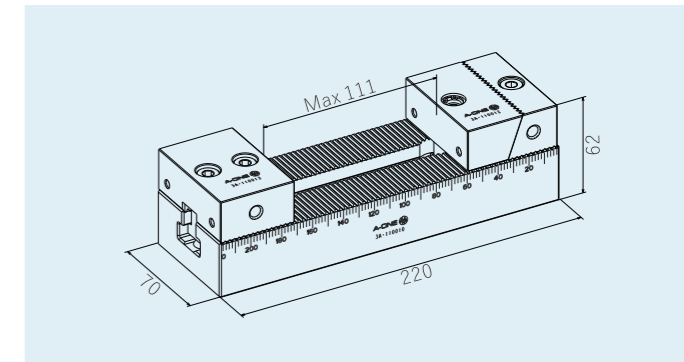
拧紧螺钉时必须使用力矩扳手, 以保证夹持时的安全和精确  
A torque wrench must be used when tightening the screws to ensure safety and accuracy during clamping

这些数据仅供参考, 实际生产中可能受到灰尘和其它环境影响  
The data is only for reference and may be subject to dust and other environmental influences during actual production



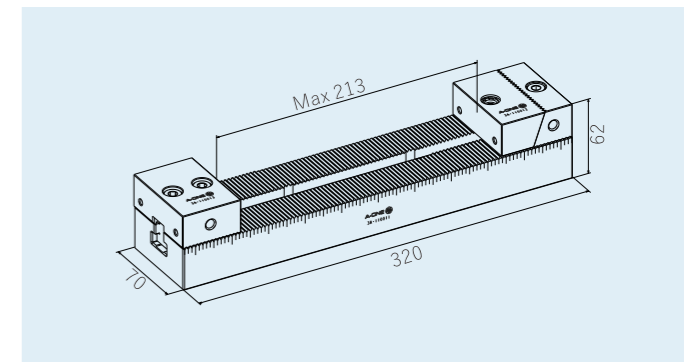
**3A-110010** 220型零点虎钳  
Clamp set base 220

- ▶ 规格 钢, 硬质, 磨削; 有2mm 间隔的定位齿 上面可装夹持元件
- ▶ 应用 可直接安装于工作台, 也可安装于托板上
- ▶ Version Hardened steel; ground with 2.0mm space of positioning teeth on which work piece can be placed
- ▶ Application Be mounted directly on the table or the pallet



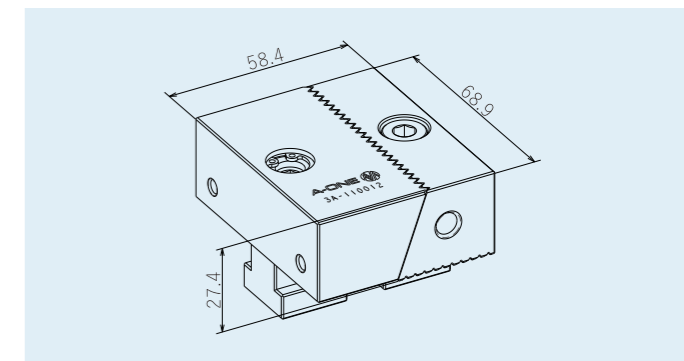
**3A-110011** 320型零点虎钳  
Clamp set base 320

- ▶ 规格 钢, 硬质, 磨削; 有2mm 间隔的定位齿, 上面可装夹持元件
- ▶ 应用 可直接安装于工作台, 也可安装于托板上
- ▶ Version Hardened steel; ground with 2.0mm space of positioning teeth on which work piece can be placed
- ▶ Application Be mounted directly on machine table or pallet 3A-400015, 3A-400016 can be installed on the back of the vise to match the zero point system.



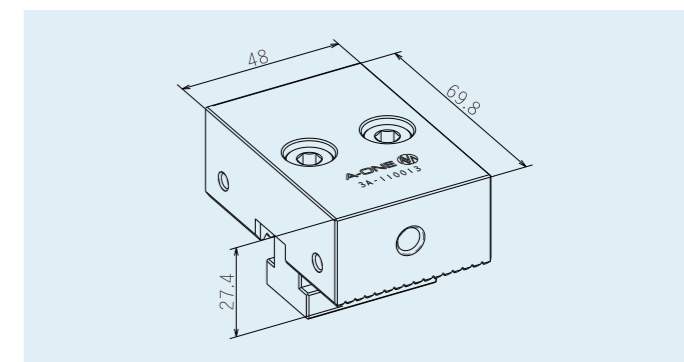
**3A-110012** 夹爪  
Clamp block

- ▶ 规格 硬质钢, 包括用于连接的榫块
- ▶ 应用 夹持表面已加工过的工件。用所提供的榫块装于底座 3A-110010 或3A-110011上
- ▶ Version Hardened steel, T nut is supplied
- ▶ Application To clamp already machined surface workpiece. To be mounted on the base of 3A-110010, 3A-110011



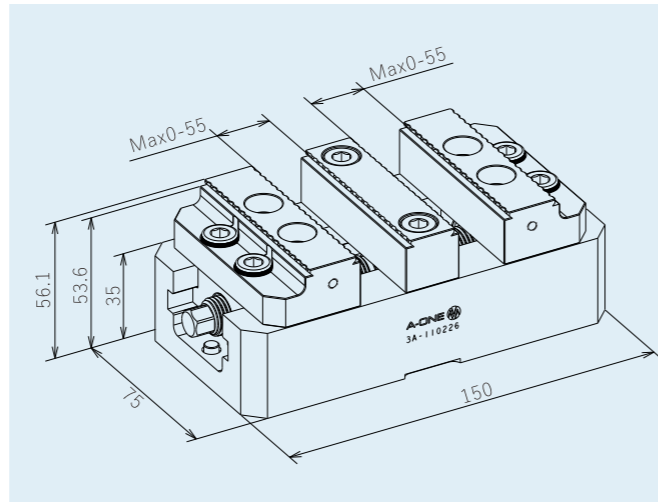
**3A-110013** F挡块  
Clamp block F

- ▶ 规格 硬质钢, 包括用于连接的T型块
- ▶ 应用 用所提供的T型块装于底座3A-110010或3A-110011上
- ▶ Version Hardened steel, T nut is supplied
- ▶ Application To clamp already machined surface workpiece. To be mounted on the base of 3A-110010, 3A-110011



**3A-110226** 75150 J1虎钳  
75150 J1 vise

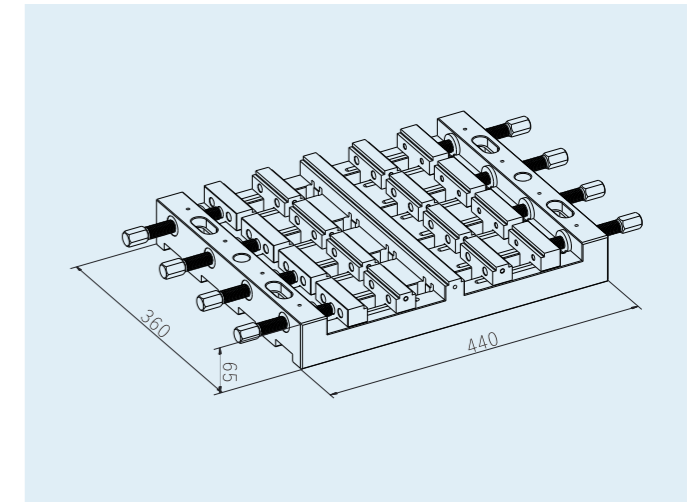
- ▶ 规格 中间夹爪是固定不动, 以确保在任何条件下都能正确夹紧零件。可在同一个虎钳上同时加工两种不同规格的零件
- ▶ 应用 适用于立式和卧式精密加工设备
- ▶ 特点 夹爪钳口位置带有燕尾结构, 可提供有效的夹紧力
- ▶ 注意 六角扳手需另购
- ▶ Version The middle clamping jaws are fixed to ensure that the parts can be clamped correctly under any conditions. Two parts of different specifications can be processed on the same vise at the same time.
- ▶ Application Suitable for vertical and horizontal precision processing equipment.
- ▶ Characteristic Dovetail structure at the jaw position can provide effective clamping force
- ▶ Note Hexagonal wrench is supplied separately



**3A-110070** 多工位虎钳  
CNC Multistation vise

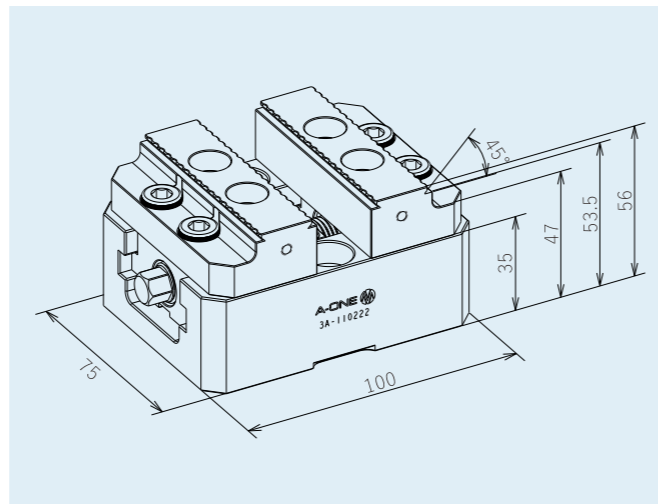
- ▶ 规格 滑块可根据实际情况拆装, 夹持精度 0.013mm 以内
- ▶ 应用 适用于 CNC 加工中心及铣床, 一次装夹多个工件
- ▶ Version The slide block can be assembled or disassembled basing on actual situation. The clamping precision:  $\leq 0.013\text{mm}$
- ▶ Application Used on CNC machining center or milling machine. Which can be mounted many workpieces at a time

夹持工件数量(Number)	最大夹持工件尺寸(workpiece size)mm
16	80*52
8	80*120
4	170*120
2	360*120



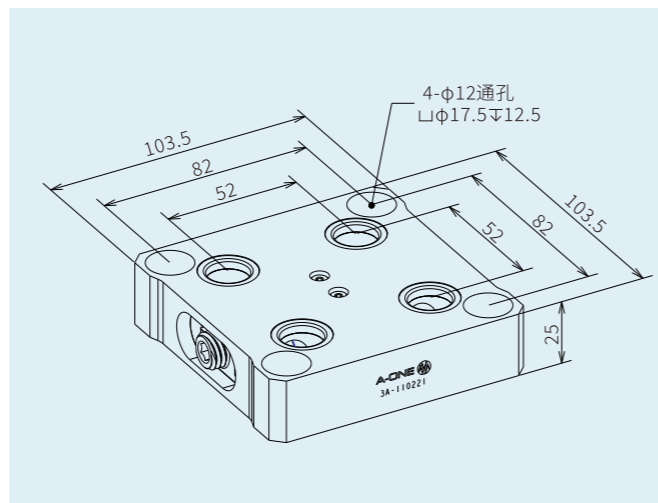
**3A-110222** 75100虎钳  
75100 vise

- ▶ 规格 双向自定中心, 重复精度小于0.03, 可直接锁螺栓固定于安装板上或使用拉钉配合X52方盘 (3A-110221) 使用
- ▶ 应用 适用于立式和卧式精密加工设备, 一次加工五个面, 特殊钳口可定制
- ▶ 注意 六角扳手需另购, 搭配X52方盘使用
- ▶ Version Double action self-centering, repeating accuracy less than 0.03, can be directly bolted to the mounting plate or used with the X52 square plate (3A-110221) using pull studs.
- ▶ Application Suitable for vertical and horizontal precision processing machine, for 5-axis machining per time ,Special jaws can be customized.
- ▶ Note Hexagonal wrench is supplied separately Use with X52 square plate



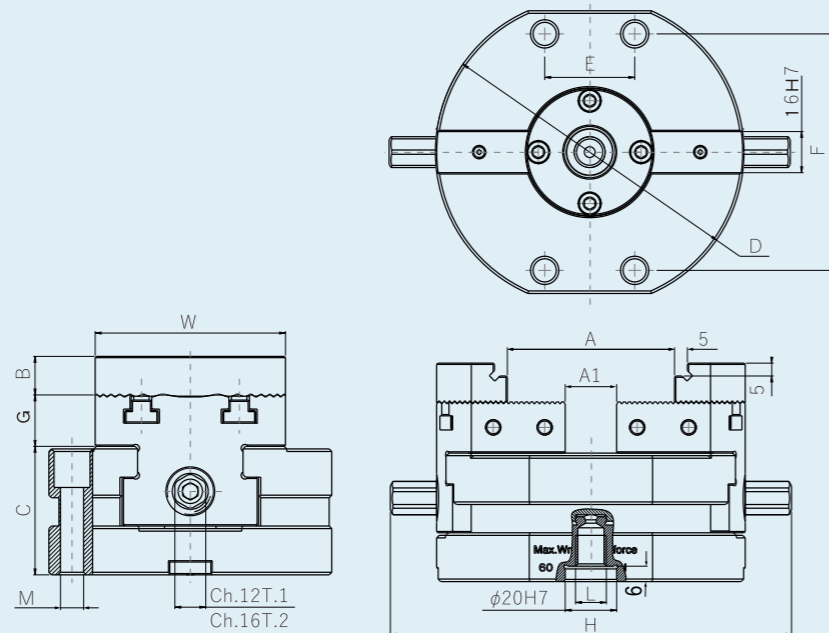
**3A-110221** X52 方盘  
X52 square plate

- ▶ 规格 103.5x103.5x25mm, 重复定位精度小于0.01mm
- ▶ 中心距 52mm
- ▶ 扭矩 30Nm
- ▶ 净重 1.65kg
- ▶ Version 103.5x103.5x25mm, Resetting precision Less than 0.01mm
- ▶ Set-up distance 52mm
- ▶ Torque 30Nm
- ▶ Net weight 1.65kg





多功能系列平口钳  
Multitasking series vises



- 规格 钳口调整幅度为2mm (多轴自定心)  
优质合金结构  
夹紧精度0.015mm  
具有最小偏差的立体刚性结构  
可选配多种类型钳口
- 应用 柔性自定心平口钳适用于五轴加工中心和数控车铣中心, 用于五轴加工中心时, 可以依次加工工件的五个面, 用于数控车铣中心时, 可以加工方形工件, 也可用于旋转工作台上的最终加工, 对中精度可达到0.04mm.

- Version Jaw adjustment in steps of 2 mm (Multiaxis self-centering)  
High quality alloy steel construction.  
Gripping accuracy within 0.015 mm  
Solid, rigid construction for minimum deflection.  
Series of interchangeable jaws available
- Application These self-centering vises are to be used on 5 axis machines in order to be able to machine 5 workpieces sides or even on lathes for prismatic workpieces or finally on rotary tables. Geometrical accuracy with tolerances within 0.04 mm.

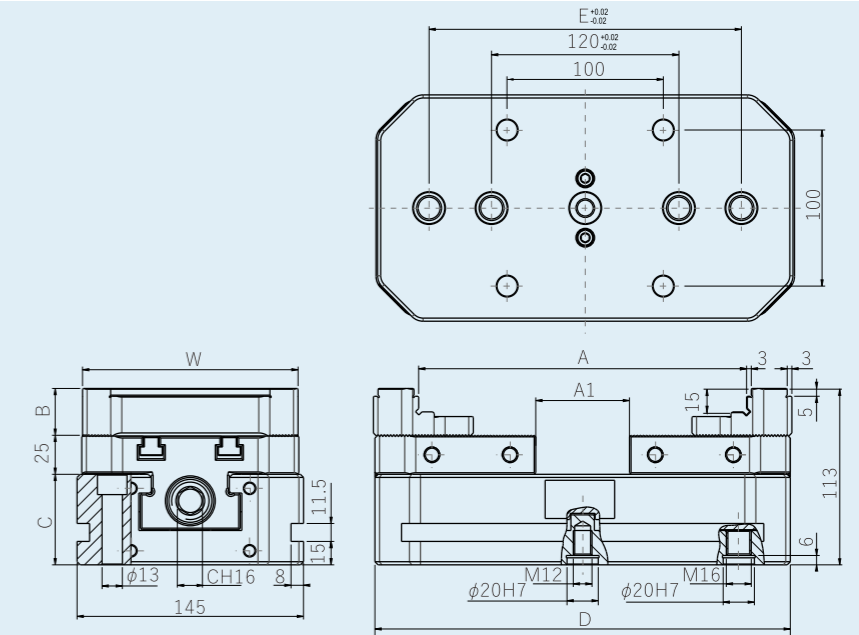
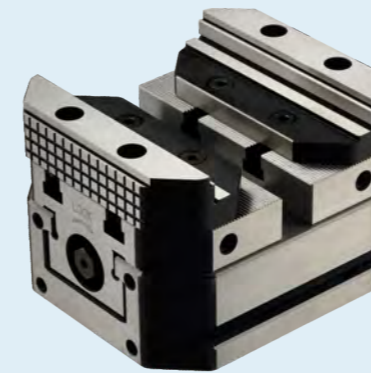
技术参数  
Table dimension 单位: mm

编号 Model NO	A	A1	W	B	C	D	E	F	G	H	L	M	重量 Net weight	夹紧力 Clamping force
3A-110511	65	20	74	15	50	Φ120	35	92	20	156	M12	Φ9	4.9kg	16KN
3A-110512	95	40	99	20	70	Φ160	35	120	25	208	M16	Φ11	11kg	20KN

选配钳口  
Optional jaws

钳口型号 Jaws model	软口钳 Soft jaw	光面钳口 Smooth jaw	槽面钳口 Serrated jaw	台阶钳口 Step jaw	V型钳口 Prismatic jaw	齿状钳口 Grip jaw
虎钳型号 Vise model						
3A-110511	645B-1	645C-1	645D-1	645E-1	645F-1	645T-1
3A-110512	645B-2	645C-2	645D-2	645E-2	645F-2	645T-2

多功能系列平口钳  
Multitasking series vises



- 规格 可作为自定心或偏心平口钳使用  
手动操作  
机械夹紧

- Version Self-centering or eccentric vise  
Manual operation  
Mechanical clamping

技术参数  
Table dimension 单位: mm

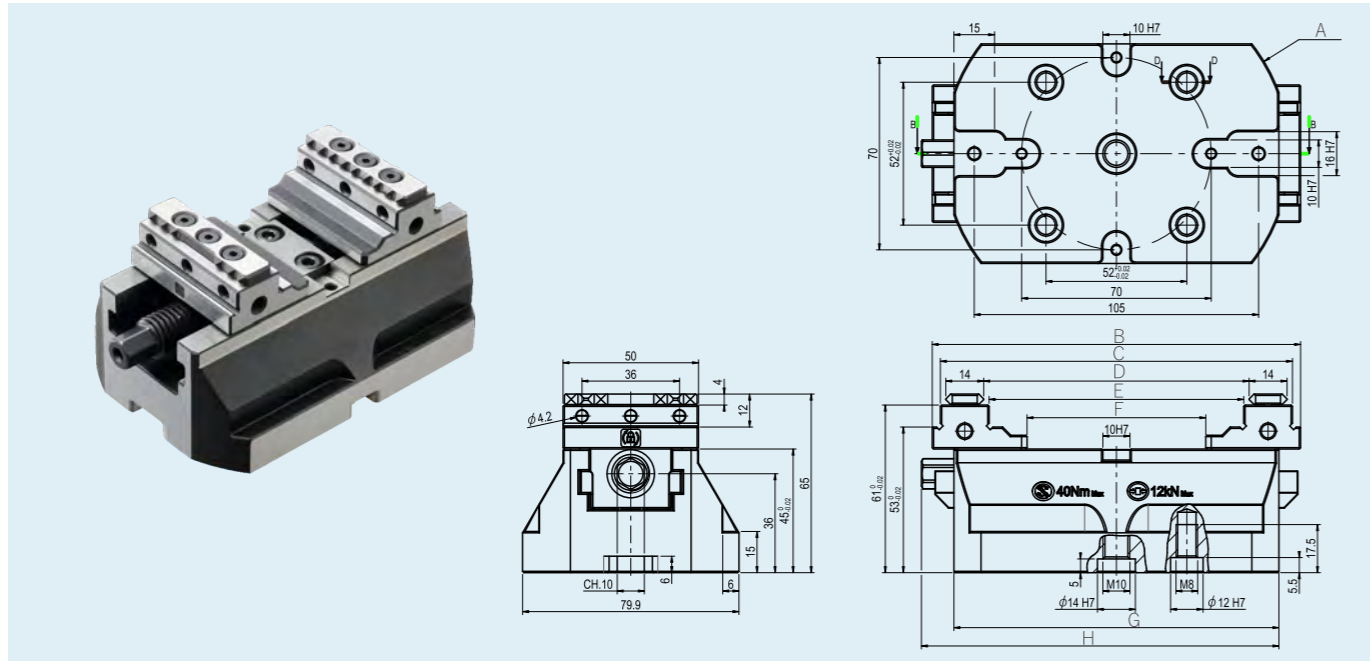
编号 Model NO	A	A1	W	B	C	D	E	重量 Net weight	夹紧力 Clamping force
3A-110513	108	20	138	30	58	166	-	13kg	30KN
3A-110514	208	60	138	30	58	266	200	20kg	30KN

选配钳口  
Optional jaws

钳口型号 Jaws model	软口钳 Soft jaw	光面钳口 Smooth jaw	槽面钳口 Serrated jaw	台阶钳口 Step jaw	V型钳口 Prismatic jaw	齿状钳口 Grip jaw
虎钳型号 Vise model						
3A-110513	645B-3	645C-3	645D-3	645E-3	645F-3	645T-3
3A-110514	645B-4	645C-4	645D-4	645E-4	645F-4	645T-4

夹紧装置

多功能系列平口钳  
Multitasking series vises



技术参数  
Table dimension

单位: mm

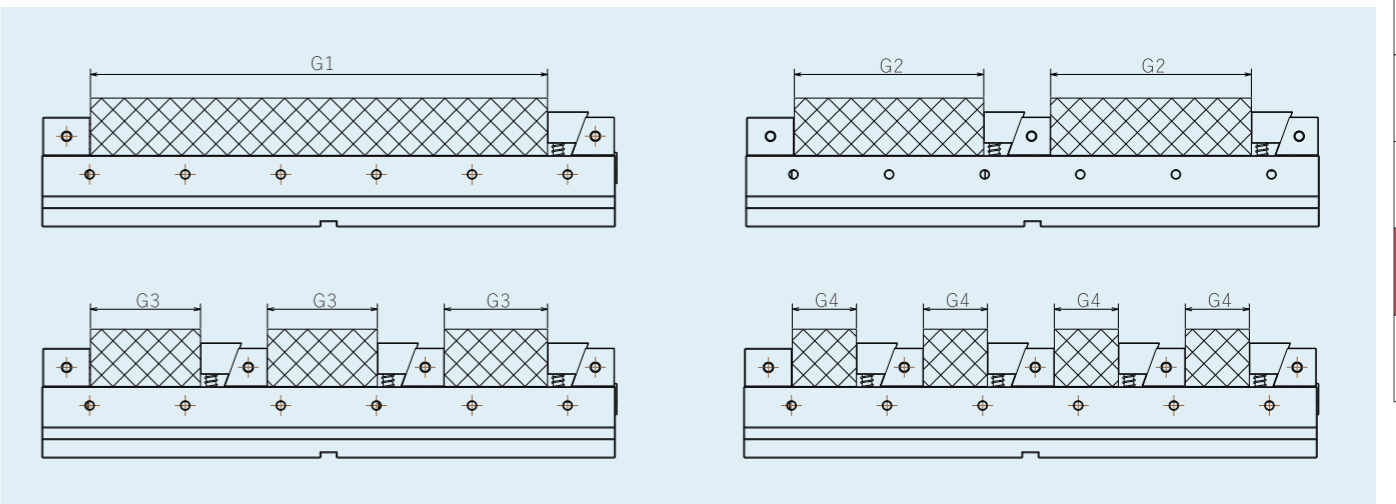
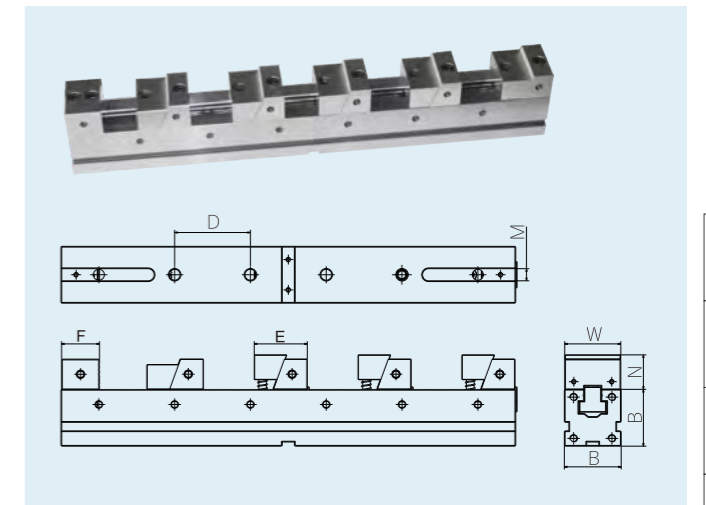
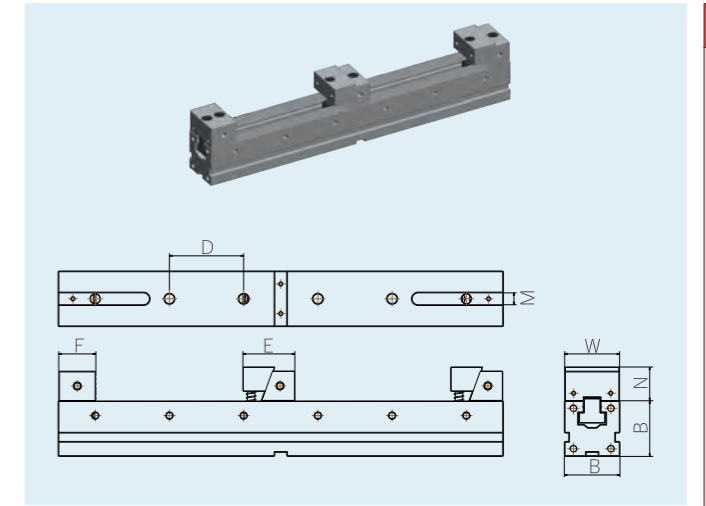
编号 Model NO	A	B	C	D	E	F	G	H	重量 Net weight	夹紧力 Clamping force
3A-110519	93	96	90	58	54	26	80	92	1.9kg	12KN
3A-110520	128	136	130	98	94	66	120	132	2.7kg	12KN
3A-110521	165	176	170	138	134	106	160	172	3.4kg	12KN

3A-110301/3A-110302 多工位加宽平口钳  
Multi-station widening flat vise

型号 Model	L	B	W	D	F	E	N	M	G1	G2	G3	G4
3A-110301	300	50	59	38	55-58	25	16	16	208	75	30	8
	400								308	125	64	33
	500								408	175	96	58
	600								508	225	129	83
	700								608	275	162	108
3A-110302	400	75	84	50	70-75	40	16	16	275	100	41	12
	500								375	150	75	37
	600								475	200	108	62
	700								575	250	141	87
	800								675	300	174	102

3A-110303/3A-110304 多工位平口钳  
Multi-station flat vise

型号 Model	L	B	W	D	F	E	N	M	G1	G2	G3	G4
3A-110303	300	50	49	38	55-58	25	16	16	208	75	30	8
	400								308	125	64	33
	500								408	175	96	58
	600								508	225	129	83
	700								608	275	162	108
3A-110304	400	75	74	50	70-75	40	16	16	275	100	41	12
	500								375	150	75	37
	600								475	200	108	62
	700								575	250	141	87
	800								675	300	174	102



夹紧装置

零点定位系统

UPC系统

下拉圆柱夹具

基准卡盘

R型系列夹具

自定心虎钳

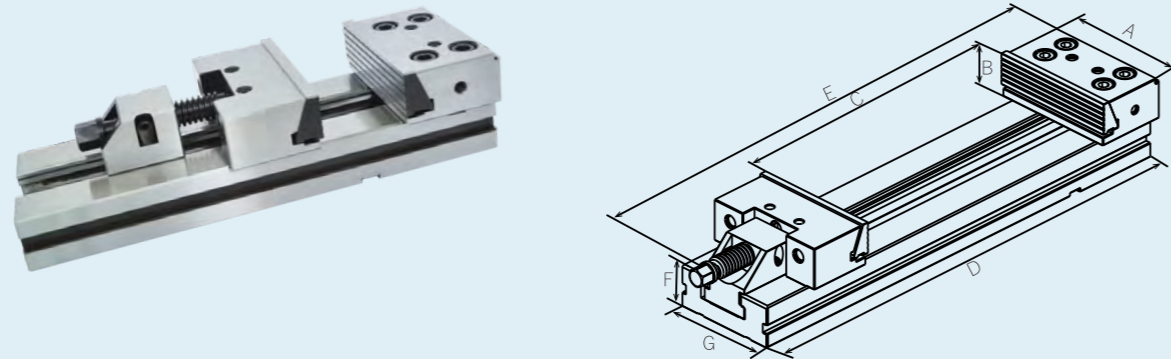
零点定位快锁

夹紧装置

其他夹具



**3A.1 标准平口钳**  
Standard vises



- ▶ **规格** 钳口对工作台垂直度50:0.02, 采用优质合金钢制造, 表面硬化处理, 硬度HRC58-62.
- ▶ **应用** 用于数控机床, 加工中心及通用机床的铣、镗、钻及磨削.

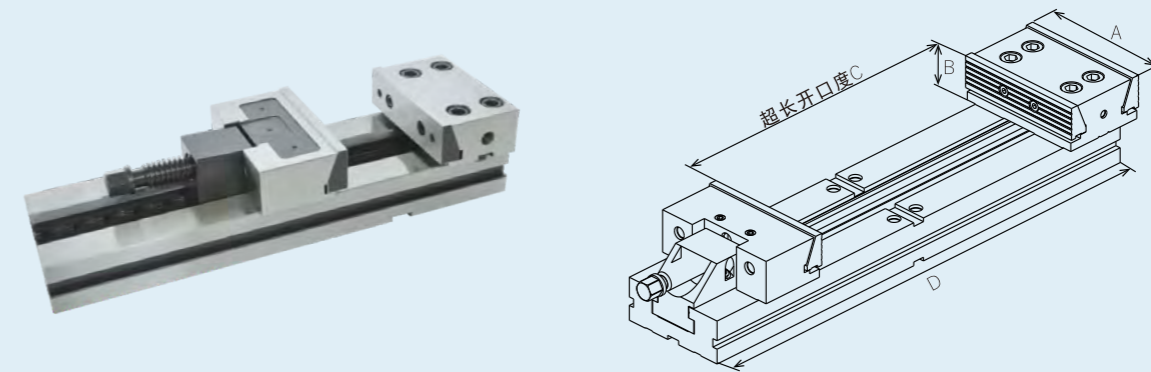
- ▶ **Version** Perpendicularity of vise jaw and work table is 50:0.02, Made of high quality alloy steel, the case hardness is HRC58-62.
- ▶ **Application** Suitable for milling, boring, drilling and grinding on CNC machine, machining centre and ordinary machines.

**技术参数**  
Table dimension

单位: mm

编号 Model NO	钳口宽A jaw width	钳口高B jaw height	开口度C jaw open	钳体长D base length	整钳长E vise length	钳体高F base height	钳体宽G base width	重量KG vise weight	夹紧力KN camping force
3A.1-1x100	100	30	100	270	320	35	75	7kg	16KN
3A.1-2x150	125	40	150	345	402	40	95	13kg	25KN
3A.1-3x200	150	50	200	420	500	50	125	26kg	30KN
3A.1-3x300			300	520	600			29kg	
3A.1-4x200	175	60	200	455	530	58	145	37kg	30KN
3A.1-4x300			300	555	630			42kg	
3A.1-4x400			400	655	730			47kg	
3A.1-4x500			500	755	830			52kg	
3A.1-5x200	200	65	200	495	580	70	170	64kg	40KN
3A.1-5x300			300	595	680			69kg	
3A.1-5x400			400	695	780			74kg	
3A.1-5x500			500	795	880			79kg	
3A.1-5x600			600	895	980			84kg	
3A.1-6x200	300	80	200	535	630	78	195	95kg	40KN
3A.1-6x300			300	635	730			105kg	
3A.1-6x400			400	735	830			115kg	
3A.1-6x500			500	835	930			125kg	
3A.1-6x600			600	935	1030			135kg	
3A.1-6x700			700	1035	1130			145kg	
3A.1-6x800			800	1135	1230			155kg	

**3A.20 单向夹紧长钳**  
Single large opening

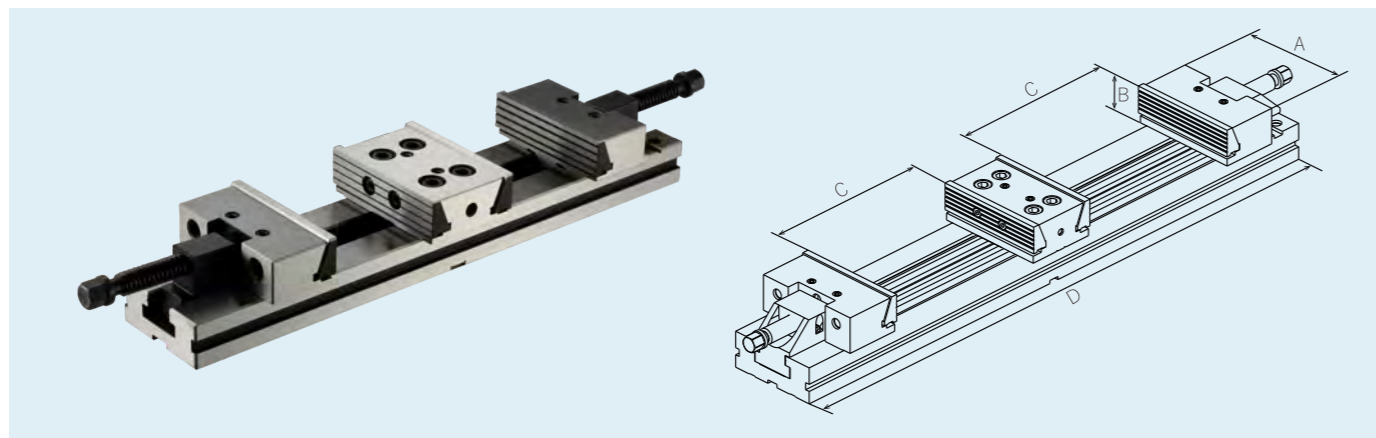


**技术参数**  
Table dimension

单位: mm

编号 Model NO	钳口宽A jaw width	钳口高B jaw height	开口度C jaw open	钳体长D base length	重量KG vise weight	夹紧力KN camping force
3A.20-1x290	100	30	290	460	10kg	16KN
3A.20-2x320	125	40	320	520	17kg	25KN
3A.20-3x360	150	50	360	580	31kg	30KN
3A.20-3x460			460	680	34kg	
3A.20-4x400	175	60	400	666	46kg	30KN
3A.20-4x500			500	766	51kg	
3A.20-4x600			600	866	56kg	
3A.20-4x700			700	966	61kg	
3A.20-5x500	200	65	500	805	85kg	40KN
3A.20-5x600			600	905	92kg	
3A.20-5x700			700	1005	99kg	
3A.20-5x800			800	1105	106kg	
3A.20-5x900			900	1205	113kg	
3A.20-6x500	300	80	500	900	127kg	40KN
3A.20-6x600			600	1000	137kg	
3A.20-6x700			700	1100	147kg	
3A.20-6x800			800	1200	157kg	

3A . 30 双向夹紧长钳  
Double opening



- ▶ 规格 双向夹紧长钳系列平口钳是二合一的平口钳，可作单向钳用（超长开口度），也可作双向钳用（双工位开口度），为客户节约开支增强加工能力。
- ▶ Version XL vises enable to have 2 vises in because they can quickly change from double vise to single vise with very large opening.

技术参数  
Table dimension

单位：mm

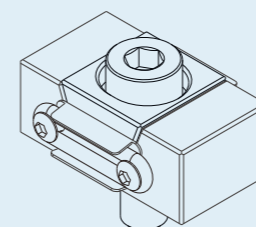
编号 Model NO	钳口宽A jaw width	钳口高B jaw height	开口度C jaw open	钳体长D base length	重量KG vise weight	夹紧力KN clamping force
3A.30-1x90	100	30	90	460	14kg	16KN
3A.30-2x100	125	40	100	520	20kg	25KN
3A.30-3x110	150	50	110	580	38kg	30KN
3A.30-3x160			160	680	42kg	
3A.30-4x120	175	60	120	666	58kg	30KN
3A.30-4x170			170	766	63kg	
3A.30-4x220			220	866	68kg	
3A.30-4x270			270	966	73kg	
3A.30-5x150	200	65	150	805	95kg	40KN
3A.30-5x200			200	905	101kg	
3A.30-5x250			250	1005	107kg	
3A.30-5x300			300	1105	113kg	
3A.30-5x350	300	80	350	1205	119kg	40KN
3A.30-6x160			160	900	155kg	
3A.30-6x210			210	1000	163kg	
3A.30-6x260			260	1100	171kg	
3A.30-6x310			310	1200	179kg	

# 其他夹具

Other fixtures

## 侧向膨胀器

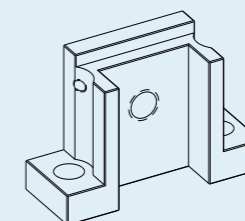
Lateral expander



P.105~P.106

## 组合夹具

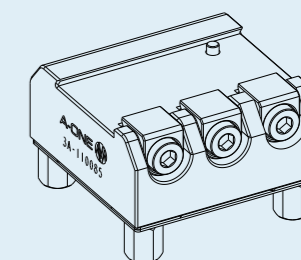
Combination fixture



P.107~P.110

## 燕尾槽夹具

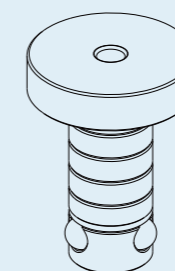
Forked tail holder



P.111~P.116

## A-ONE球锁轴系统

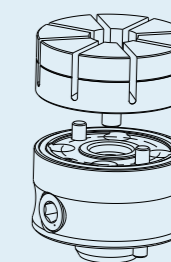
A-ONE Ball lock system



P.117~P.119

## 外形夹紧工具

Outside Shape clamping fixture



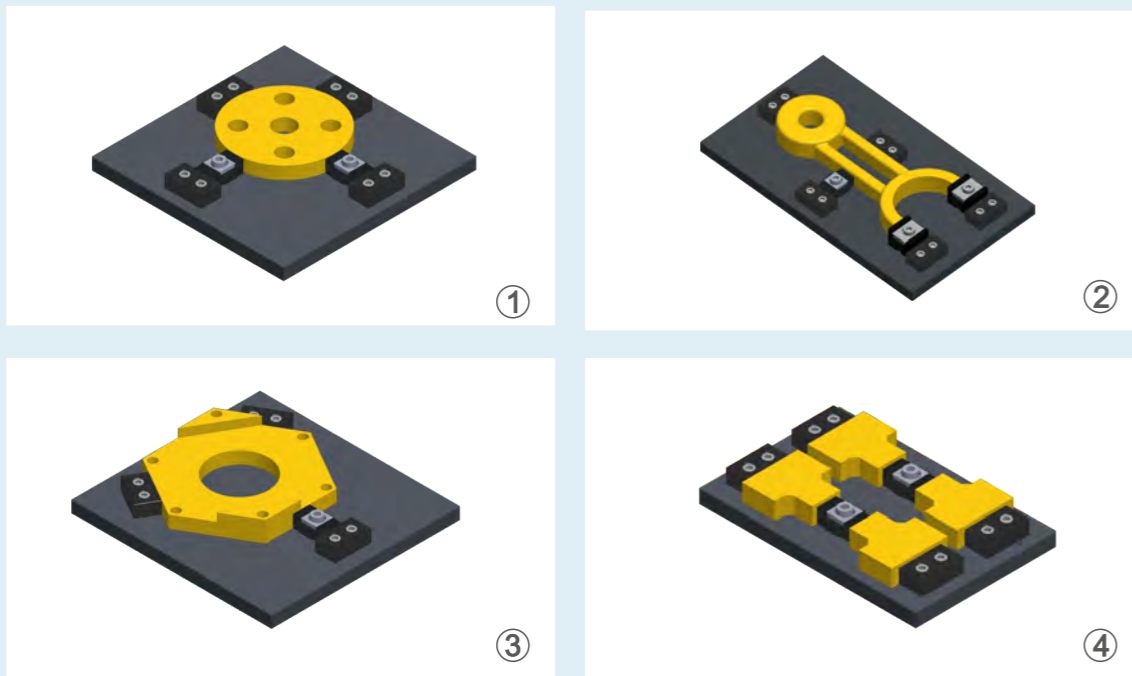
P.120



侧向膨胀器

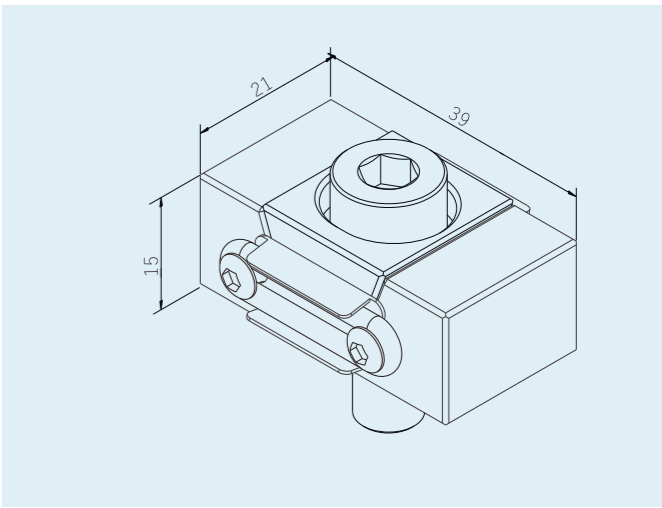
侧向膨胀器

侧向膨胀器应用范例



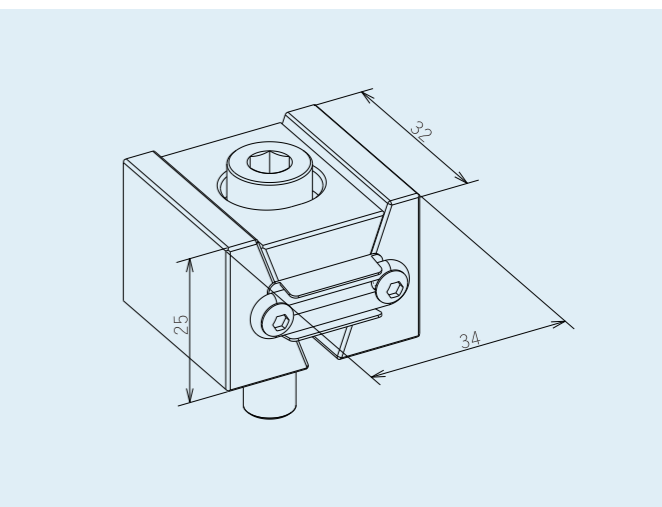
3A-110081 侧向膨胀器 39×21×15mm  
Lateral expander 39×21×15mm

- ▶ 规格 39\*21\*15mm. 夹紧行程 3mm
- ▶ 应用 零件夹持
- ▶ 特点 结构紧凑, 一次夹持两个零件, 根据产品规格和外形可灵活组合
- ▶ Version 39\*21\*15 mm. The clamping stroke is 3mm
- ▶ Application For clamping component
- ▶ Advantage Compact structure, clamping two components per time, flexible combination according to the product specifications and shape



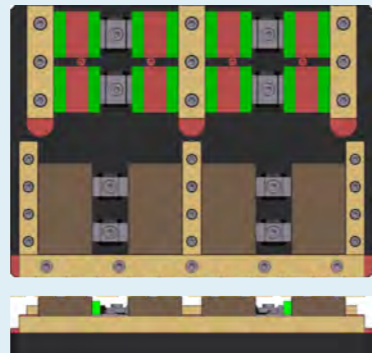
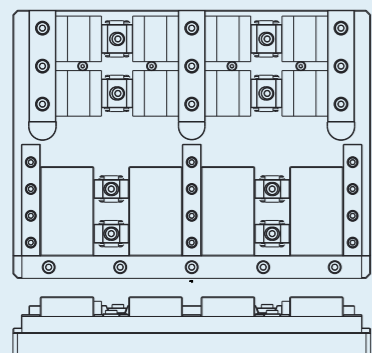
3A-110083 侧向膨胀器 34×32×25 mm  
Lateral expander 34×32×25mm

- ▶ 规格 34\*32\*25mm. 夹紧行程 3mm
- ▶ 应用 零件夹持
- ▶ 特点 结构紧凑, 一次夹持两个零件, 根据产品规格和外形可灵活组合
- ▶ Version 34\*32\*25mm. The clamping stroke is 3mm
- ▶ Application For clamping component
- ▶ Advantage Compact structure, clamping two components per time, flexible combination according to the product specifications and shape



特点:  
Characteristics:

1. 选用六角扳手轻松锁紧的设计结构  
Easy to lock design structure with hex wrench
2. 迷你型虎钳具有更换工件及设置快速的特点, 可灵活运用因不同变化的设计需求  
The mini vise has the characteristics of changing workpieces and setting up quickly, and can be flexibly applied to different design requirements.
3. 适用于不同工作平台 (三轴、四轴、五轴及卧式皆可使用)  
Suitable for different kinds of machine table. (3-axis, 4-axis, 5-axis and horizontal can be used)



▶ 加工零件范例

▶ 加工零件范例

零点定位系统

UPC系统

下拉圆柱夹具

基准卡盘

R型系列夹具

自定心虎钳

零点定位快锁

夹紧装置

侧向膨胀工具

零点定位系统

UPC系统

下拉圆柱夹具

基准卡盘

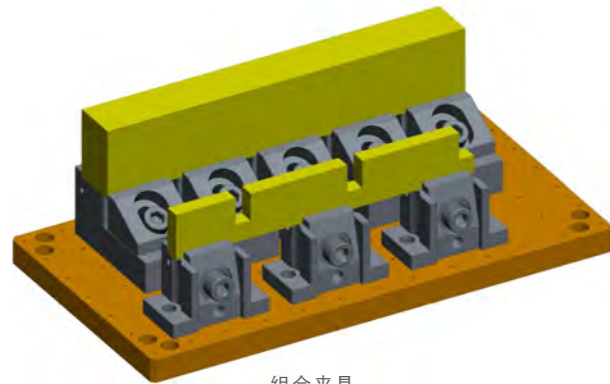
R型系列夹具

自定心虎钳

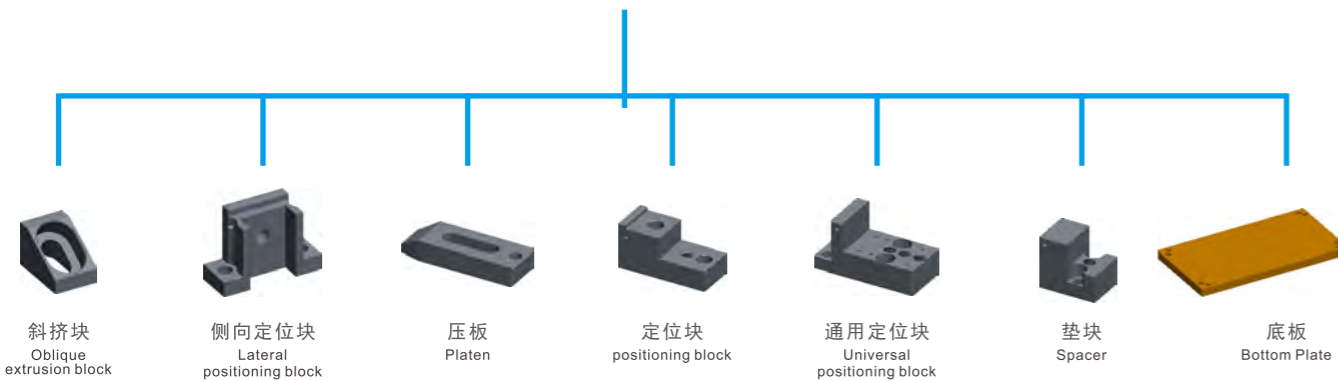
零点定位快锁

夹紧装置

侧向膨胀工具



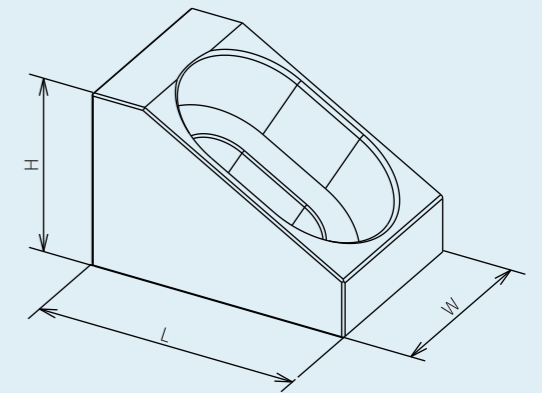
组合夹具  
Combination fixture



斜挤块  
Oblique extrusion block

- ▶ 规格 组合配件一
- ▶ 材质 45#钢, 表面发黑处理
- ▶ 应用 用于挤压零件
- ▶ 注意 可按客户要求定制
- ▶ Version Combination accessories include the following categories: Oblique extrusion block
- ▶ Material 45# steel with surface blackening
- ▶ Advantage For extruding parts
- ▶ Notice It can be customized according to customer requirements

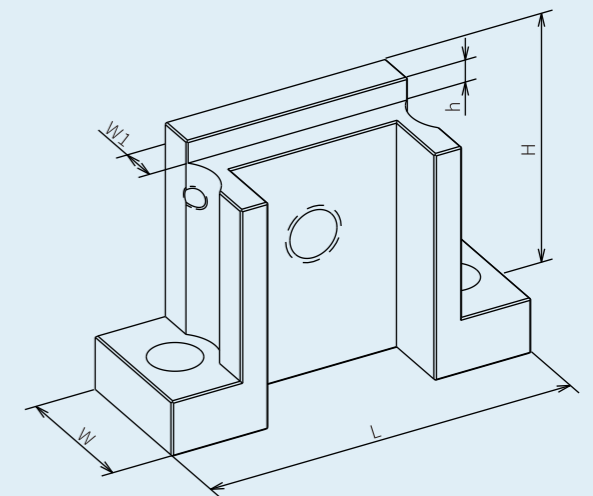
名称 Name	L	W	H
斜挤块35 Oblique extrusion block35	35	24	24
斜挤块45 Oblique extrusion block45	45	24	24
斜挤块45 Oblique extrusion block45	55	24	24
宽斜挤块35 Wide Oblique extrusion block45	35	40	24
宽斜挤块45 Wide Oblique extrusion block45	45	40	24



侧向定位块  
Lateral positioning block

- ▶ 规格 组合配件二
- ▶ 材质 45#钢, 表面发黑处理
- ▶ 应用 用于定位细长零件
- ▶ 注意 可按客户要求定制
- ▶ Version Combination accessories include the following categories: Lateral positioning block
- ▶ Material 45# steel with surface blackening
- ▶ Advantage For positioning slender parts
- ▶ Notice It can be customized according to customer requirements

名称 Name	L	W	W1	H	h
侧向定位块 Lateral positioning block	65	24	7	45	4
	65	35	7	45	4
	65	24	7	60	4
	65	35	7	60	4
加宽侧向定位块 Widen lateral positioning block	115	24	7	45	4
	115	50	7	45	4
	115	24	7	60	4
	115	50	7	60	4



原理介绍

Principle introduction

通过一系列标准的夹具配件, 使用“搭积木”的方式搭配出所需要的夹具;  
Through a series of standard fixture accessories, use "building blocks" to match the required fixtures

优势

Advantage

- 1. 实现夹具配件标准化, 减少夹具准备时间。  
1. Standardize fixture accessories and reduce fixture preparation time
- 2. 标准的夹具配件可有效降低制作夹具成本。  
2. Standard fixture accessories can effectively reduce the cost of making fixtures
- 3. 通用性强, 可根据产品随意组合。  
3. Strong versatility, can be freely combined according to products
- 4. 降低夹具损耗成本, 组合配件可循环使用。  
4. Reduce the cost of fixture loss, and the combined accessories can be recycled

应用案例

Application case

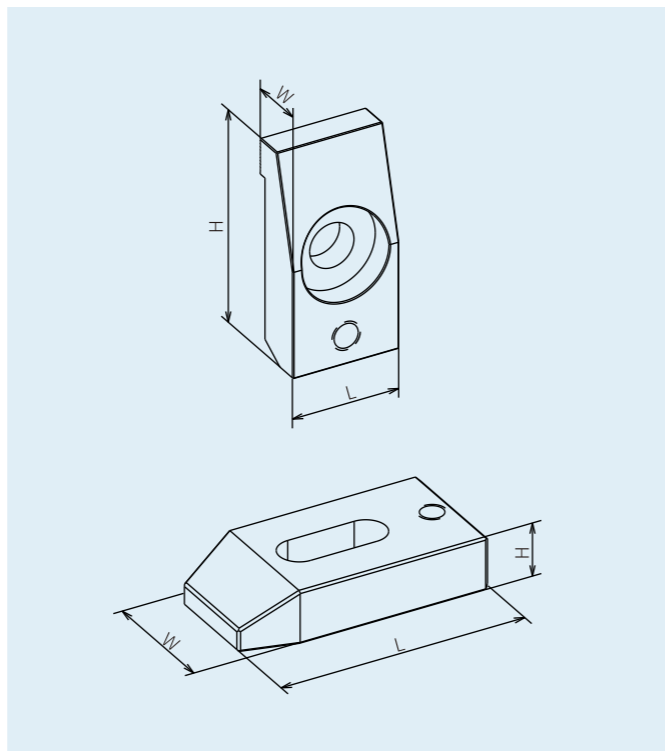




压板  
Platen

- ▶ 规格 组合配件三
- ▶ 材质 45#钢, 表面发黑处理
- ▶ 应用 用于压紧零件
- ▶ 注意 可按客户要求定制
- ▶ Version Combination accessories include the following categories:Platen
- ▶ Material 45# steel with surface blackening
- ▶ Advantage For compacting parts
- ▶ Notice It can be customized according to customer requirements

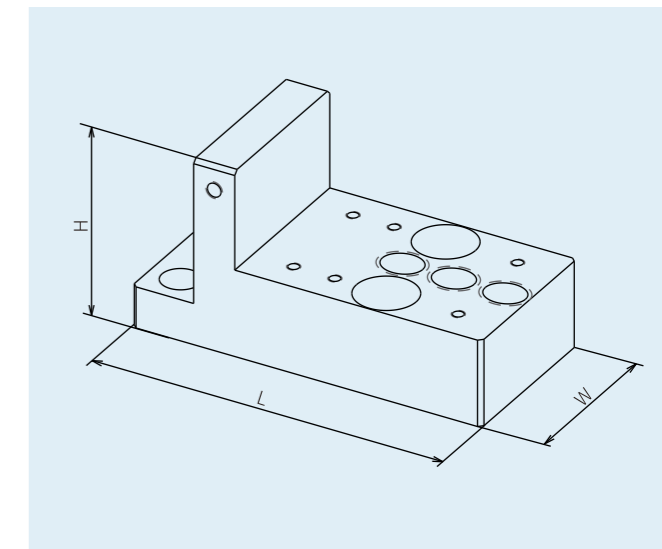
名称 Name	L	W	H
侧向压板 Lateral platen	30	16	60
	30	15	45
压板 Platen	55	28	12
	70	24	12
	50	28	12
	60	24	12
	90	24	12
	30	12	8
	35	18	8



通用定位块  
Universal positioning block

- ▶ 规格 组合配件五
- ▶ 材质 45#钢, 表面发黑处理
- ▶ 应用 用于定位方形零件
- ▶ 注意 可按客户要求定制
- ▶ Version Combination accessories include the following categories: Universal positioning block
- ▶ Material 45# steel with surface blackening
- ▶ Advantage For positioning square parts
- ▶ Notice It can be customized according to customer requirements

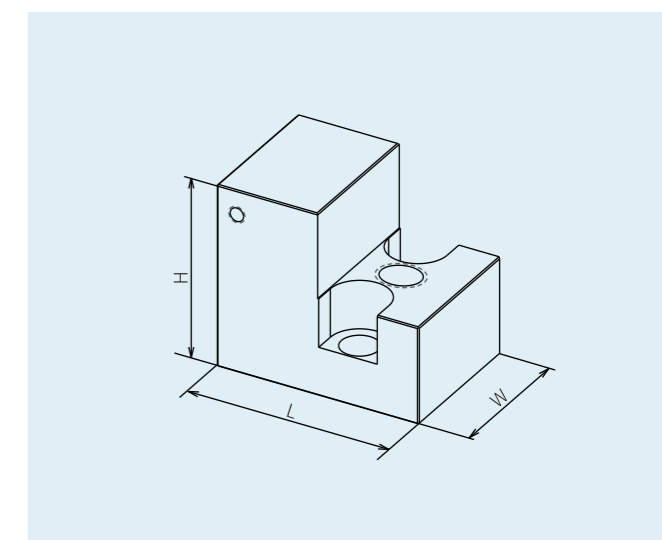
名称 Name	L	W	H
定位块 Positioning block	50	35	45
通用定位块 Universal positioning block	85	40	45



垫块  
Spacer

- ▶ 规格 组合配件六
- ▶ 材质 45#钢, 表面发黑处理
- ▶ 应用 用于垫高零件, 定位零件下表面
- ▶ 注意 可按客户要求定制
- ▶ Version Combination accessories include the following categories: Spacer
- ▶ Material 45# steel with surface blackening
- ▶ Advantage Used to elevate parts and locate the lower surface of parts
- ▶ Notice It can be customized according to customer requirements

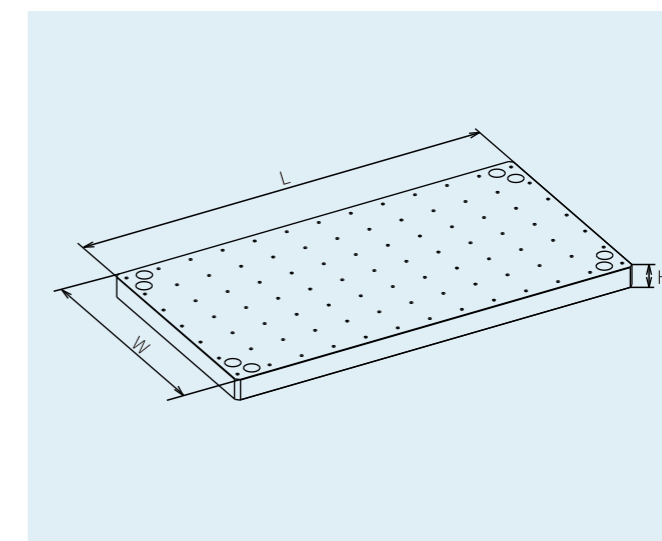
名称 Name	L	W	H
垫块 Spacer	40	20	21
	40	10	21
	50	40	21



底板  
Bottom Plate

- ▶ 规格 组合配件七
- ▶ 材质 45#钢, 表面发黑处理
- ▶ 应用 用于夹具底板
- ▶ 注意 可按客户要求定制
- ▶ Version Combination accessories include the following categories: Bottom Plate
- ▶ Material 45# steel with surface blackening
- ▶ Advantage used for fixture bottom plate
- ▶ Notice It can be customized according to customer requirements

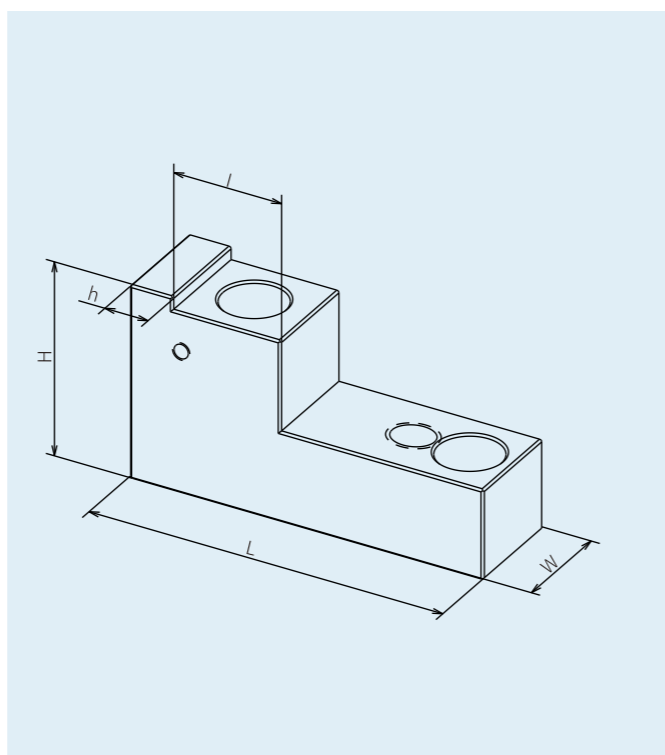
名称 Name	L	W	H
底板 Bottom Plate	310	165	16
	400	205	18

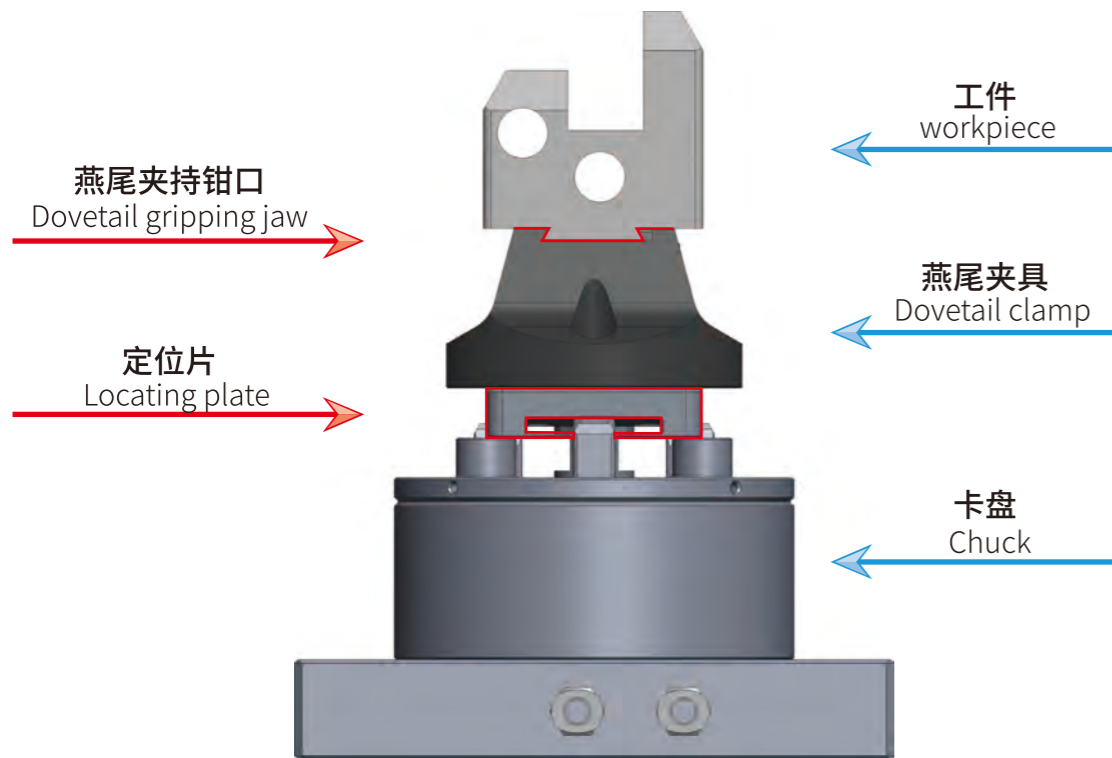


定位块  
Positioning block

- ▶ 规格 组合配件四
- ▶ 材质 45#钢, 表面发黑处理
- ▶ 应用 用于定位零件
- ▶ 注意 可按客户要求定制
- ▶ Version Combination accessories include the following categories:Positioning block
- ▶ Material 45# steel with surface blackening
- ▶ Advantage For positioning parts
- ▶ Notice It can be customized according to customer requirements

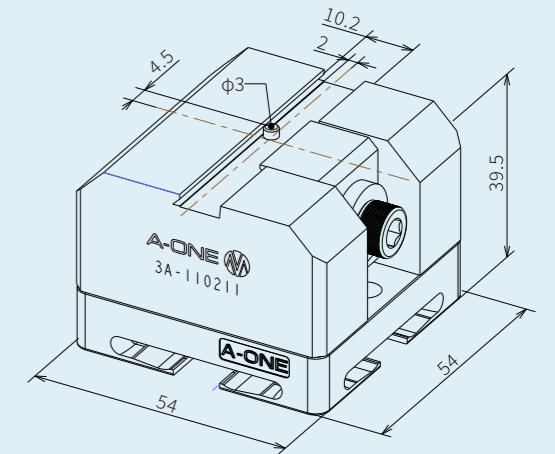
名称 Name	L	I	W	H	h
宽定位块 wide positioning block	82	25	40	45	3
	90	35	40	45	3
	100	45	40	45	3
定位块 Positioning block	72	*	24	45	*
	92	*	24	45	*
	82	25	24	45	3
	92	35	24	45	3
	102	45	24	45	3
	112	55	24	45	3
	122	65	24	45	3
	132	75	24	45	3
	142	85	24	45	3
50	*	35	45	*	





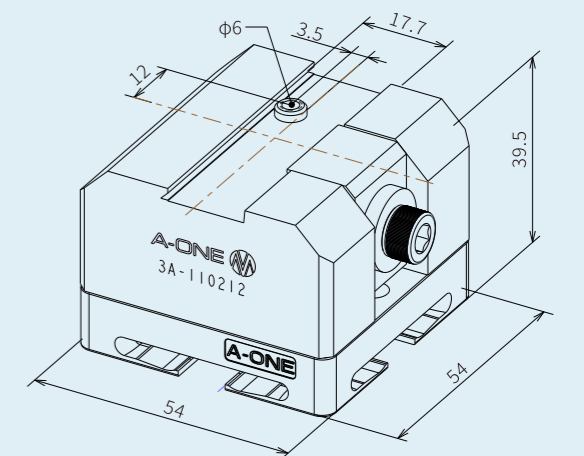
3A-110211 燕尾夹R12  
Dovetail collet R12

- ▶ 规格 夹具尺寸54\*54\*39.5mm, 燕尾宽度10.2mm  
标配R型接口, 燕尾角度45°
- ▶ 应用 钢、铜、铝等金属材料切削加工
- ▶ 特点 夹位小, 夹持力大, 一次夹持五面加工  
尺寸小巧, 安装范围广泛
- ▶ Version 54\*54\*39.5mm, dovetail width 10.2mm, with 3R  
standard interface, dovetail angle 45°
- ▶ Application Stainless steel, Copper, aluminum and other metal  
cutting processing
- ▶ Advantage Small clamping position, large clamping force, 5-axis machining  
per time, clamping outside the machine, fast switching



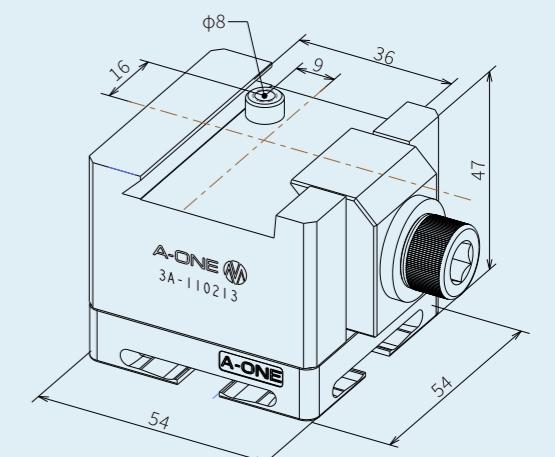
3A-110212 燕尾夹R25  
Dovetail collet R25

- ▶ 规格 夹具尺寸54\*54\*39.5mm, 燕尾宽度17.7mm  
标配R型接口, 燕尾角度45°
- ▶ 应用 钢、铜、铝等金属材料切削加工
- ▶ 特点 夹位小, 夹持力大, 一次夹持五面加工  
尺寸小巧, 安装范围广泛
- ▶ Version 54\*54\*39.5mm, dovetail width 17.7mm, with 3R  
standard interface, dovetail angle 45°
- ▶ Application Stainless steel, Copper, aluminum and other metal  
cutting processing
- ▶ Advantage Small clamping position, large clamping force, 5-axis machining  
per time, clamping outside the machine, fast switching



3A-110213 燕尾夹R50  
Dovetail collet R50

- ▶ 规格 夹具尺寸54\*54\*47mm, 燕尾宽度36mm  
标配R型接口, 燕尾角度45°
- ▶ 应用 钢、铜、铝等金属材料切削加工
- ▶ 特点 夹位小, 夹持力大, 一次夹持五面加工  
尺寸小巧, 安装范围广泛
- ▶ Version 54\*54\*47mm, dovetail width 36mm, with 3R  
standard interface, dovetail angle 45°
- ▶ Application Stainless steel, Copper, aluminum and other metal  
cutting processing
- ▶ Advantage Small clamping position, large clamping force, 5-axis machining  
per time, clamping outside the machine, fast switching



提供燕尾夹具个性化定制

Offer customized dovetail clamp

燕尾夹具具有快速、稳定、夹紧力大、所需夹持位少等特点，一次装夹可实现五面加工。

The dovetail clamp has the characteristics of fast, stable, large clamping force and less required clamping position, which can realize 5-axis machining per time.

A-ONE燕尾夹具系列产品丰富，标配ITS接口、也可支持直接锁紧安装，提供定制服务，可按要求进行设计与制作。

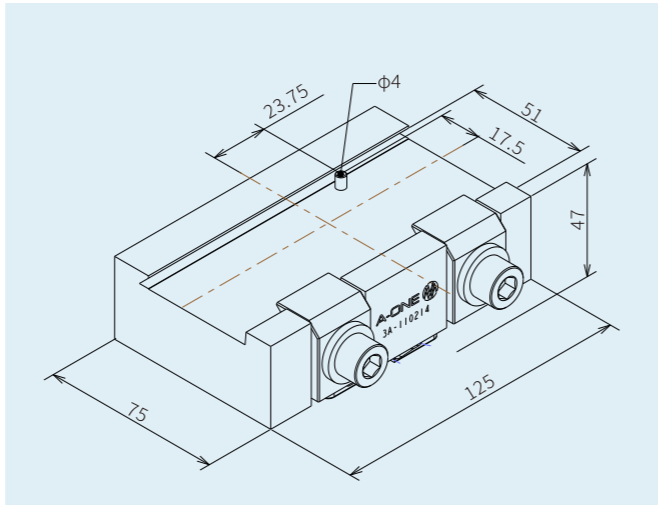
A-ONE dovetail clamps are available in a wide range of products, with standard ITS interfaces and direct locking installation. Customized services are available and can be designed and produced as required.





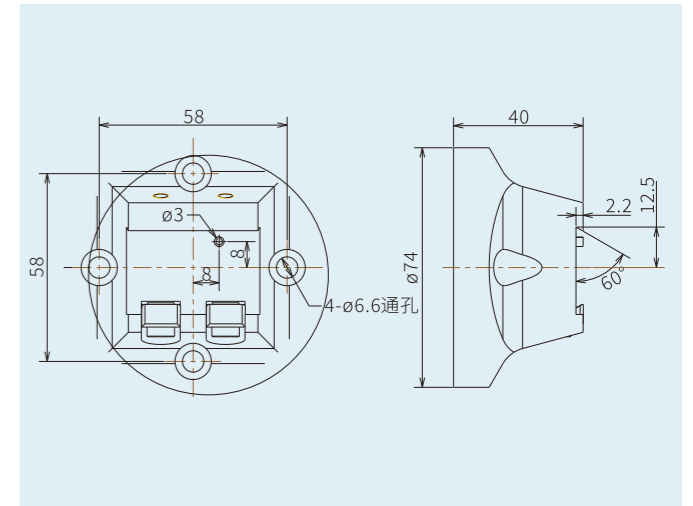
**3A-110214** 燕尾夹R75  
Dovetail collet R75

- ▶ 规格 夹具尺寸125\*75\*47mm, 燕尾宽度51mm 标配R型接口, 燕尾角度45°
- ▶ 应用 钢、铜、铝等金属材料切削加工
- ▶ 特点 夹位小, 夹持力大, 一次夹持五面加工 尺寸小巧, 安装范围广泛
- ▶ Version 125\*75\*47mm, dovetail width 51mm, with 3R standard interface, dovetail angle 45°
- ▶ Application Stainless steel, Copper, aluminum and other metal cutting processing
- ▶ Advantage Small clamping position, large clamping force, 5-axis machining per time, clamping outside the machine, fast switching



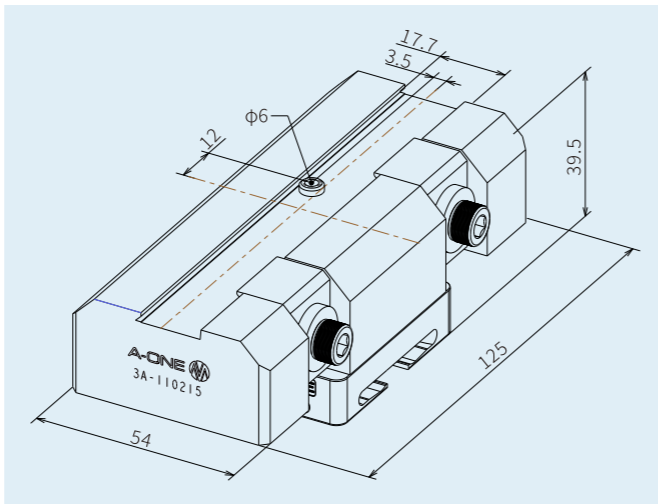
**3A-110089** 燕尾夹头Φ74  
Dovetail collet Φ74

- ▶ 规格  $\phi 74 \times 40$ mm 燕尾宽度25mm, 利用螺丝连接机台或安装板 燕尾角度60°
- ▶ 应用 铜、铝等金属材料切削加工
- ▶ 特点 胚料定位, 夹位小, 一次夹持五面加工 尺寸小巧, 安装范围广泛
- ▶ Version  $\phi 74 \times 40$ mm, with dovetail width 25mm and standard ITS 50 interface, connecting the machine or mounting plate with screws, dovetail angle 60°
- ▶ Application Copper, aluminum and other metal cutting processing
- ▶ Advantage Blank positioning, small clamping position, 5-axis machining per time, small size and wide installation range



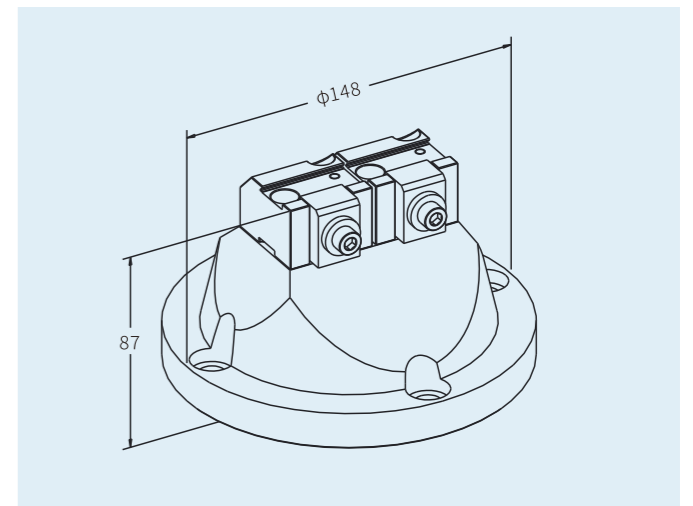
**3A-110215** 燕尾夹R25L  
Dovetail collet R25L

- ▶ 规格 夹具尺寸125\*54\*39.5mm, 燕尾宽度17.7mm 标配R型接口, 燕尾角度45°
- ▶ 应用 钢、铜、铝等金属材料切削加工
- ▶ 特点 夹位小, 夹持力大, 一次夹持五面加工 尺寸小巧, 安装范围广泛
- ▶ Version 125\*54\*39.5mm, dovetail width 17.7mm, with 3R standard interface, dovetail angle 45°
- ▶ Application Stainless steel, Copper, aluminum and other metal cutting processing
- ▶ Advantage Small clamping position, large clamping force, 5-axis machining per time, clamping outside the machine, fast switching



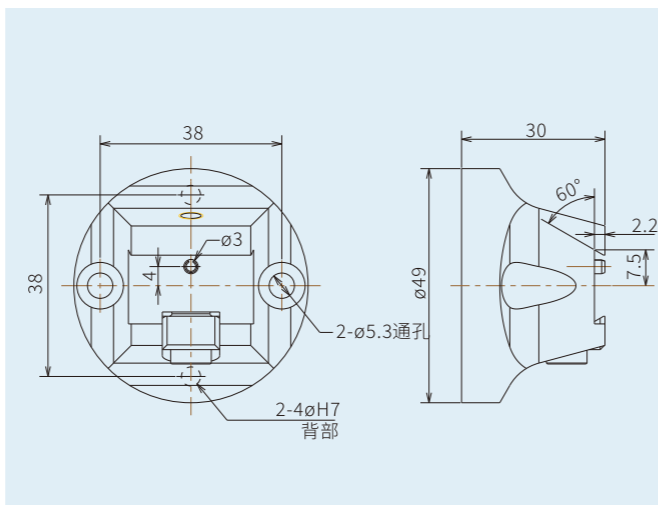
**3A-110077** U16 燕尾托板 G  
U16 Dovetail pallet G

- ▶ 规格 夹具底板可根据要求非标定制
- ▶ 应用 五轴机床加工
- ▶ 特点 统一燕尾夹位, 工件重复定位精度可达 0.02mm 以内 用于一次装夹多面加工
- ▶ Version Fixture pallet can be customized
- ▶ Application For using 5 axis machine
- ▶ Advantage Unique foreked tail holding position, Workpiece repeatability with 0.02mm. easy to clamping one and multi-surface machining.



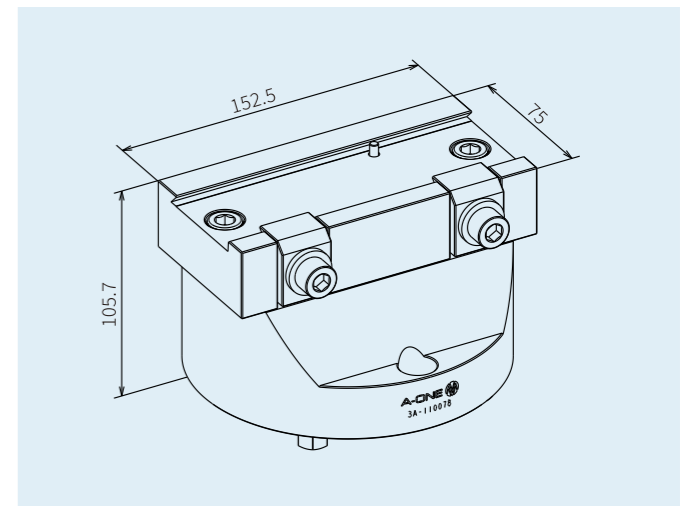
**3A-110079** 燕尾夹头Φ49  
Dovetail collet Φ49

- ▶ 规格  $\phi 49 \times 30$ mm 燕尾宽度15mm, 利用螺丝连接机台或安装板 燕尾角度60°
- ▶ 应用 铜、铝等金属材料切削加工
- ▶ 特点 胚料定位, 夹位小, 一次夹持五面加工 尺寸小巧, 安装范围广泛
- ▶ Version  $\phi 49 \times 30$ mm, with dovetail width 15mm and standard ITS 50 interface, connecting the machine or mounting plate with screws, dovetail angle 60°
- ▶ Application Copper, aluminum and other metal cutting processing
- ▶ Advantage Blank positioning, small clamping position, 5-axis machining per time, small size and wide installation range



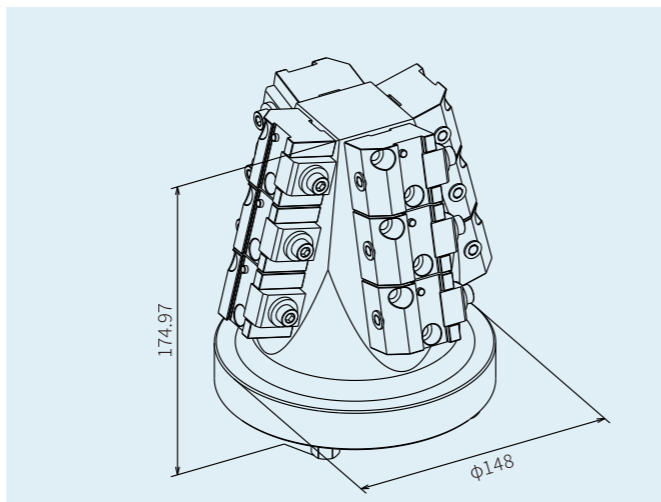
**3A-110078** U50 燕尾托板 G  
U50 Dovetail pallet G

- ▶ 规格 夹具底板可根据要求非标定制
- ▶ 应用 五轴机床加工
- ▶ 特点 统一燕尾夹位, 工件重复定位精度可达 0.02mm 以内 用于一次装夹多面加工
- ▶ Version Fixture pallet can be customized
- ▶ Application For using 5 axis machine
- ▶ Advantage Unique foreked tail holding position, Workpiece repeatability with 0.02mm. easy to clamping one and multi-surface machining.



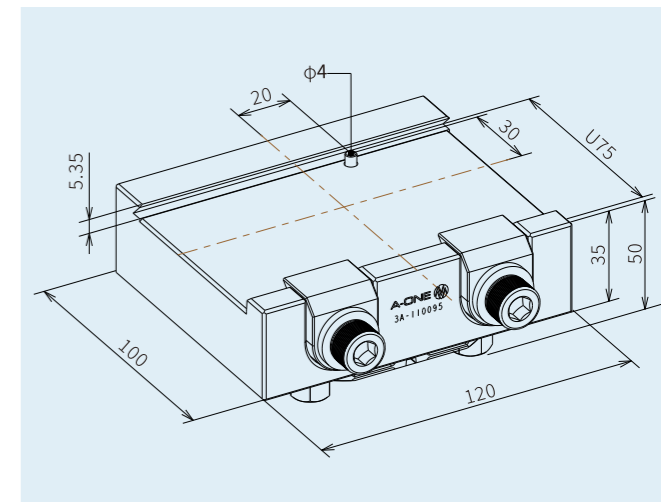
燕尾托板 A  
Dovetail pallet A

- ▶ 规格 夹具底板可根据要求非标定制
- ▶ 应用 卧式四轴机床加工
- ▶ 特点 统一燕尾夹位, 工件重复定位精度可达 0.02mm 以内用于一次装夹多面加工
- ▶ Version Fixture pallet can be customized
- ▶ Application 4 axis horizontal lathe machining
- ▶ Advantage Unique forked tail holding position, workpiece repeatability with 0.02mm. easy to clamping one time and multi-surface machining



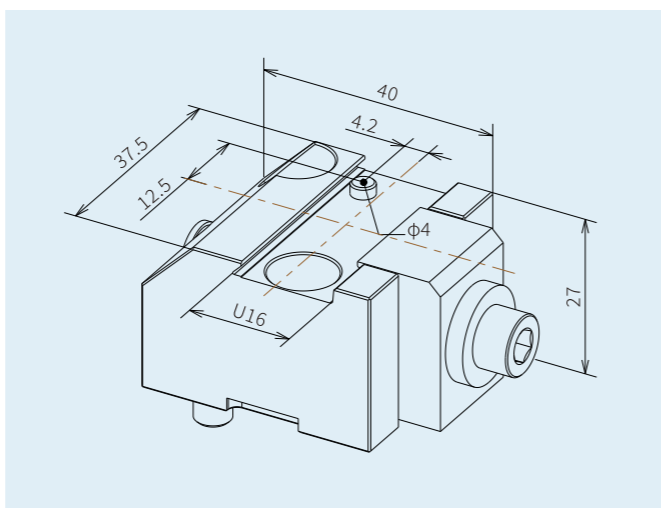
3A-110095 带G片燕尾夹U75  
U75 Dovetail holder with G plate

- ▶ 规格 夹具尺寸120\*100\*35mm, 燕尾宽度75mm, 燕尾角度45°, 带G片接口
- ▶ 应用 铜, 铝等金属材料切削加工
- ▶ 特点 夹位小, 且夹持力大, 一次夹持五面加工, 机外装夹, 快速切换
- ▶ Version 120\*100\*35mm, dovetail width 75mm, dovetail angle 45°, with interface of G plate
- ▶ Application Cutting processing of metal material such as aluminum and copper
- ▶ Advantage Small clamping position, large clamping force, 5-axis machining per time, clamping outside the machine, fast switching



3A-110064 燕尾槽夹具 U16  
Dovetail slotted holder U16

- ▶ 规格 夹具尺寸40\*37.5\*27mm, 燕尾宽度17mm, 用销钉与螺丝连接于托板, 燕尾角度45°
- ▶ 应用 铜, 铝等金属材料切削加工
- ▶ 特点 夹位小, 夹持力大, 一次夹持五面加工, 尺寸小巧, 安装范围广泛
- ▶ Version 40\*37.5\*27mm, dovetail width 17mm, connecting pallet with pins, dovetail angle 45°
- ▶ Application Copper, aluminum and other metal cutting processing
- ▶ Advantage Small clamping position, large clamping force, 5-axis machining per time, clamping outside the machine, fast switching

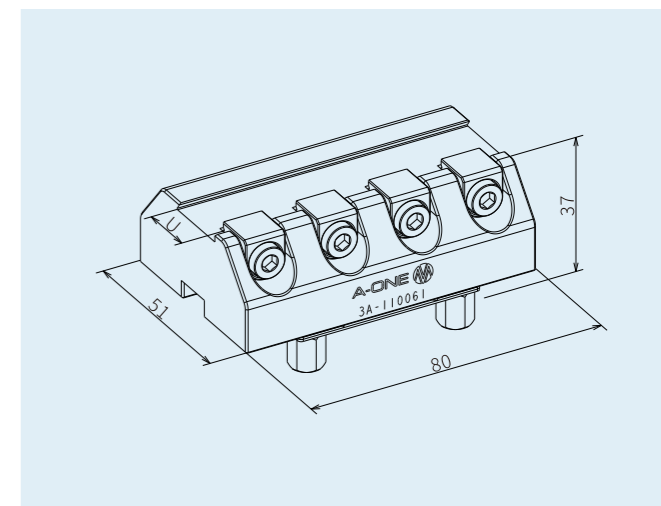


3A-110061 燕尾夹头 U15  
Dovetail collet U15

3A-110062 燕尾夹头 U20  
Dovetail collet U20

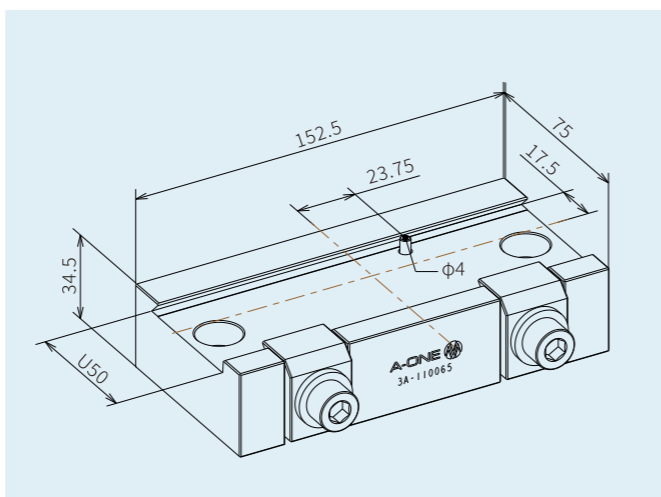
3A-110063 燕尾夹头 U25  
Dovetail collet U25

- ▶ 规格 夹具长80mm, 燕尾宽度15mm, 20mm, 25mm, 标配ITS50接口, 燕尾角度55°
- ▶ 应用 铜, 铝等金属材料切削加工
- ▶ 特点 夹位小, 夹持力大且一次夹持五面加工, 机外装夹, 快速切换
- ▶ Version Clamp length 80mm, with dovetail width 15mm, 20mm, 25mm and standard ITS 50 interface, dovetail angle 55°
- ▶ Application Copper, aluminum and other metal cutting processing
- ▶ Advantage Small clamping position, large clamping force, 5-axis machining per time, clamping outside the machine, fast switching



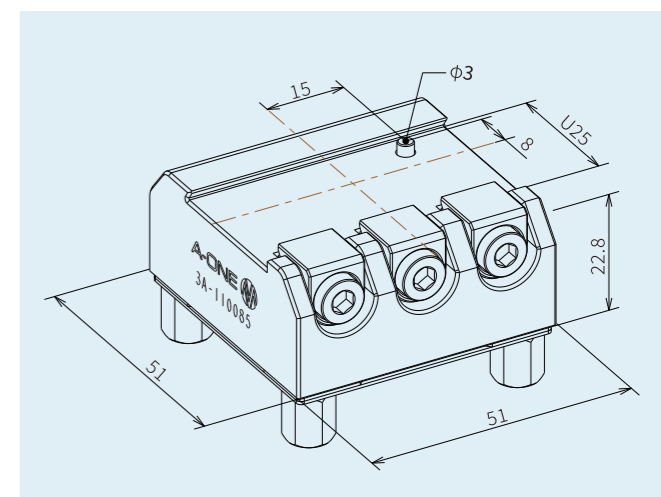
3A-110065 燕尾槽夹具 U50  
Dovetail slotted holder U50

- ▶ 规格 夹具尺寸75\*152.5\*34.5mm, 燕尾宽度50mm, 用销钉与螺丝连接于托板, 燕尾角度45°
- ▶ 应用 铜, 铝等金属材料切削加工
- ▶ 特点 夹位小, 夹持力大, 一次夹持五面加工, 尺寸小巧, 安装环境灵活
- ▶ Version 75\*152.5\*34.5mm, dovetail width 50mm, connecting pallet with pins, dovetail angle 45°
- ▶ Application Copper, aluminum and other metal cutting processing
- ▶ Advantage small clamping position, large clamping force, 5-axis machining per time, clamping outside the machine, fast switching



3A-110085 燕尾槽夹具 U25  
Dovetail collet U25

- ▶ 规格 夹具尺寸51\*51\*22.8mm, 燕尾宽度25mm, 标配ITS50接口, 燕尾角度55°
- ▶ 应用 铜, 铝等金属材料切削加工
- ▶ 特点 胚料定位, 夹位小, 且夹持力大, 一次夹持五面加工, 机外装夹, 快速切换
- ▶ Version 51\*51\*22.8mm, with dovetail width 25mm and standard ITS 50 interface, dovetail angle 55°
- ▶ Application Copper, aluminum and other metal cutting processing
- ▶ Advantage Blank positioning, small clamping position, large clamping force, 5-axis machining per time, clamping outside the machine, fast switching



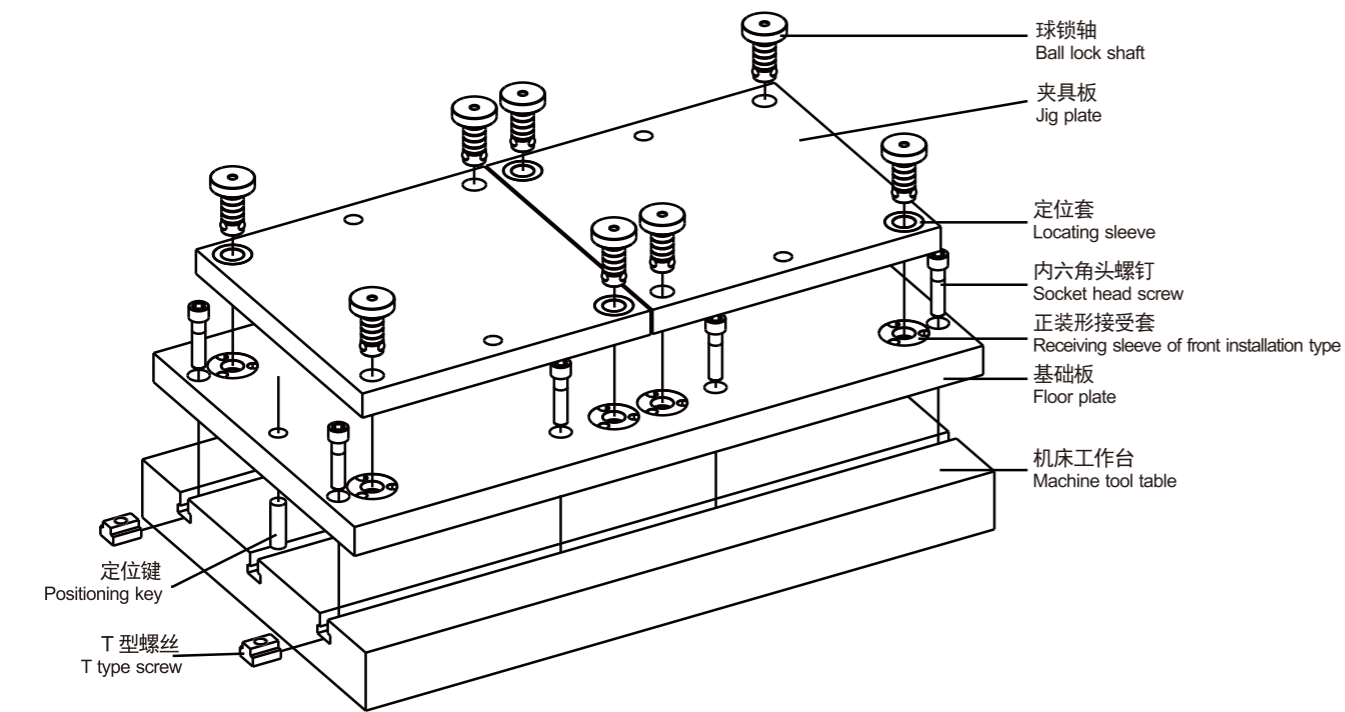


**定位 Positioning**

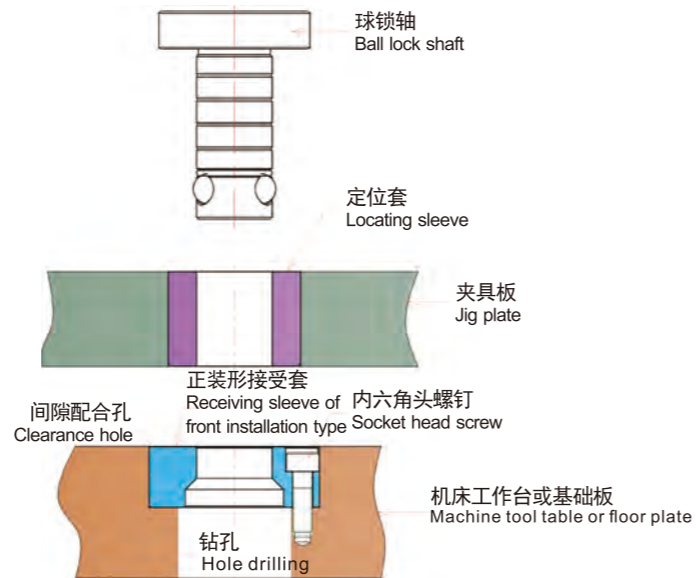
球锁系统可精确地定位工件，无需为夹具找正并且确保重复定位精度在 ±0.010mm 之内  
Ball Lock system can accurately locate the workpiece. It is not necessary to make alignment for the fixture and the resetting precision can be ensured within ± 0.010mm.

**锁紧 Locking**

球锁系统可将夹具板牢牢地固定在基础板上，每个轴最大可提供 9 吨的锁紧力。  
Ball Lock system can firmly fix the jig plate on the floor plate with a maximum of nine tons locking force for each axle.

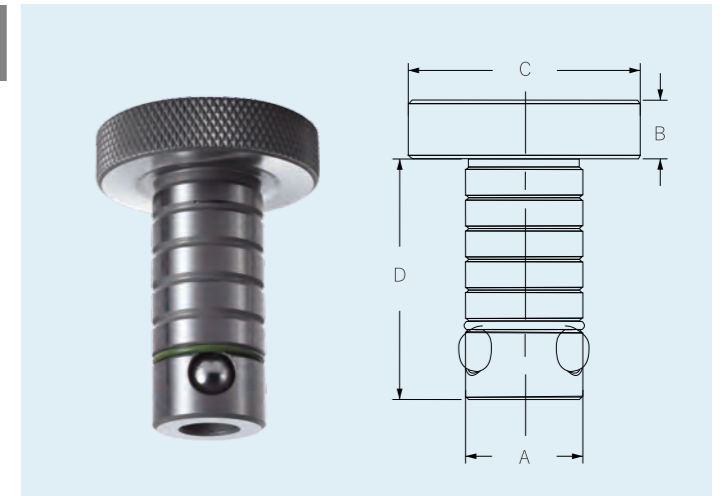


- 1) 基础板，作为定位基准，永久固定在机器工作台上。基础板上面装有多球锁接受套，配合不同大小的夹具板。
- 2) 夹具板，装有两个球锁定位套，与基础板上的接受套对应，通过球锁轴锁紧。
- 3) 球锁轴，起定位和锁紧的作用，通过与定位套配合，将夹具板快速、精确地固定在基础板上。有多种尺寸可供选择。



**定位锁紧球锁轴 - 公制**  
Locating and locking ball lock shaft—Metric system

- ▶ 热处理 球锁轴, HRC 40 - 45  
接受套, HRC 50 - 54  
定位套, HRC 62 - 64
- ▶ Version ball lock shaft, HRC 40-45  
receiving sets, HRC 50-54  
locating sleeve, HRC 62-64

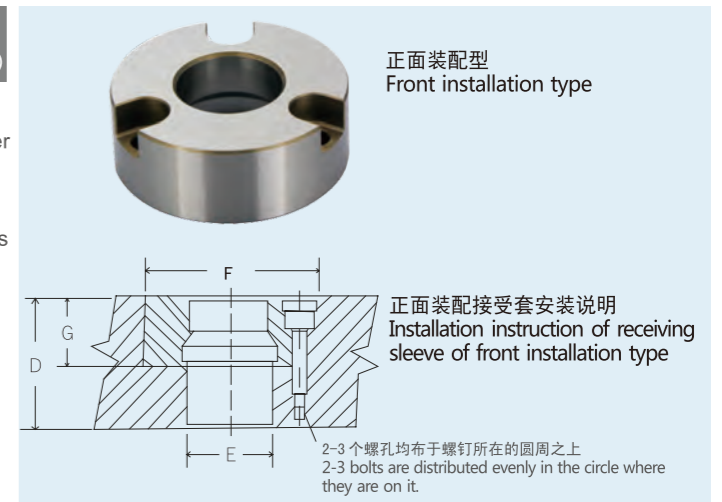


**定位锁紧球锁轴尺寸**  
Dimensions of locating and locking Ball Lock Shaft

编码 Model No.	A	夹具板厚度 ±0.13mm Thickness of jig plate	B	C	D	六角扳手尺寸 Hex wrench dimension	最大螺丝扭矩 (N.m) Max screw torque	最大夹紧力 (KN) Max clamping force	推荐螺丝扭矩 (N.m) Recommended screw torque	推荐夹紧力 (KN) Recommended clamping force
3A-700004	20	20	10	40	39.5	3	5.3	13.3	4	10
3A-700003	20	25	10	40	40.5	3	5.3	13.3	4	10
3A-700007	25	20	10	45	44.0	4	11	30	9	23
3A-700009	25	25	10	45	49.0	4	11	30	9	23
3A-700012	30	20	13	50	49.0	5	18	44	15	35
3A-700014	30	25	13	50	54.0	5	18	44	15	35

**接受套 (公制)**  
Receiving sleeve of front installation type is often used for blind holes (clearance fit)

- ▶ 安装好的接受套表面应低于基础板表面约 0.3mm
- ▶ The surface of fitted receiving sleeve should be about 0.3mm lower than the floor plate surface
- ▶ 正装型接受套常用于盲孔 (间隙配合)
- ▶ Receiving sleeve of front installation type is often used for blind holes (clearance fit)

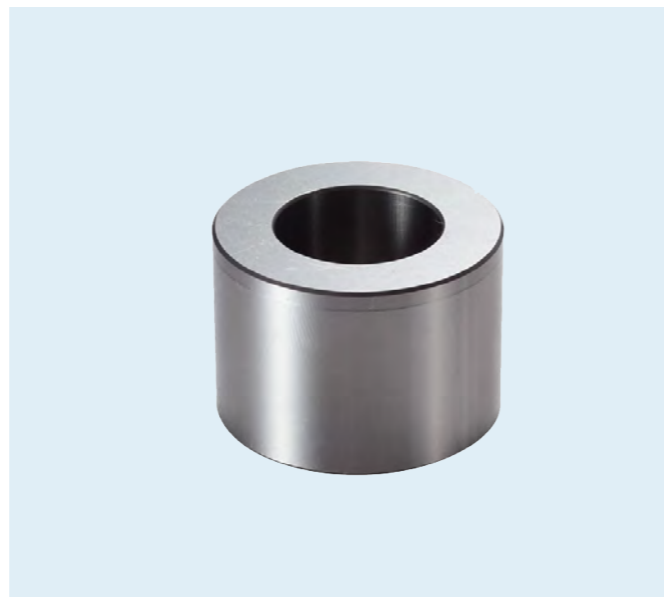


**安装尺寸 Installation dimension**  
正面装配 Front assembly

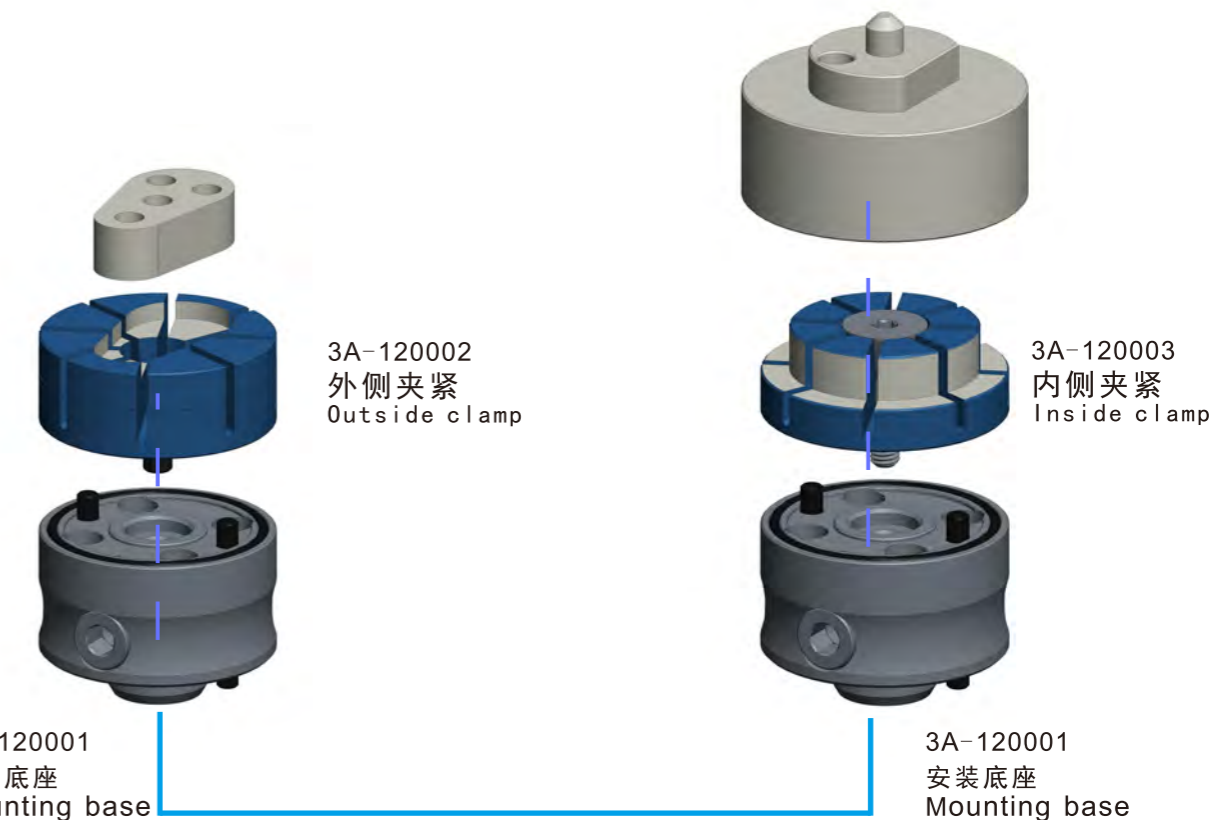
编码 Model No.	球锁轴直径 Diameter of ball lock shaft	实际外径 Actual external diameter	间隙孔直径 Diameter of clearance hole E	沉孔 Counterbore	深度 Depth	最小基础板厚度 Minimum floor plate thickness D
3A-700001	20	45	21.0	45	16.21	25
3A-700010	25	55	25.5	55	20.32	30
3A-700015	30	60	30.5	60	22.15	35

定位套  
Locating sleeve

- ▶ 重复定位精度将决定是否需要一级、二级定位套各一个还是两个一级定位套。用两个一级定位套的情况下，如果接受套两个孔的中心距在  $\pm 0.005$  mm 公差范围内，那就重复定位精度可以保持  $\pm 0.013$  mm 以内。
- ▶ Resetting precision will determine whether Class I & II locating sleeves are required one for each or only two Class I sleeves are required. If two Class I locating sleeves are applied and the center distance of the two holes of the receiving sleeve is within the tolerance range of  $\pm 0.005$  mm, the resetting precision can be maintained within  $\pm 0.013$  mm.
- ▶ 定位套及背面装配型接受套安装注意事项  
为了减少轴在内孔中取不出来的可能性，内孔和接受套外径配合的最大过盈量不得超过 0.013 mm。  
Installation Considerations for locating sleeve and receiving sleeve of back assembly type In order to minimize the possibility that the shaft cannot be taken out from the bore, the maximum amount of interference between the bore and the receiving sleeve can not exceed 0.013 mm
- ▶ 定位套尺寸  
▶ Dimensions of locating sleeve



编码 Model No.	球锁轴直径 (mm) Diameter of ball lock shaft	夹具板厚度 Thickness of jig plate	一级定位套内径 Internal diameter of Class I locating sleeve	定位套外径 external diameter of locating sleeve
3A-700005	20	20	20	35
3A-700002	20	25	20	35
3A-700006	25	20	25	35
3A-700008	25	25	25	35
3A-700011	30	20	30	45
3A-700013	30	25	30	45



外形夹紧工具 Outside Shape clamping fixture

- ▶ 规格 D65型
- ▶ Version D65 type
- ▶ 应用 用于小型异形件的夹持  
▶ Application To clamp small shaped workpiece
- ▶ 注意 用于4-M6螺栓安装于工作台底板上  
▶ Note To be mounted on the table of machining center with 4\*M6 bolt

型号 Model	名称 Name	安装 Mounting
3A-120001	D65型安装底座 D65 type mounting base	3A-120001
3A-120002	D65型外侧夹紧钳口 D65 type outside clamping jaw	
3A-120003	D65型内侧夹紧钳口 D65 type inner clamping jaw	
3A-120004	下拉圆锥螺栓 Drop-down conical bolt	适用于内侧夹紧钳口 Suitable for inside clamping jaw



部分合作伙伴 (排序不分先后)

# Partial partner

## 模具加工 Mold processing

- |        |        |       |        |      |
|--------|--------|-------|--------|------|
|        |        |       |        |      |
| 宝利根    | 宝田精工   | 比亚迪   | 常州华威模具 | 大豪车业 |
|        |        |       |        |      |
| 大连銓艺精密 | 得意电子   | 德丰电创  | 东菱     | 东泰精密 |
|        |        |       |        |      |
| 凤铝     | 富士康集团  | 广东长盈  | 赫比     | 恒德   |
|        |        |       |        |      |
| 宏丰     | 金莱特    | 金三维   | 精英模具   | 九江金鹭 |
|        |        |       |        |      |
| 九牧厨卫   | 莱克     | 理光    | 立讯精密工业 | 领益   |
|        |        |       |        |      |
| 绿点科技   | 南平铝业   | 宁波华德  | 宁波继峰   | 宁波均胜 |
|        |        |       |        |      |
| 普联     | 群创光电   | 厦门华尔达 | 山东豪迈   | 上海瀚氏 |
|        |        |       |        |      |
| 深圳凯中精密 | 伟康医疗   | 香港模具  | 烟台霍富   | 亿和   |
|        |        |       |        |      |
| 银宝山新   | 珠海格力大金 | 珠海三威  | 华益盛    | 海泰科  |

## 口碑好, 20多年经验积累

### Good word of mouth , More than 20 years of experience

凭借品质稳定、性价比高, 得到海内外客户的高度肯定。

Thanks to its stable quality and high cost performance, it is highly recognized by customers at home and abroad.



## 零件加工 Parts processing

- |           |      |           |        |        |
|-----------|------|-----------|--------|--------|
|           |      |           |        |        |
| ASM先进半导体  | TTI  | 北方自动控制研究所 | 彼联科技   | 伯恩光学   |
|           |      |           |        |        |
| 潮州三环      | 大博医疗 | 东莞祥鑫      | 国泰达鸣精密 | 杭州西子航空 |
|           |      |           |        |        |
| 恒拓高       | 华生电机 | 利元亨       | 南京造币厂  | 南兴木工   |
|           |      |           |        |        |
| 锐健        | 瑞声科技 | 上海航天      | 一汽大众   | 中船重工   |
|           |      |           |        |        |
| 中国工程物理研究院 | 中均科技 | 中山科瑞      | 迈瑞     | 深圳吉阳   |

## 其他 Other

- |        |    |      |      |     |       |
|--------|----|------|------|-----|-------|
|        |    |      |      |     |       |
| 北京精雕集团 | 牧野 | 航天壹巨 | 庆鸿机电 | 沙迪克 | 株洲科力特 |