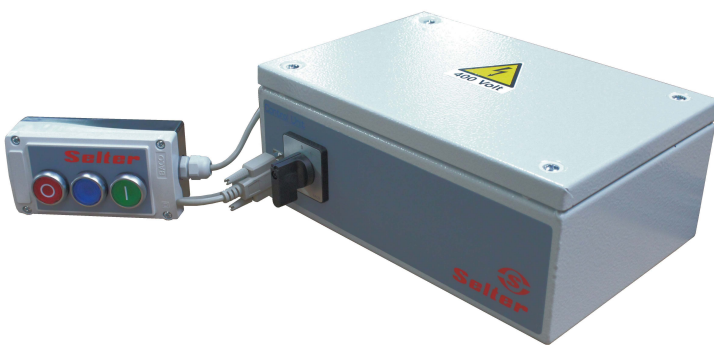


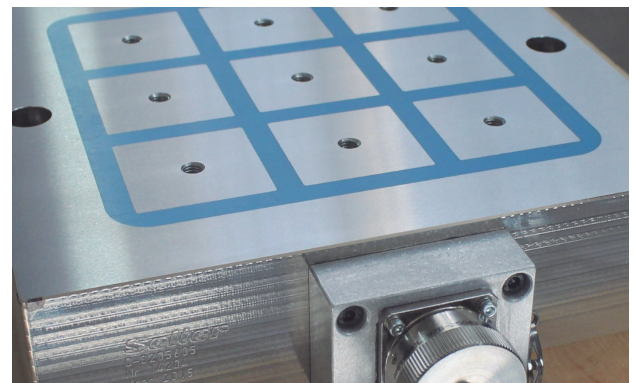
ELECTROPERMANENT MAGNETIC CHUCKS QUADRI-POL

These chucks have square poles with great magnetic power and they are specially designed to hold iron pieces in milling operations and CNC machines. They are built from a solid block of steel and have great stability and rigidity with no warping. The five accessible sides of the pieces can be machined in one only operation without the need of clamps or jaws. The chuck's electropermanent circuit offers the following advantages:

- Minimal energy consumption. Energy is only consumed during the magnetisation and demagnetisation process.
- Absence of warping as the chuck does not heat up.
- There is no risk of accident due to a cut in the power supply.



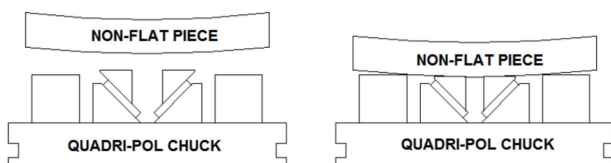
Electronic controller allows the sequential activation of the 1, 2, 3 and 4 chucks. It also incorporates a parasitic high power EMD filter, that complies with electromagnetic com-patibility directive.



POLAR EXTENSIONS

These extensions are prolongations of the chuck's square poles to a certain height. Pieces with irregular surface are securely attached to the chuck by means of polar extensions. There are two types: fix and mobile. Mobile extensions adapt to the irregular surface of the piece and the fixed ones, act as a support points. The perfect clamping is obtained by using 3

fixed extensions and so many mobiles as the piece requires.



ELECTROPERMANENT MAGNETIC CHUCKS QUADRI-POL / FOR MILLING

VERSIONS

Available in four different versions, which differ mainly in the measures of the poles.

QP1.50

Suitable for general machining of all types of pieces and with thicknesses from 8-10 mm. Thanks to poles 50 x 50 mm, they have a greater flexibility for the use of pole extensions in the case of pieces with particular shape. Contra, the largest number of poles with respect to the 70 series, carries a higher cost.

QP2.50

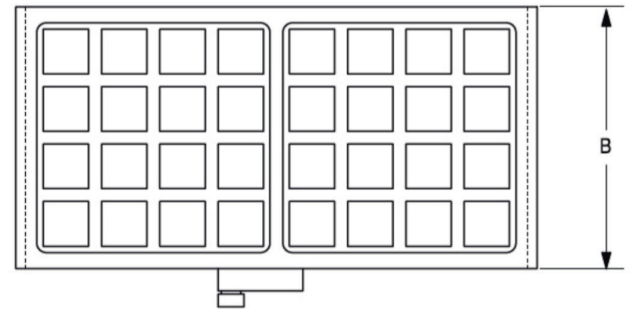
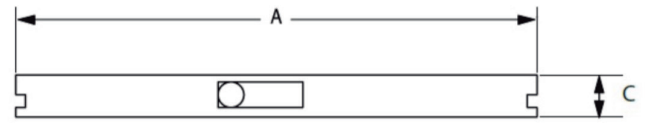
Characteristics similar to the version 1.50 but higher power. Performs better in presence of large air gaps. Its magnetic power allows an effectively machining of forgings or warped surfaces.

QP1.70

Basic version of the range and the cheapest. Suitable for general machining of all types of pieces and with thicknesses from 15-20 mm. It has almost half of poles with respect to the 50 series, but its cost is lower.

QP2.70

Characteristics similar to version 1.70 but higher power. Performs better in the presence of large air gaps. Suitable for forged pieces or deformed surfaces.



QP 1.50

CODE	A mm	B mm	C mm	Nº OF POLS	WEIGHT Kg
32.05.613	320	240	66	12	35
32.05.614	440	240	66	18	49
32.05.615	600	240	66	24	67
32.05.616	760	240	66	30	84
32.05.617	880	240	66	36	98
32.05.618	1000	240	66	42	111
32.05.623	320	300	66	16	44
32.05.624	440	300	66	24	61
32.05.625	600	300	66	32	83
32.05.626	760	300	66	40	105
32.05.627	880	300	66	48	122
32.05.628	1000	300	66	56	139
32.05.644	440	420	66	36	85
32.05.645	600	420	66	48	116
32.05.646	760	420	66	60	147
32.05.647	880	420	66	72	171
32.05.648	1000	420	66	84	194
32.05.664	480	480	66	42	106
32.05.665	600	480	66	56	133
32.05.666	760	480	66	70	169
32.05.667	880	480	66	84	195
32.05.668	1000	480	66	98	222
32.05.684	480	580	66	48	129
32.05.685	600	580	66	64	161
32.05.686	760	580	66	80	204
32.05.687	880	580	66	96	236
32.05.688	1000	580	66	112	268

QP 1.70

CODE	A mm	B mm	C mm	Nº OF POLS	WEIGHT Kg
32.22.614	390	230	66	8	42
32.22.615	600	230	66	12	64
32.22.616	760	230	66	16	81
32.22.618	960	230	66	20	102
32.22.624	390	310	66	12	56
32.22.625	600	310	66	18	86
32.22.626	760	310	66	24	109
32.22.628	960	310	66	30	138
32.22.644	390	390	66	16	70
32.22.645	600	390	66	24	108
32.22.646	760	390	66	32	137
32.22.648	960	390	66	40	173
32.22.664	480	470	66	24	104
32.22.665	600	470	66	30	130
32.22.666	760	470	66	40	165
32.22.668	960	470	66	50	209
32.22.685	600	560	66	36	155
32.22.686	760	560	66	48	197
32.22.688	960	560	66	60	248

ELECTROPERMANENT MAGNETIC CHUCKS QUADRI-POL

CHARACTERISTICS

VERSION	QP 1.50	QP 2.50	QP 1.70	QP 2.70
Force/Pol (daN)	380,0	380,0	830,0	830,0
Force/Pol (daN) Airgap 1 mm	72,3	169,6	162,6	380,0
Force/Pol (daN) Airgap 1,5 mm	40,0	90,0	120,0	255,0
Minimum thickness of piece	10	10	20	20
Height of the chuck (mm)	66	76	66	76



POLAR EXTENSIONS

CODE	N° OF FIGURE	TYPE	LENGHT mm	WIDH mm	HEIGHT mm
43.00.112	1	MOBILE	47	45	54
43.01.102	1	MOBILE	70	70	70
43.00.011	3	FIX	45	45	20
43.00.013	2	FIX	45	45	54
43.01.001	2	FIX	70	70	70
43.01.002	3	FIX	70	70	20

