

ZERO POINT QUICK CHANGE DEVICES

Quick Change Device and its accessories (including Base Plate, Adapter Plate 52/96, Column, Riser Block, Multi Plate, Clamping Bridge, etc.) are highly modular, and their combination can satisfy different machine tools, fixtures and processes

- Installing Quick Change Device can greatly save the positioning time of the fixture during change over
- Installing Quick Change Device in the entire production line can effectively reduce the accumulated tolerance
- Fixtures can be rotated 90 degrees while maintaining centering accuracy
- Support common stud specifications in the market (52/ 96 mm bolt distance)
- Various specifications for flexible configuration, especially suitable for 4, 5-axis machine tool with limited bed space



Base Plate

Base plate is made of High quality Steel (S50C) with heat treatment of HRC 46, then grounded precisely to ensure the durability and accuracy.

**Repeatability: < 0.008 mm.
Pull stud spacing: 52mm or 96mm**

- 1 Mechanical clamping with a screw or fast actuation system
- 2 4xM5 threads are used as positioning support for vises
- 3 Ø12 mm for concentric alignment and 20 mm keyways for axial alignment
- 4 A flexible positioning solution for vertical and horizontal machining centers. Suitable for using on 3- and 5-axis machine tables and 4th axis rotary or trunnion systems.



FRONT



BACK

Rectangular Plate

with clamping edge & mounting bores



M-52x52 (8001)

Size 150x116x27 mm

Pull Stud No. M-52x52PS

Mounting Holes 100x50 mm

Weight (kg) 3



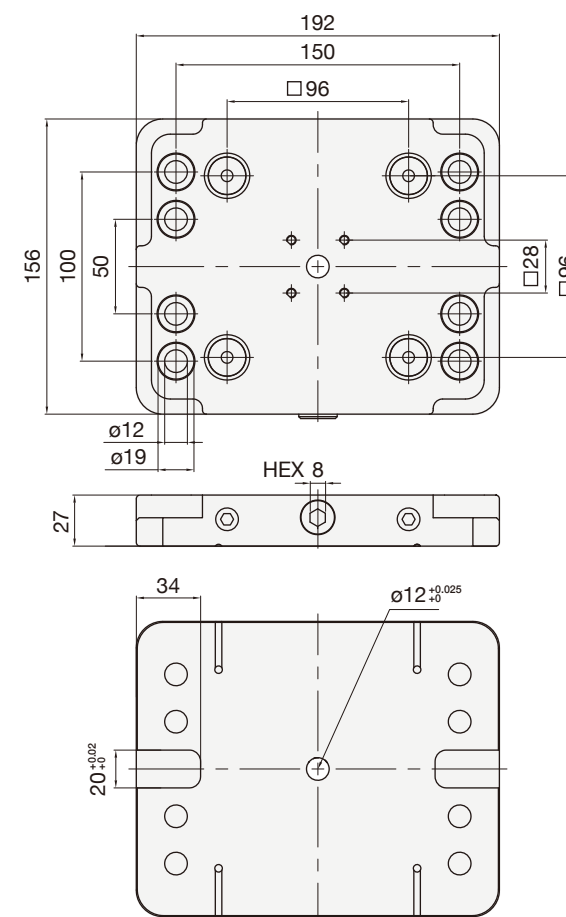
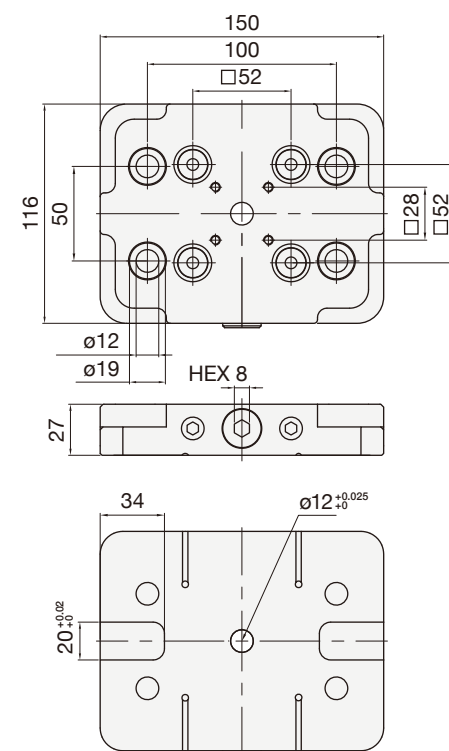
M-96x96 (8051)

Size 192x156x27 mm

Pull Stud No. M-96x96PS

Mounting Holes 150x50/100 mm

Weight (kg) 5.5



Rectangular Plate

without clamping edge & mounting bores



M-52x52 (8002)

Size 150x116x27 mm

Pull Stud No. M-52x52PS

Mounting Holes -

Weight (kg) 3.5



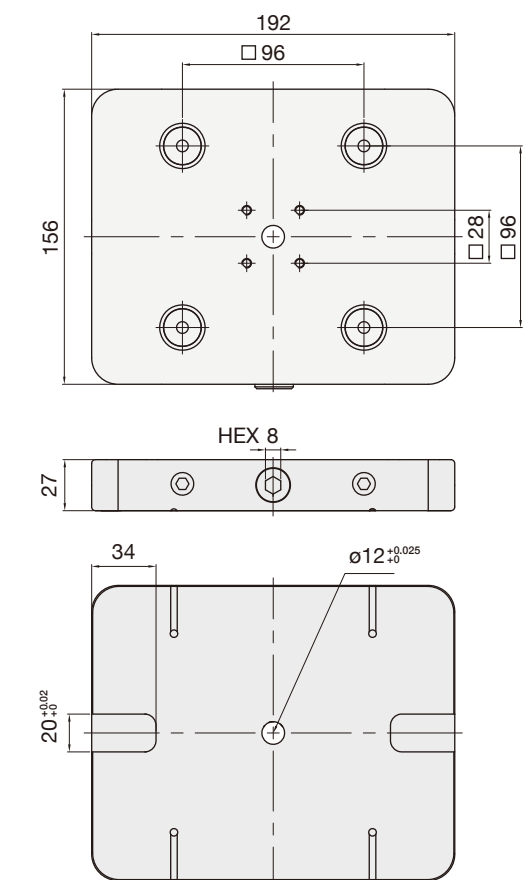
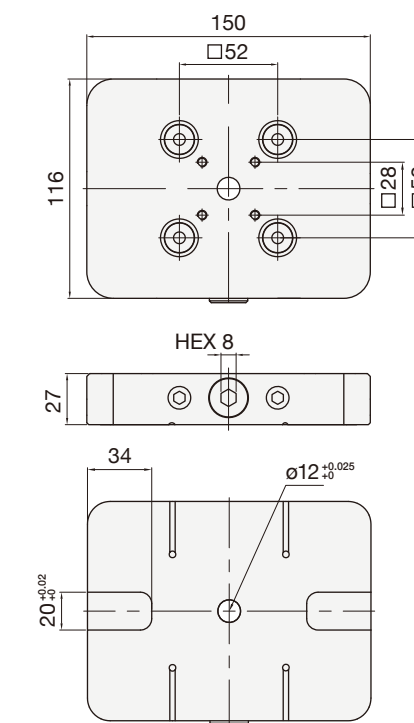
M-96x96 (8052)

Size 192x156x27 mm

Pull Stud No. M-96x96PS

Mounting Holes -

Weight (kg) 6



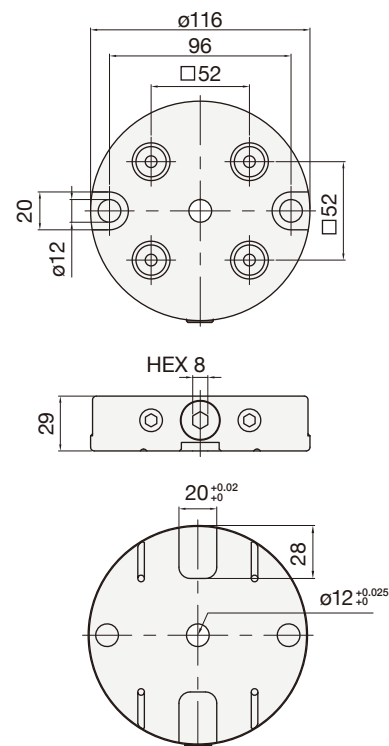
Round Plate

with clamping edge & mounting bores



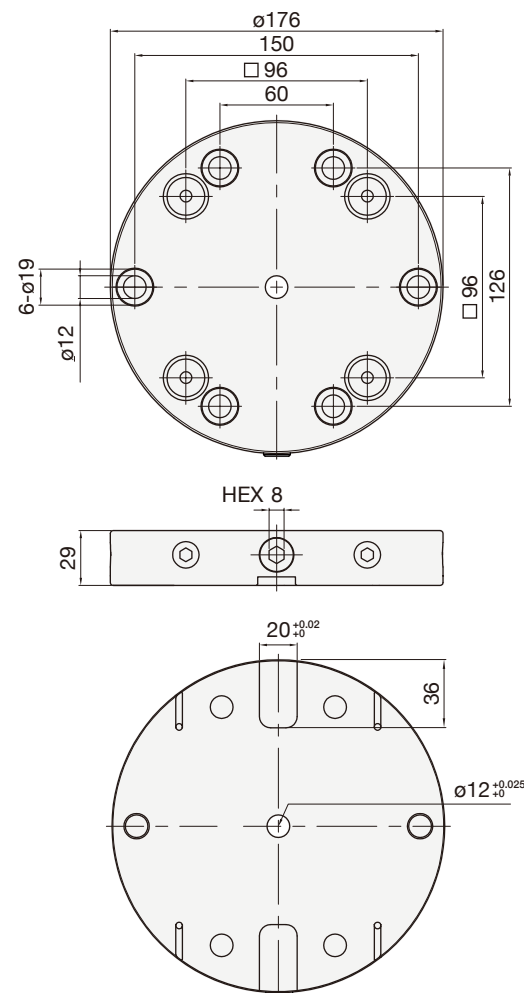
M-52x52 (8004)

Size	ø116x29 mm
Pull Stud No.	M-52x52PS
Mounting Holes	96 mm
Weight (kg)	2



M-96x96 (8053)

Size	ø176x29 mm
Pull Stud No.	M-96x96PS
Mounting Holes	150 mm / 60x126 mm
Weight (kg)	5



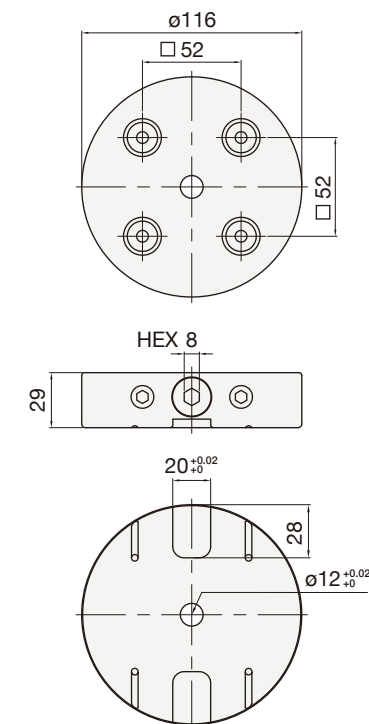
Round Plate

without clamping edge & mounting bores



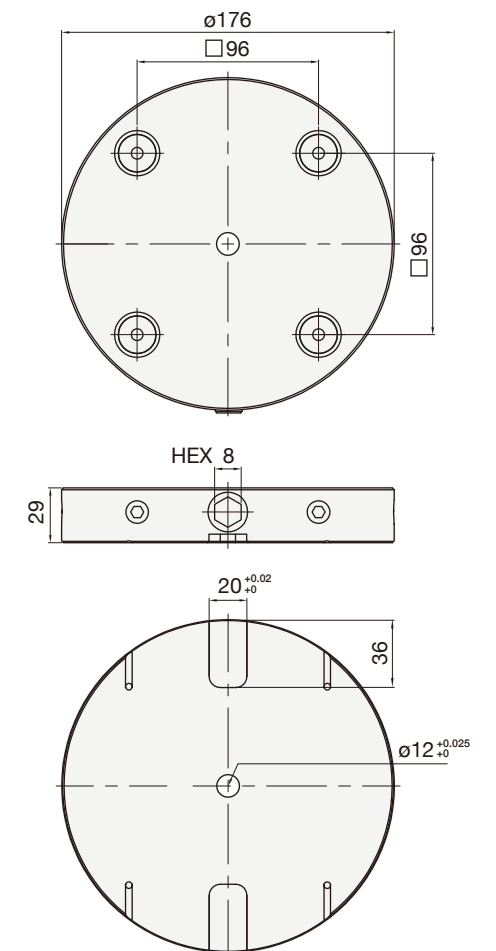
M-52x52 (8005)

Size	ø116x29 mm
Pull Stud No.	M-52x52PS
Mounting Holes	-
Weight (kg)	2.2



M-96x96 (8054)

Size	ø176x29 mm
Pull Stud No.	M-96x96PS
Mounting Holes	-
Weight (kg)	5.5



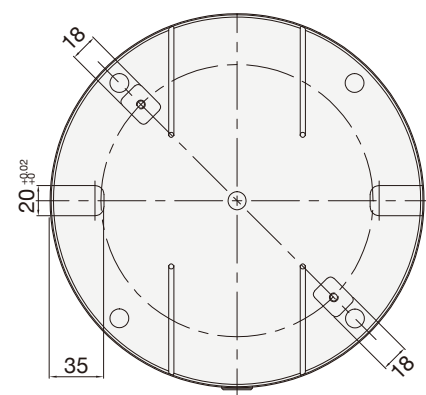
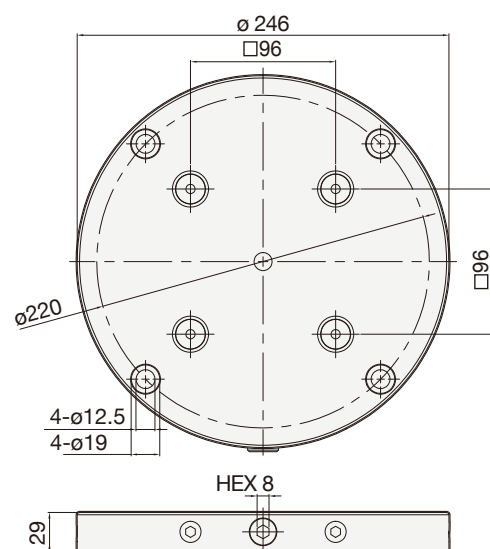
Round Plate

with mounting bores for
tables with 90° grooves



M-96x96 (8057)

Size	ø246x29 mm
Pull Stud No.	M-96x96PS
Mounting Holes	4x90° / Diameter 220 mm
Weight (kg)	9.5

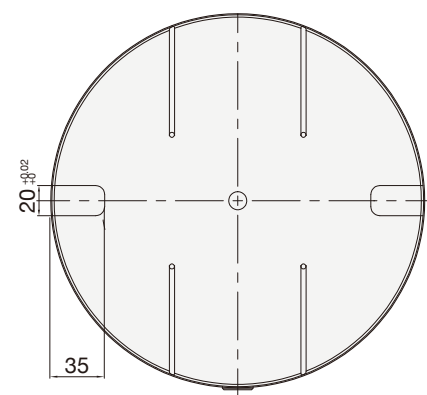
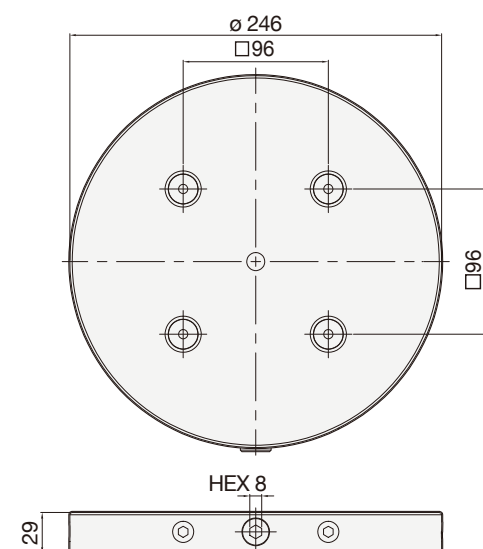


without mounting bores for
tables with 90° grooves



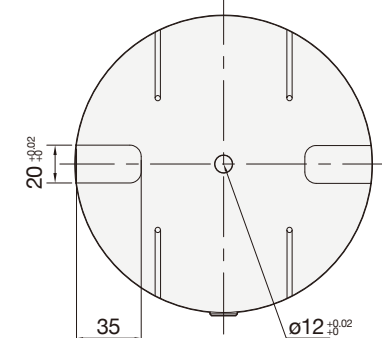
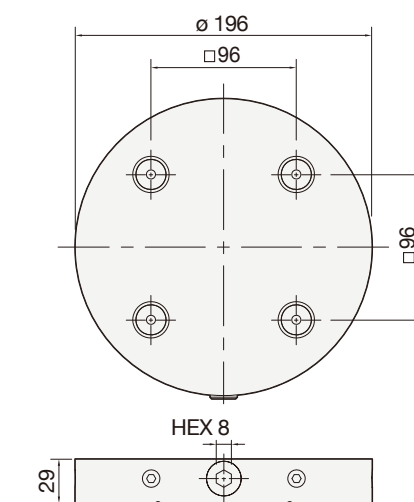
M-96x96 (8059)

Size	ø246x29 mm
Pull Stud No.	M-96x96PS
Mounting Holes	-
Weight (kg)	9.5



M-96x96 (8060)

Size	ø196x29 mm
Pull Stud No.	M-96x96PS
Mounting Holes	-
Weight (kg)	6

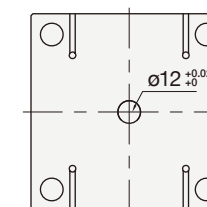
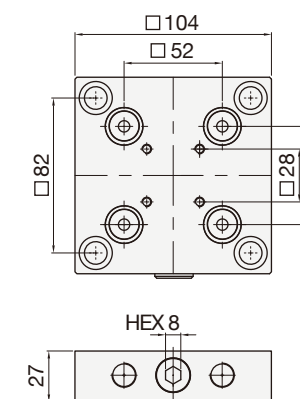


Grid Plate



M-52x52 (8011)

Size	104x104x27 mm
Pull Stud No.	M-52x52PS
Mounting Holes	82x82 mm
Weight (kg)	1.8



Round Modification Plate



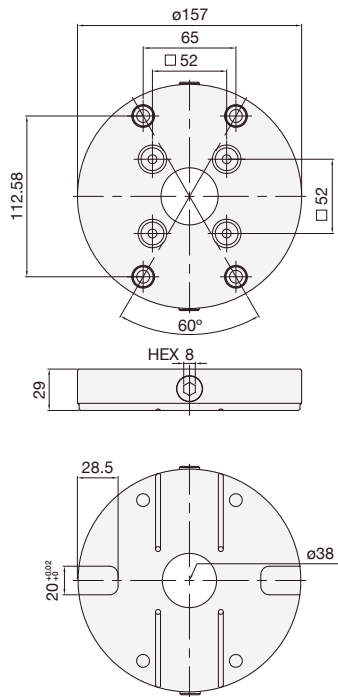
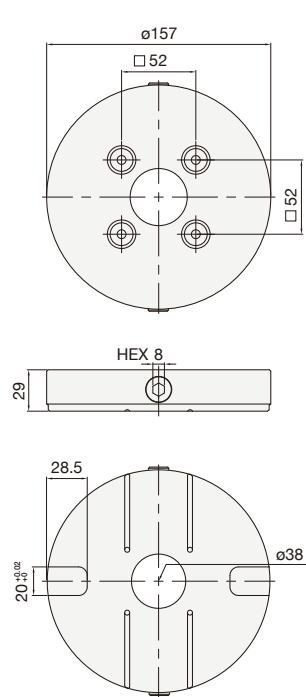
for machine tables
with 6x60° groove

M-52x52 (8009)

Size	ø157x29 mm
Pull Stud No.	M-52x52PS
Mounting Holes	-
Weight (kg)	4

M-52x52 (8009-M)

Size	ø157x29 mm
Pull Stud No.	M-52x52PS
Mounting Holes	for machine tables with 6x60° grooves
Weight (kg)	4



Round Modification Plate

for machine tables with 6x60° grooves



M-96x96 (8055)

Size	ø176x29 mm
Pull Stud No.	M-96x96PS
Mounting Holes	for machine tables with 6x60° grooves
Weight (kg)	5

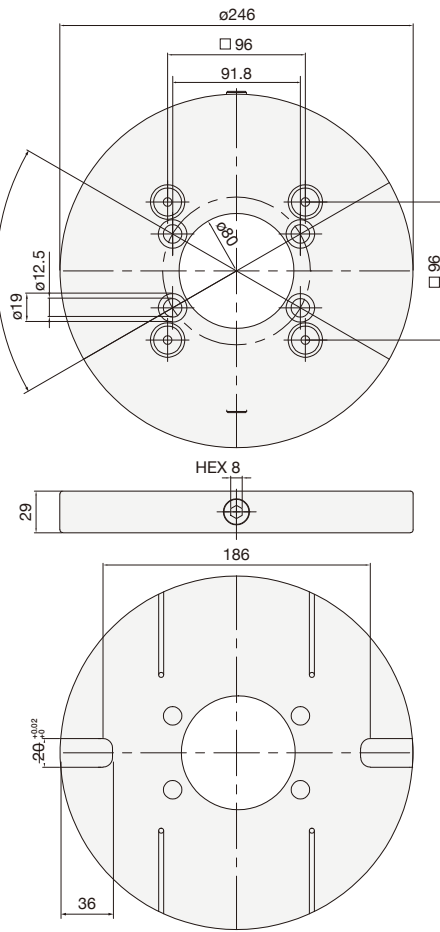
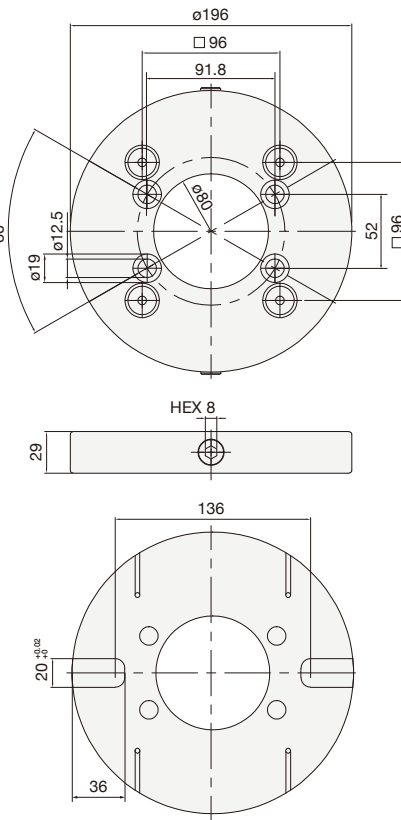
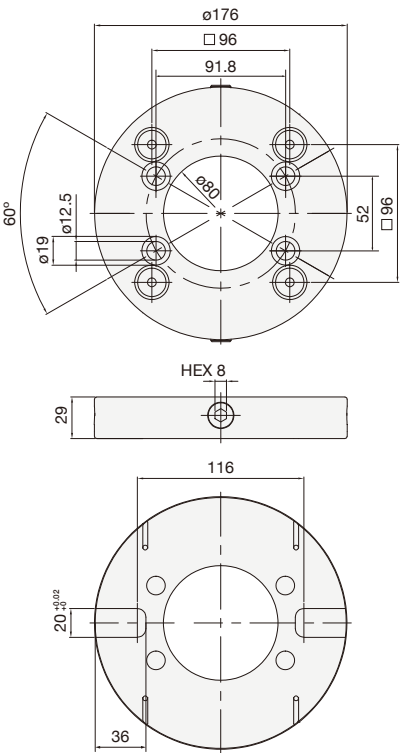


M-96x96 (8055-1)

Size	ø196x29 mm
Pull Stud No.	M-96x96PS
Mounting Holes	for machine tables with 6x60° grooves
Weight (kg)	6

M-96x96 (8055-2)

Size	ø246x29 mm
Pull Stud No.	M-96x96PS
Mounting Holes	for machine tables with 6x60° grooves
Weight (kg)	9.5



Adapter Plates-52 / 96

At the beginning, vise and the Plate of 96mm system was purchased. If user needs to process small workpieces in the future, it is recommended to use a modular Adapter Plate, which can quickly change the 96 system to 52 system.



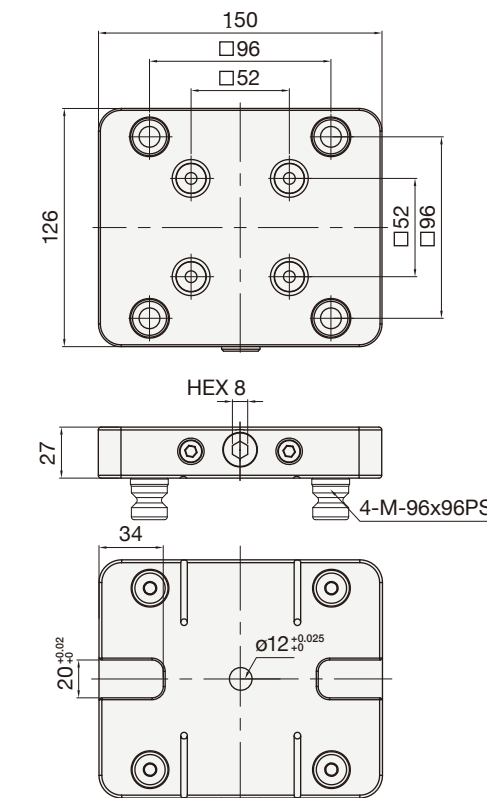
Adapter Plates

Rectangular Adapter Plate



M-52x96 (8003)

Size	150x126x27 mm
Pull Stud No.	M-52x52PS
Mounting Holes	96x96 mm
Weight (kg)	3

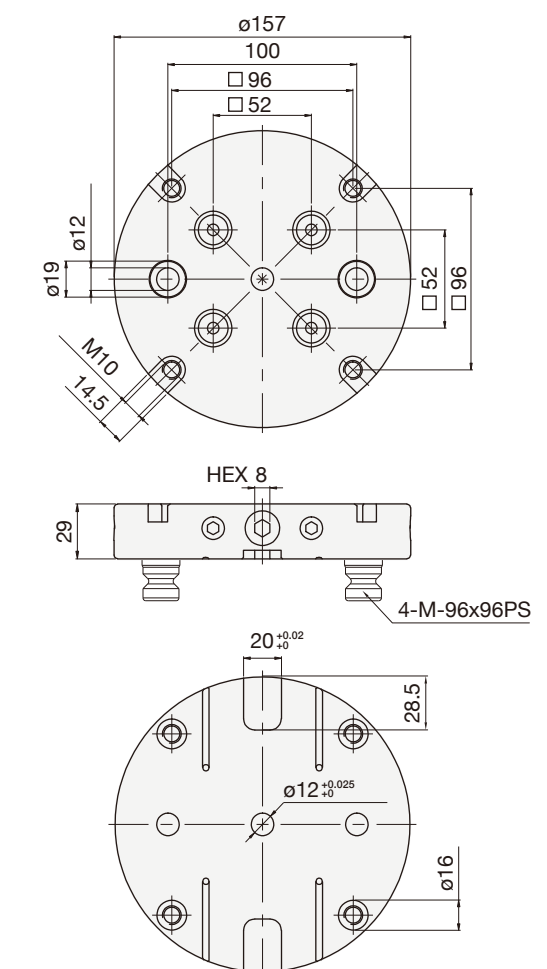


Round Adapter Plate



M-52x96 (8006)

Size	ø157x29 mm
Pull Stud No.	M-52x52PS
Mounting Holes	100 mm / 96x96 mm
Weight (kg)	3.9



Adapter Plate for 3-Jaw Chuck

ZERO POINT QUICK CHANGE DEVICES / ADAPTER PLATES / ADAPTER PLATE FOR 3-JAW CHUCK

3 Jaw Chuck Adapter Plate for M-52x52



M-52x52 (4")

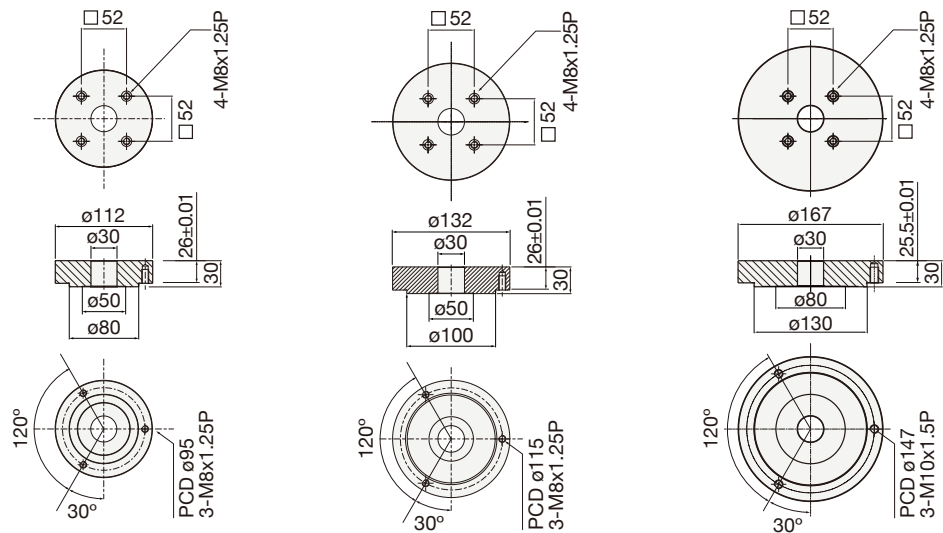
Size	ø112x30 mm
Pull Stud No.	M-52x52PS
Mounting Holes	M8
Weight (kg)	2

M-52x52 (5")

Size	ø132x30 mm
Pull Stud No.	M-52x52PS
Mounting Holes	M8
Weight (kg)	2.9

M-52x52 (6")

Size	ø167x30 mm
Pull Stud No.	M-52x52PS
Mounting Holes	M10
Weight (kg)	4.6



3 Jaw Chuck Adapter Plate for M-96x96



M-96x96 (6")

Size	ø167x30 mm
Pull Stud No.	M-96x96PS
Mounting Holes	M10
Weight (kg)	4.6

M-96x96 (7")

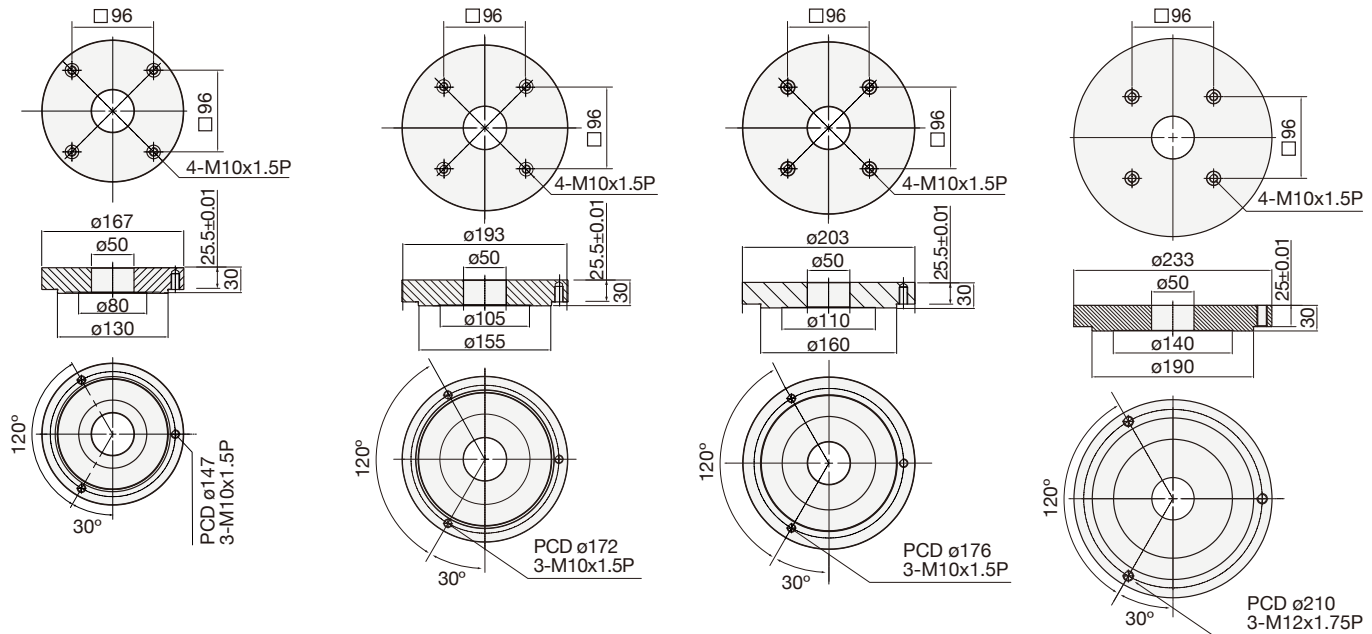
Size	ø193x30 mm
Pull Stud No.	M-96x96PS
Mounting Holes	M10
Weight (kg)	6

M-96x96 (8")

Size	ø203x30 mm
Pull Stud No.	M-96x96PS
Mounting Holes	M10
Weight (kg)	6.7

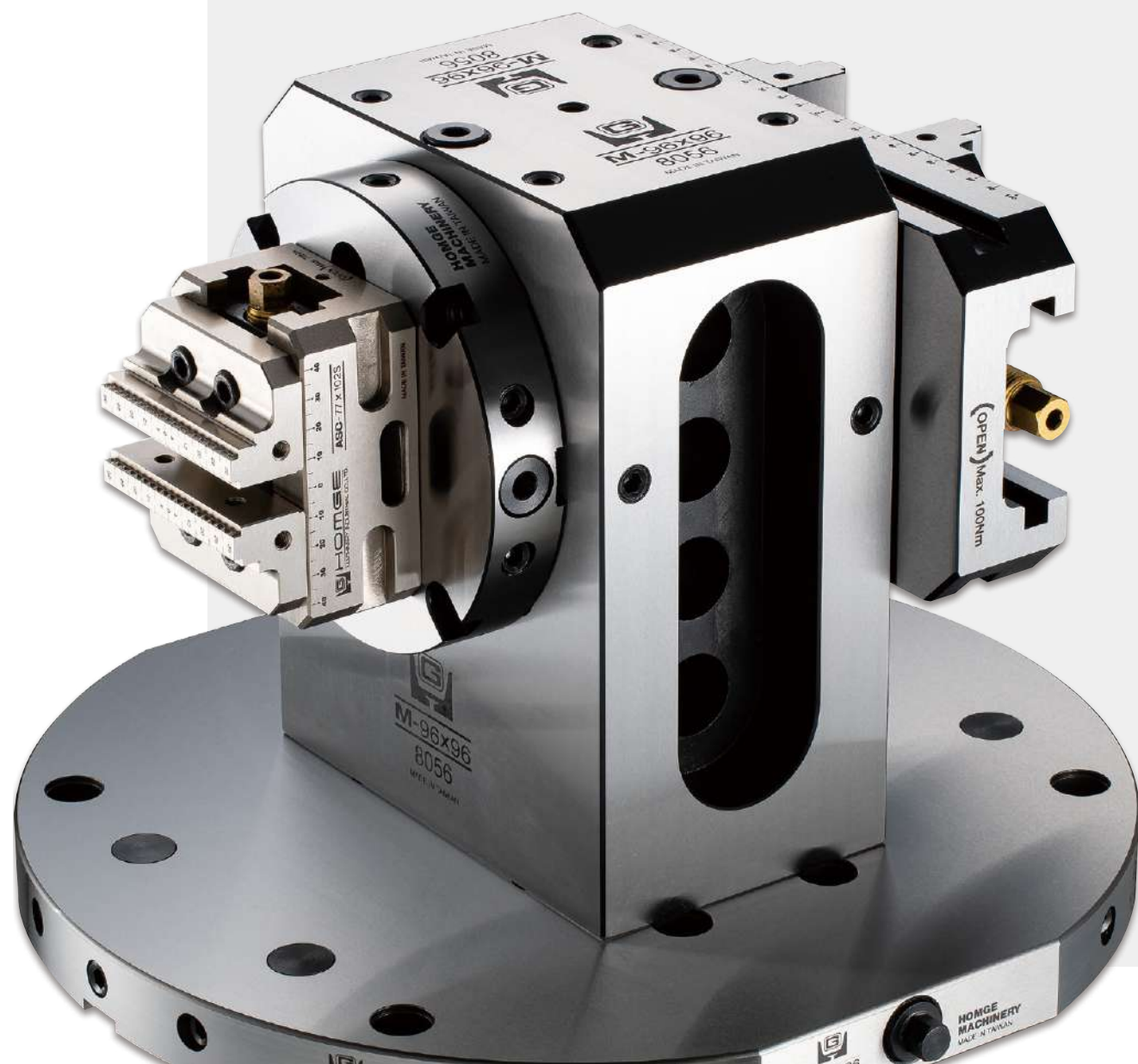
M-96x96 (9")

Size	ø233x30 mm
Pull Stud No.	M-96x96PS
Mounting Holes	M12
Weight (kg)	8.9



Column

Double-sided positioning tombstone inherits the characteristics of the positioning plate and can utilize the processing space of the machine tool. Suitable for 3-axis machine tool users who often apply dual-sided processing.

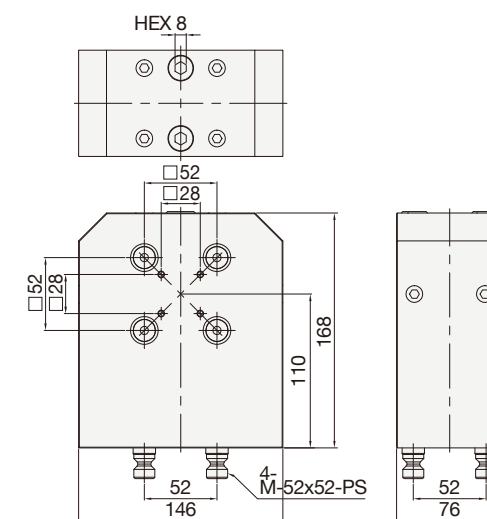


Twin Base



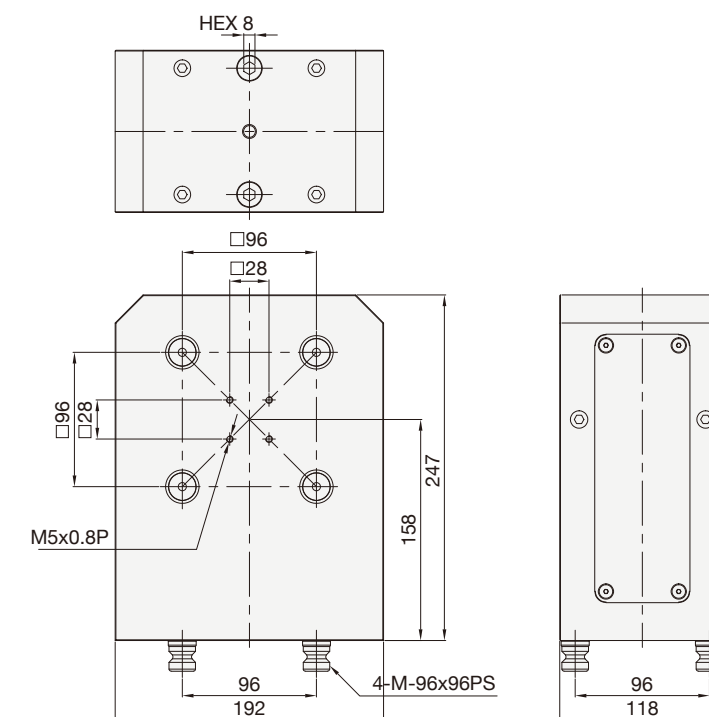
M-52x52 (8008)

Size	146x76x168 mm
Pull Stud No.	M-52x52PS
Mounting Holes	-
Weight (kg)	14



M-96x96 (8056)

Size	192x118x247 mm
Pull Stud No.	M-96x96PS
Mounting Holes	-
Weight (kg)	37



Master Gauging Pallet

Suitable for quick checking the precise alignment of Quick Changing Plates and for concentric alignment of rotary or chucks.

How it works:

After clamping the gauging pallet in a Quick Change Device - plate, the axial alignment of the Quick Change Device - plate is done by probing the jig-ground sides of the gauging pallet. For a concentric alignment the inner diameter of the gauging pallet can be used.



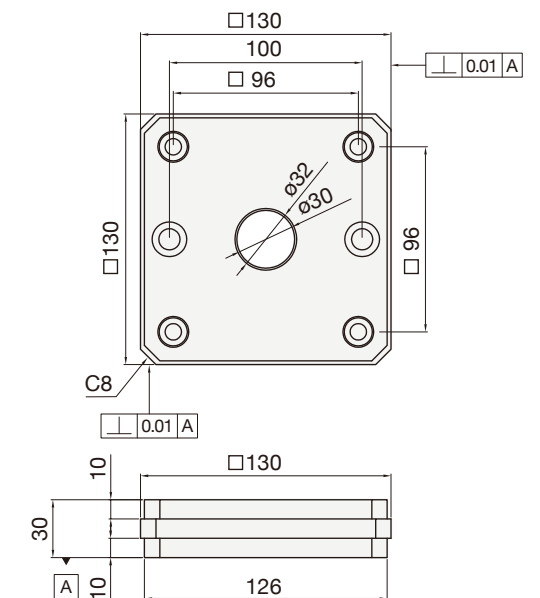
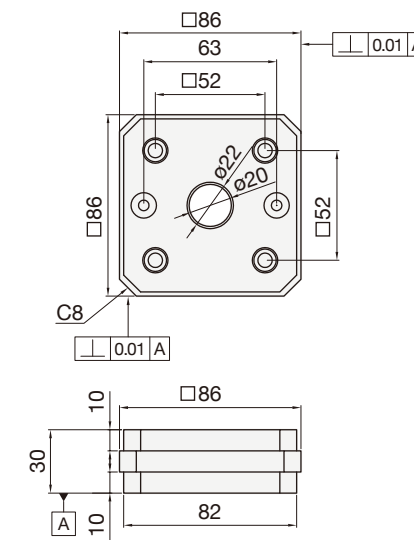
M-52x52 (8010)

Size	86x86x30 mm
Pull Stud No.	M-52x52PS
Weight (kg)	1.5



M-96x96 (8058)

Size	130x130x30 mm
Pull Stud No.	M-96x96PS
Weight (kg)	3.4



Riser Block

Riser Block provides sufficient space for tool feed by reducing the interference between the bed and the machining tool Suitable for multi-axis machining and one-piece formed processes

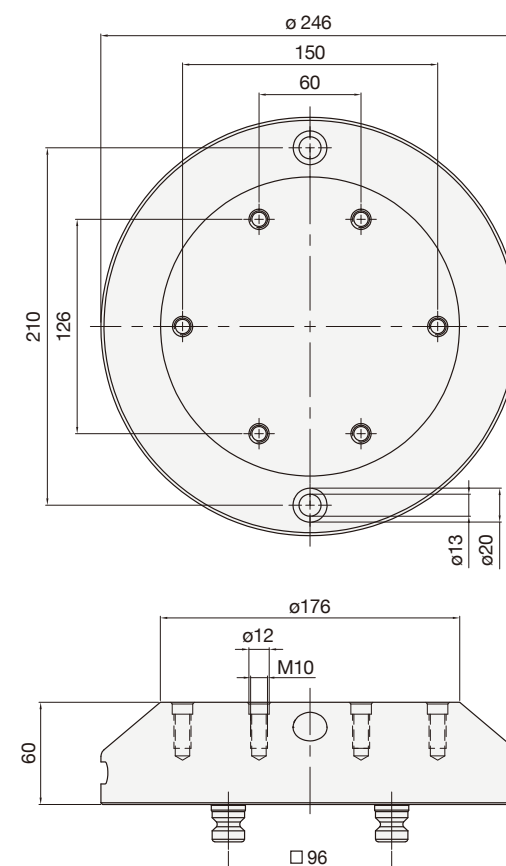


Round Aluminum Riser



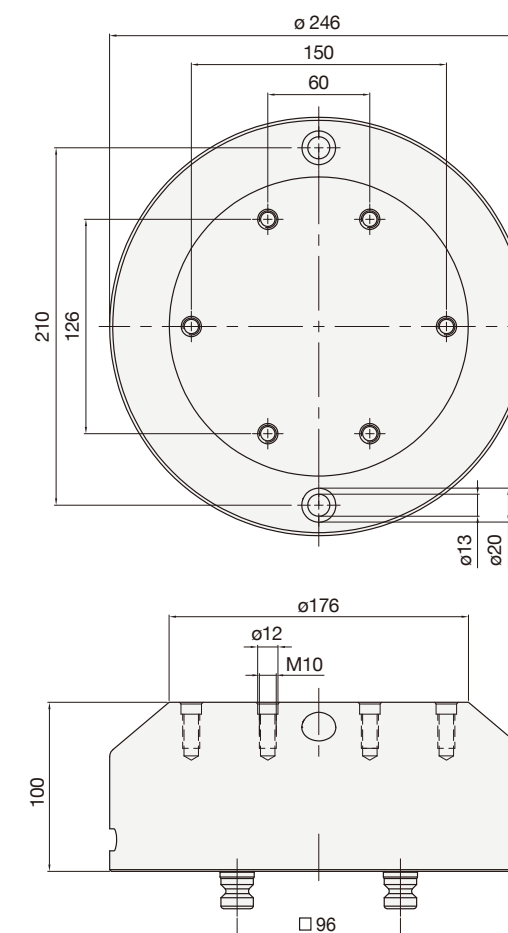
M-96x96 (8202)

Size	ø246x60 mm
Pull Stud No.	M-96x96PS
Mounting Holes	210mm / 150 mm / 60x126 mm
Weight (kg)	7
Material	Aluminum



M-96x96 (8206)

Size	ø246x100 mm
Pull Stud No.	M-96x96PS
Mounting Holes	210mm / 150 mm / 60x126 mm
Weight (kg)	12
Material	Aluminum



Rectangular Riser

(Height: 60 mm)



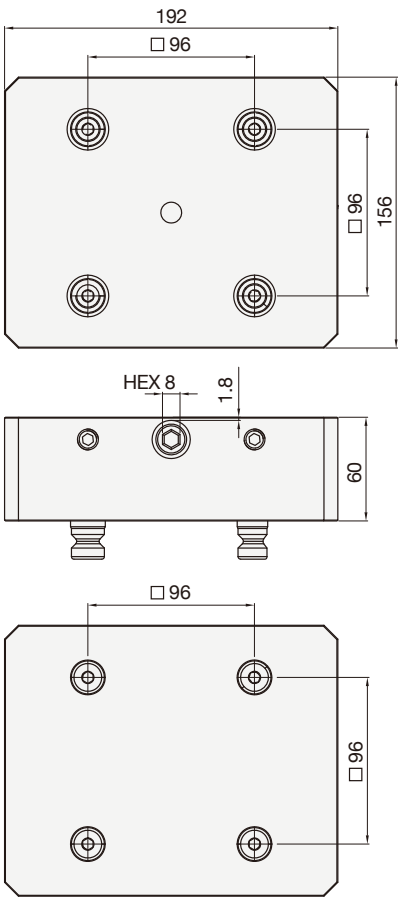
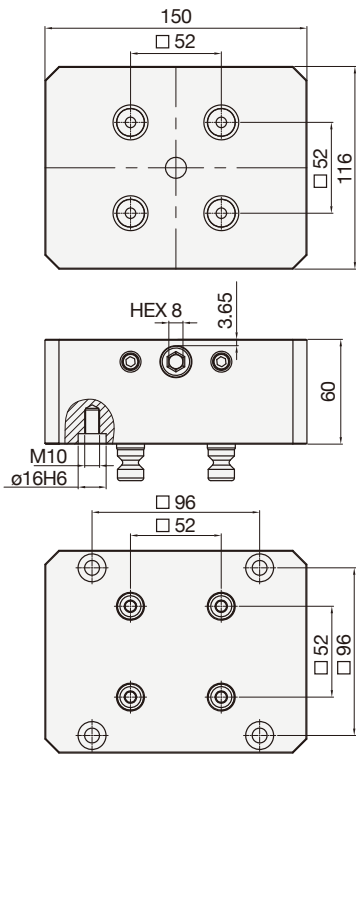
M-52x52 (3131)

Size	150x116x60 mm
Pull Stud No.	M-52x52PS / M-96x96PS
Mounting Holes	-
Weight (kg)	6.1



M-96x96 (8222)

Size	192x156x60 mm
Pull Stud No.	M-96x96PS
Mounting Holes	-
Weight (kg)	11.2



Rectangular Riser

(Height: 100 mm)



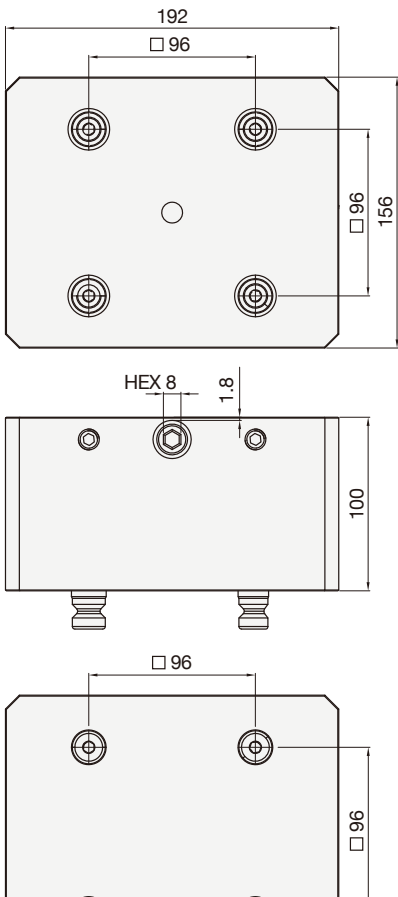
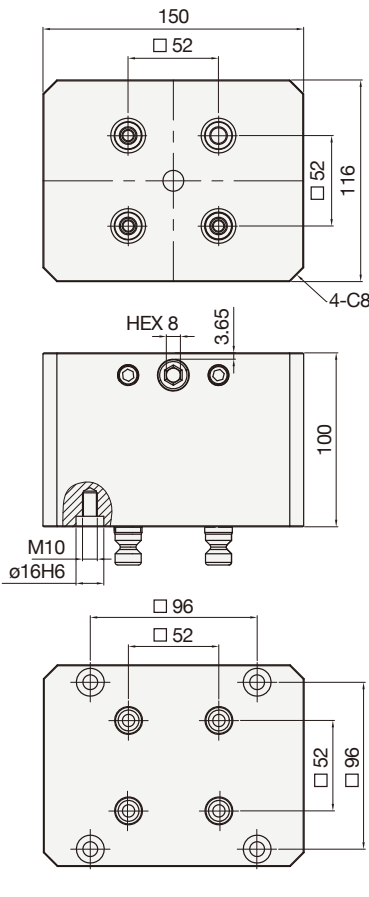
M-52x52 (3133)

Size	150x116x100 mm
Pull Stud No.	M-52x52PS / M-96x96PS
Mounting Holes	-
Weight (kg)	10



M-96x96 (8226)

Size	192x156x100 mm
Pull Stud No.	M-96x96PS
Mounting Holes	-
Weight (kg)	18.1



Multi Plates

Multi plates provide more positioning points, allowing users to effectively use the space of machine tables; whether it is fixing a single large workpiece or multiple small parts, the fixture positioning is fast and accurate



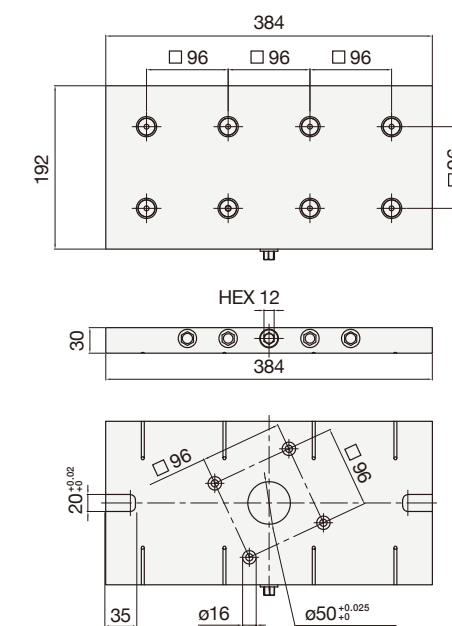
Multi Plate / 2-Fold Grid Plate

RECTANGULAR
without Mounting Bores



M-96x96 (8062)

Size	384x192x30 mm
Pull Stud No.	M-96x96PS
Mounting Holes	-
Weight (kg)	14.7
Standard Accessories	Cover Plug M-96x96CPS x 8 pcs Cover Plug with Hook M-96x96H x 2 pcs Cover Plug Remover x 1 pc

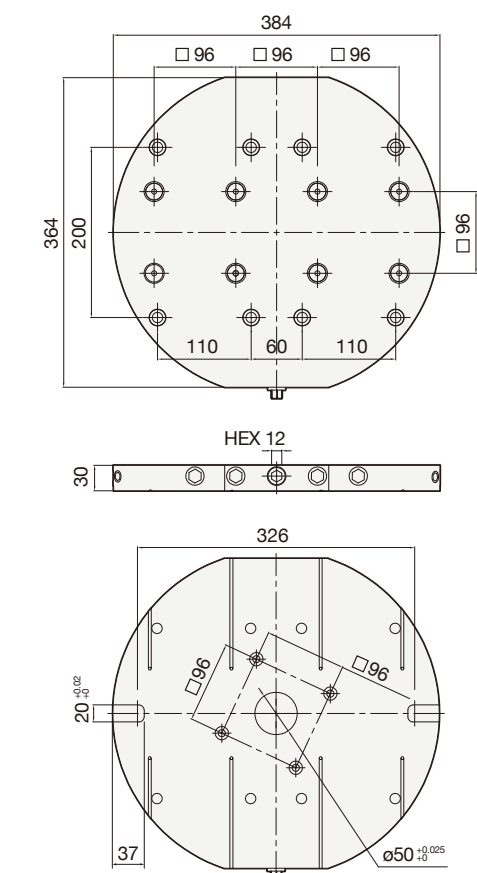


ROUND
with Mounting Bores for 100mm T-Slot distance



M-96x96 (8067)

Size	ø384x364x30 mm
Pull Stud No.	M-96x96PS
Mounting Holes	as the drawing shown
Weight (kg)	22.4
Standard Accessories	Cover Plug M-96x96CPS x 8 pcs Cover Plug with Hook M-96x96H x 2 pcs Cover Plug Remover x 1 pc



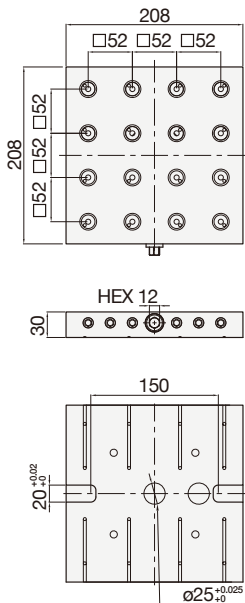
Multi Plate / 4-Fold Grid Plate

M-52x52
without Mounting Bores



M-52x52 (8026)

Size	208x208x30mm
Pull Stud No.	M-52x52PS
Mounting Holes	-
Weight (kg)	8.2
Standard Accessories	Cover Plug M-52x52CPS x 16 pcs Cover Plug with Hook M-52x52H x 2 pcs Cover Plug Remover x 1 pc

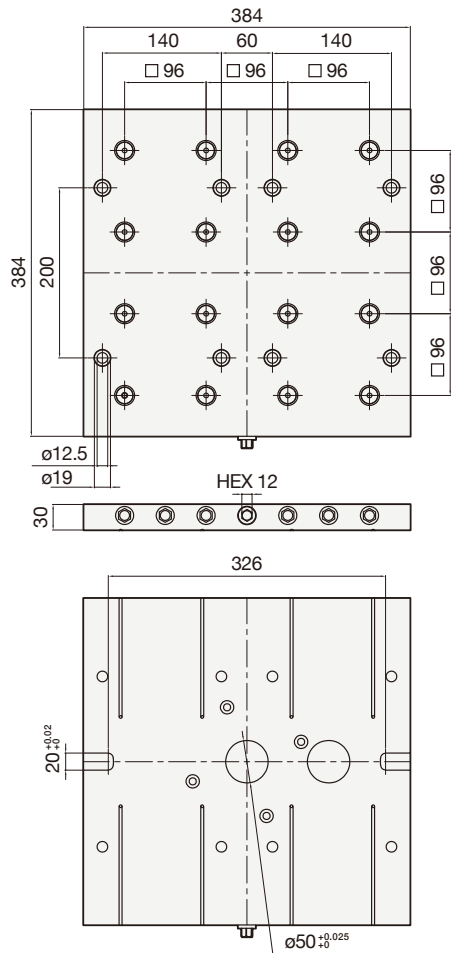


M-96x96
with Mounting Bores



M-96x96 (8066)

Size	384x384x30mm
Pull Stud No.	M-96x96PS
Mounting Holes	as the drawing shown
Weight (kg)	29.2
Standard Accessories	Cover Plug M-96x96CPS x 16 pcs Cover Plug with Hook M-96x96H x 2 pcs Cover Plug Remover x 1 pc

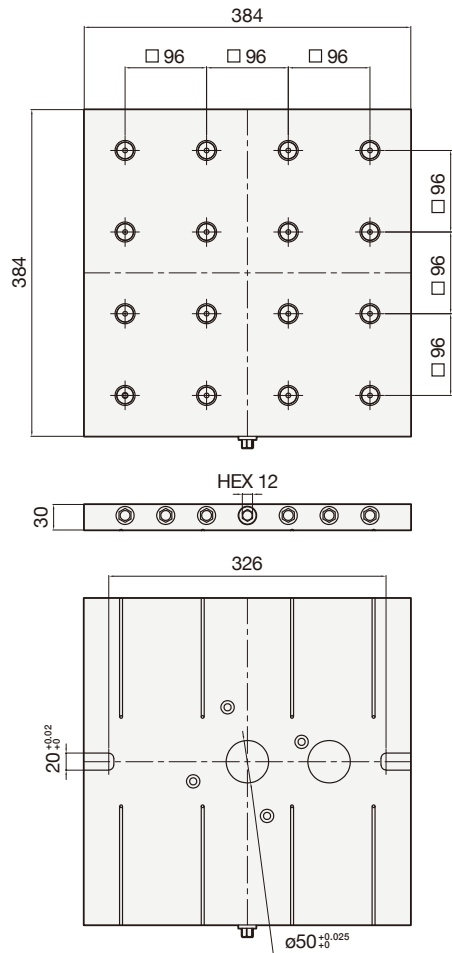


M-96x96
without Mounting Bores



M-96x96 (8066-B)

Size	384x384x30mm
Pull Stud No.	M-96x96PS
Mounting Holes	-
Weight (kg)	29.2
Standard Accessories	Cover Plug M-96x96CPS x 16 pcs Cover Plug with Hook M-96x96H x 2 pcs Cover Plug Remover x 1 pc



Clamping Bridge

Single Clamping Bridge

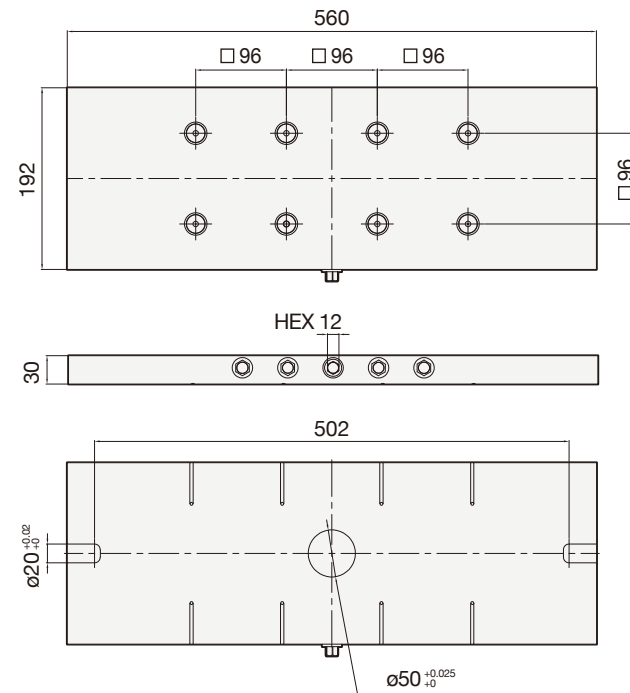
44

ZERO POINT QUICK CHANGE DEVICES / CLAMPING BRIDGE



M-96x96 (8068)

Size	560x192x30 mm
Pull Stud No.	M-96x96PS
Mounting Holes	-
Weight (kg)	23
Standard Accessories	Cover Plug M-96x96CPS x 8 pcs Cover Plug with Hook M-96x96H x 2 pcs Cover Plug Remover x 1 pc



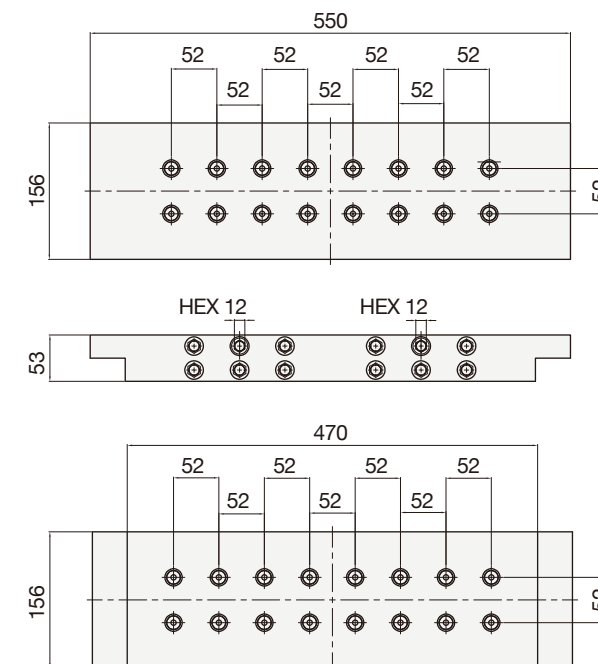
Clamping Bridge

Twin Clamping Bridge



M-52x52 (8022)

Size	550x156x53 mm
Pull Stud No.	M-52x52PS
Mounting Holes	-
Weight (kg)	27.7
Standard Accessories	Cover Plug M-52x52CPS x 32 pcs Cover Plug with Hook M-52x52H x 2 pcs Cover Plug Remover x 1 pc

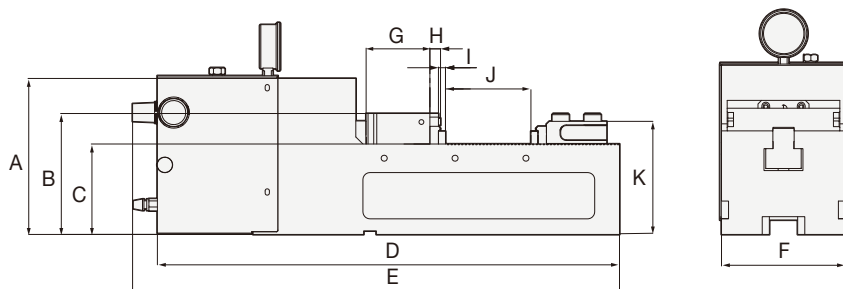


STAMPING UNIT

Model: ASC-153



The tooth profiles of each stamping unit



SPECIFICATIONS (Material: Material: FCD 60 ductile Iron. Hardness: HRC 50)

Unit: mm

Model	A	B	C	D	E	F	G	H	I
ASC-153	70	43	28	32	75	80	10	M6	102
Model	J	K	Max. Clamping Force		Safety Range		Weight(kg)		
ASC-153	107	77	0-24000 kg		8 mm		117		



SIMPLE, QUICK & ACCURATE

ASC-153 Stamping Unit can easily shape tooth profile on the workpiece, which allows precise positioning between the workpiece and the vise.

1 The body of the Stamping Unit is made of **Ductile Iron FCD 70** with patented **PNEUMATIC SYSTEM**. Required tooth profile is pre-stamped onto the workpiece with high pressure, so that the workpiece will be stably clamped by the corresponding tooth profile on five-axis vise.

2 The stamping force is between **0~24 tons**, which is suitable for stamping tooth profile on both soft and hard materials. The black knob is **pressure regulator**, used to set pneumatic force according to processing conditions.

3 The serrated jaws of stamping unit are made of **Tool Steel**, heat-treated to achieve hardness above **HRC55** and marked with scales to facilitate accurate positioning. It is recommended that the hardness of workpiece should not exceed HRC35.

4 The effective stamping stroke of the moveable jaw is **10mm**; during the initialization phase, please adjust the jaw spacing according to the width of the workpiece and make sure to reserve **3~5mm** as a margin for smooth loading/unloading. Meanwhile, please refer to the scale on the jaws to set the datum point.

5 Pre-stamping is beneficial to both hard and soft workpieces. The former can effectively reduce wear and tear caused by workpiece on the serrated jaws; the latter can avoid workpiece deformation caused by excessive pressure for stable clamping.

6 By engaging the teeth profile of both the workpiece and the vise, clamping accuracy can be fully guaranteed; therefore, it is ideal for multi-part processing and automatic processing.

7 Customized serrated jaws of the stamping unit are acceptable.

- Simple setting, Quick pre-stamping, which can greatly improve the reliability of five-axis processing.



FAST ACTUATION SYSTEM



Model: M-52x52AS

- 1 set
- Weight: 0.49 kg / set

Model: M-96x96AS

- 1 set
- Weight: 0.63 kg / set

Optional Accessories

for Zero Point Quick Change Devices

Pull Studs

Can be adopted onto vises or workpieces to use together with any Quick Change Device.

Model: M-52x52PS

- 4 pcs / set
- Weight: 0.16 kg / set



Model: M-96x96PS

- 4 pcs / set
- Weight: 0.28 kg / set



Spacer Studs

Improve the machining accessibility of edges or angles by making a through space between workpieces and Quick Change Devices.

Model: M-52x52SS

- 4 pcs / set
- Weight: 0.27 kg / set



Model: M-96x96SS

- 4 pcs / set
- Weight: 0.4 kg / set



Cover Plugs - Plastic

Model: M-52x52CPP

- 4 pcs / set
- Weight: 0.01 kg / set



Model: M-96x96CPP

- 4 pcs / set
- Weight: 0.02 kg / set



Cover Plugs - Steel

Model: M-52x52CPS

- 4 pcs / set
- Weight: 0.10 kg / set



Model: M-96x96CPS

- 4 pcs / set
- Weight: 0.16 kg / set



Cover Plug with hook

Model: M-52x52H

- 2 pcs / set
- Weight: 0.18 kg / set



Model: M-96x96H

- 2 pcs / set
- Weight: 0.32 kg / set

Cover Plug Remover

for M-52x52 and M-96x96

- 1 pc
- Weight: 0.11 kg

