

# Basic equipment – Macro

With a Macro chuck as basic equipment on the machine table, you can interconnect all your machines to create a single system. Move the workpiece from the wire EDM machine to the grinding machine or the die-sinking machine without subsequent alignment – quickly and precisely.

If you choose a pneumatic Macro chuck, you can operate round-the-clock production if you wish.

- + Allows fully automated production
- + Links all your machines together
- + Z-references with automatic air-blast cleaning
- + X and Y references of cemented carbide
- + Repetition accuracy:  
Macro 0.002 mm  
MacroNano 0.001 mm
- + Turbo locking – enhanced clamping force.

**Note:** The pneumatic chucks require an air pressure of  $6\pm 1$  bar.



## Recommendations for loading in Macro chucks

Table chucks with horizontal mounting of the workpiece

Article number	Max torque	Capacity (X=150 mm)
3R-600.24RS	6 Nm	4 kg
3R-600.24-4RS	8 Nm	5 kg
3R-602.10	22.5 Nm	15 kg
3R-602.10-1	30 Nm	20 kg
3R-602.12-1	45 Nm	30 kg
3R-602.26	30 Nm	20 kg
3R-602.27	30 Nm	20 kg
3R-602.27-1	18 Nm	12 kg
3R-602.81RS	30 Nm	20 kg

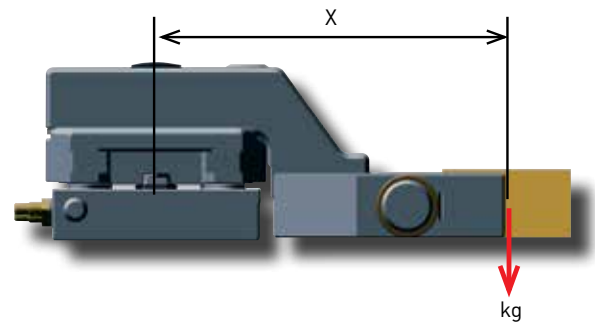
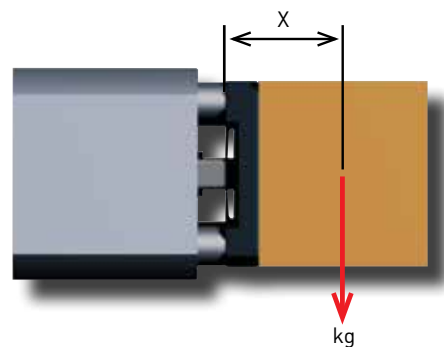


Table chucks with vertical mounting of the workpiece

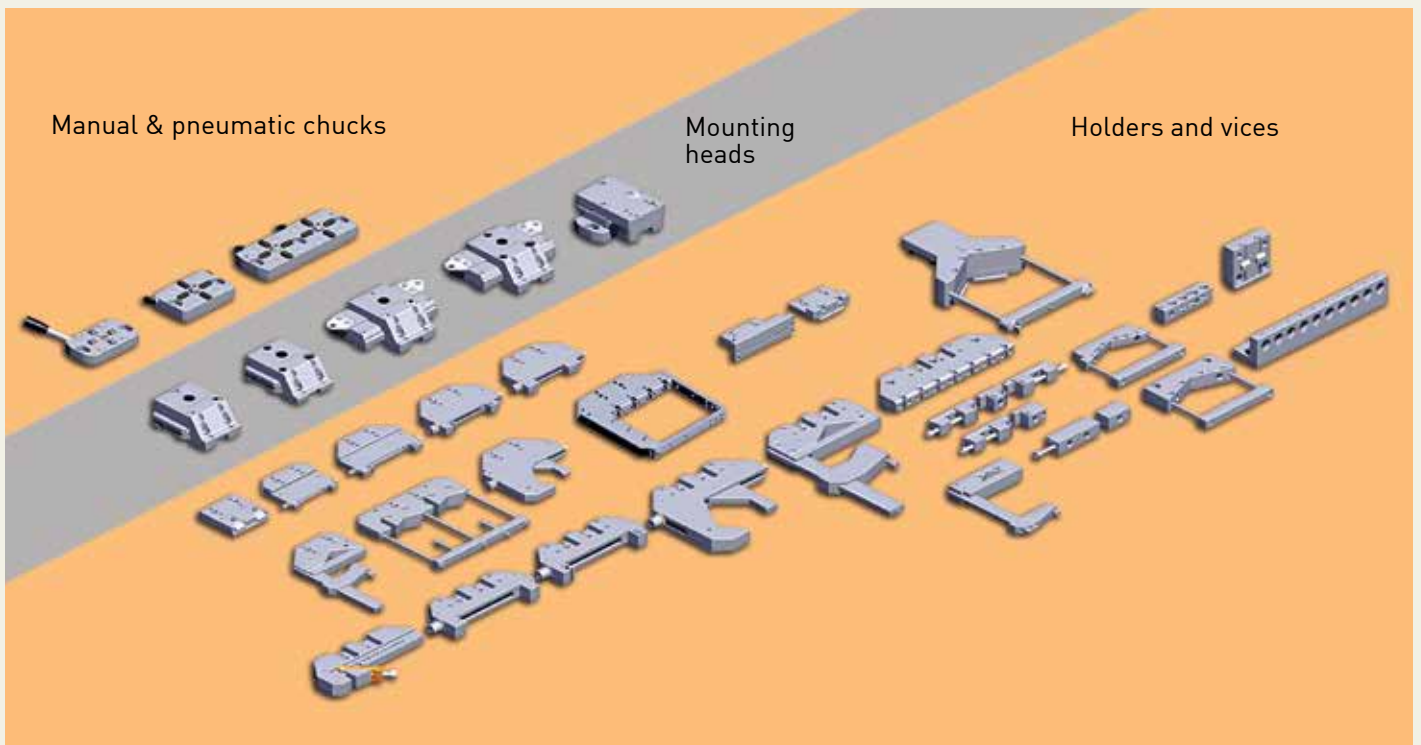
Article number	Max torque	Capacity (X=100 mm)
3R-600.24RS	6 Nm	6 kg
3R-600.24-4RS	8 Nm	7-8 kg
3R-602.4.1	8 Nm	7-8 kg
3R-602.27-1	8 Nm	7-8 kg
3R-60.360-X	8 Nm	7-8 kg



## Basic equipment – Macro

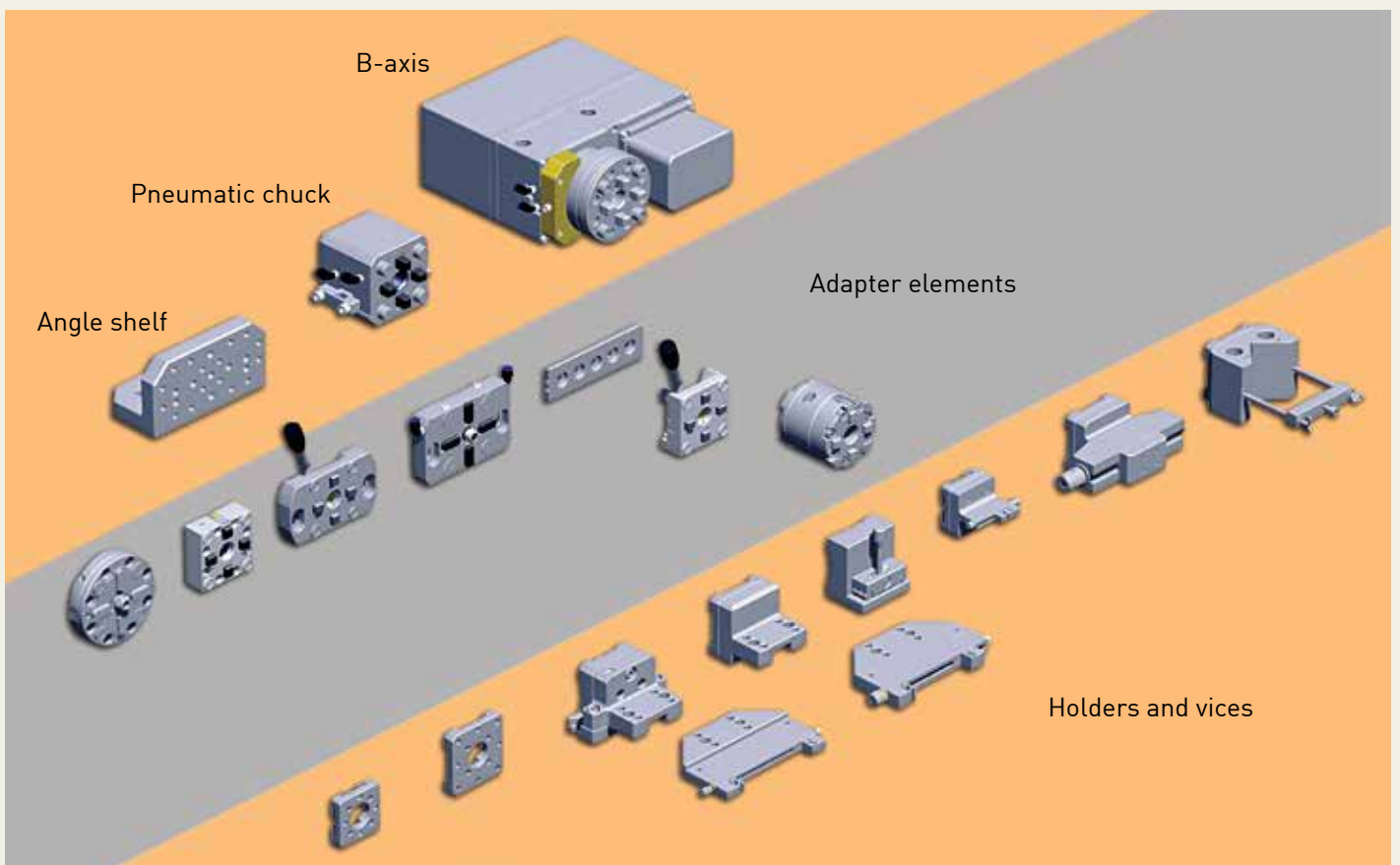
### Overview of the Macro system with horizontal mounting

Basic equipment on the machine table



### Overview of the Macro system with vertical mounting

Basic equipment on the machine table

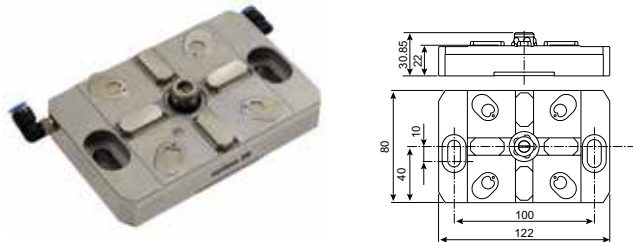


# Basic equipment – Macro

## Pneumatic chuck, Macro, 3R-602.10-1

Pneumatic chuck for Macro holders.

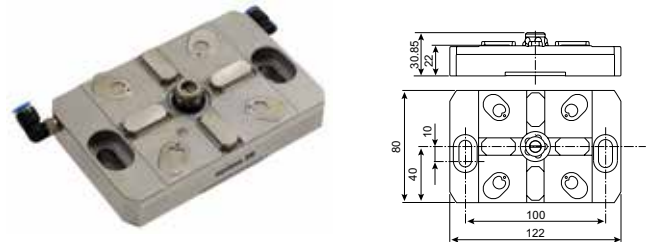
- Clamping force 6.7 kN
- Fixed index positions 4x90°
- Supplied with drawbar 3R-605.10
- Air-blast cleaning of Z-references
- Protective cover.
- Weight 1.0 kg.



## Pneumatic chuck, MacroNano, 3R-602.10-1N

Pneumatic chuck for Macro holders.

- Clamping force 6.7 kN
- Fixed index positions 4x90°
- Supplied with drawbar 3R-605.10
- Air-blast cleaning of Z-references
- Protective cover.
- Weight 1.0 kg.

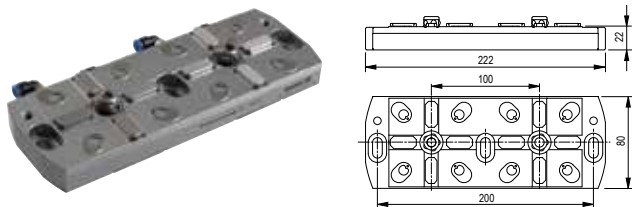


## Pneumatic chuck, MacroTwin, 3R-602.12-1

Pneumatic chuck for Macro or MacroTwin. Horizontal mounting on the machine table.

Note: On automatic changing with WorkPal – MacroTwin holders only.

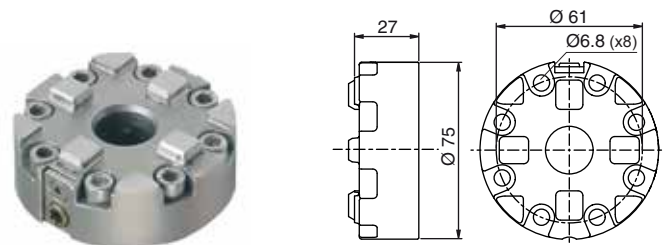
- Clamping force 2x6.7 kN
- Fixed index positions 4x90°
- Supplied with drawbars 3R-605.10
- Air-blast cleaning of the Z-references
- Protective covers
- Weight 1.5 kg.



## Manual chuck, Macro, 3R-600.24RS

Manual chuck for Macro holder. Designed for permanent mounting.

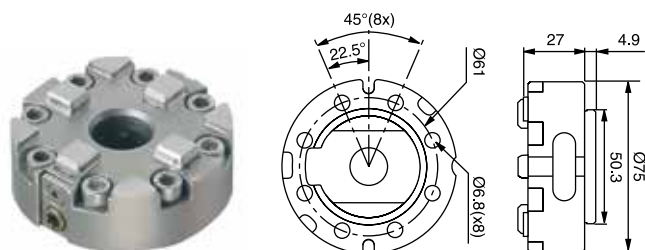
- Clamping force 6 kN
- Fixed index positions 4x90°
- Required drawbar 3R-605.2RS
- Tightening torque 6 Nm
- Weight 0.7 kg.



## Manual chuck, Macro, 3R-600.23RS

Manual chuck with mounting flange for Macro holder. Designed for permanent mounting.

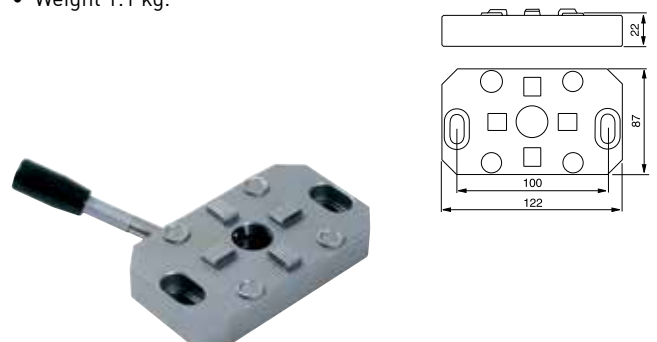
- Clamping force 6 kN
- Fixed index positions 4x90°
- Required drawbar 3R-605.2RS
- Tightening torque 6 Nm
- Weight 0.7 kg.



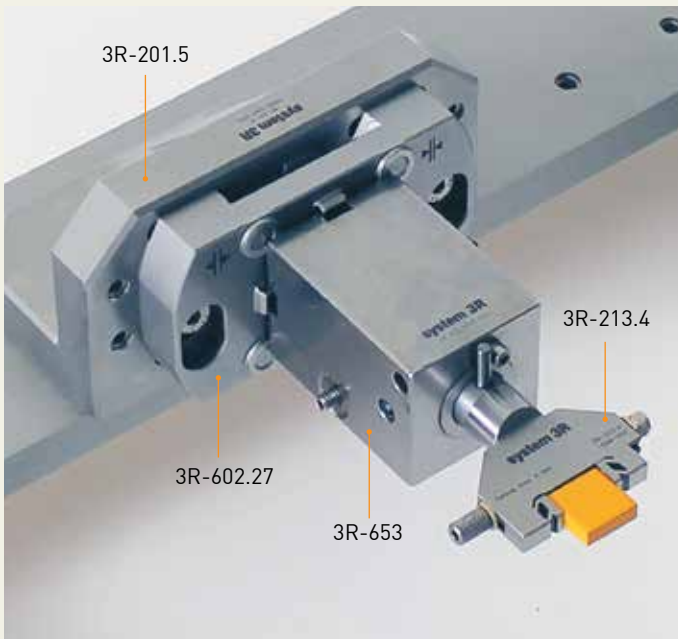
## Manual chuck, Macro, 3R-602.27

Manual chuck with lever for Macro holder.

- Clamping force 6 kN
- Fixed index positions 4x90°
- Supplied with drawbar 3R-605.27RS.
- Built-in latch function
- Weight 1.1 kg.



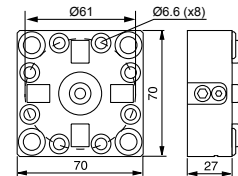
## Basic equipment – Macro



### Manual chuck, Macro, 3R-600.24-4RS

Manual chuck for Macro holder. Mounts on a suitable fixture.

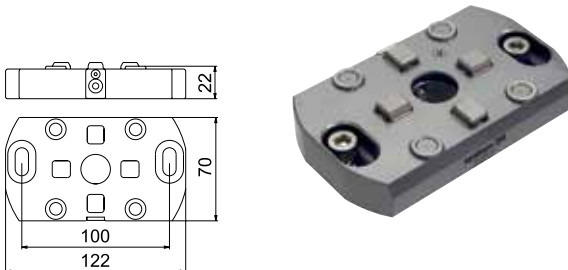
- Clamping force 6 kN
- Fixed index positions 4x90°
- Required drawbar 3R-605.2RS
- Tightening torque 6 Nm
- Ground front edge
- Weight 1 kg.



### Manual chuck, Macro, 3R-602.26

Manual chuck for Macro holder.

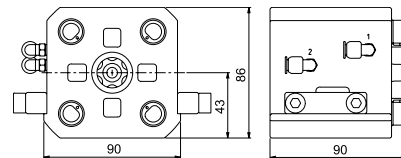
- Clamping force 6 kN
- Fixed index positions 4x90°
- Supplied with drawbar 3R-605.26.
- Tightening torque 6 Nm
- Weight 1.1 kg.



### Pneumatic chuck, Macro, 3R-602.4.1

Pneumatic chuck for Macro holder.

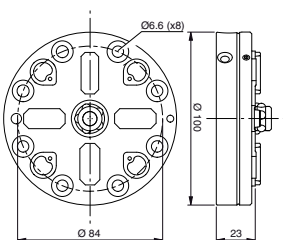
- Clamping force 6 kN
- Fixed index positions 4x90°
- Required drawbar 3R-605.1RS
- Air-blast cleaning of Z-references
- Weight 4.1 kg.



### Pneumatic chuck, Macro, 3R-602.81RS

Pneumatic chuck, low-profile, for Macro holder.

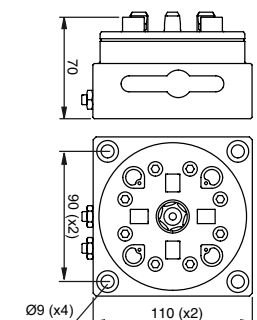
- Clamping force 6 kN
- Fixed index positions 4x90°
- Required drawbar 3R-605.10
- Air-blast cleaning of Z-references
- Weight 4.1 kg.



### Pneumatic chuck, MacroHP, 3R-600.10-3RS

Pneumatic chuck locked/opened with air gun.

- Clamping force 6 kN
- Fixed index positions 4x90°
- Required drawbar 3R-605.1RS
- Air-blast cleaning of the Z-references
- Carbide XY-References
- Weight 4.4 kg.

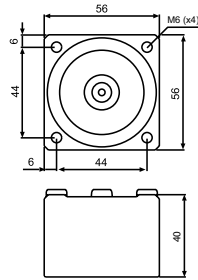


# Basic equipment – Macro

## Pneumatic chuck, Macro, 3R-600.15-3

Pneumatic chuck for permanent mounting on the machine table.

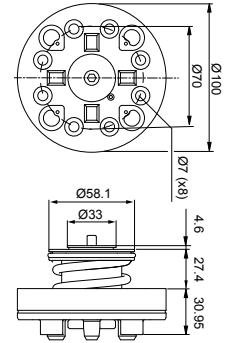
- Clamping force 4.5 kN
- Fixed index positions 4x90°
- Supplied with drawbar 3R-605.2RS
- Weight 0.8 kg.



## Pneumatic built-in chuck, Macro, 3R-SP26771-RS

Chuck for Macro holder. For permanent mounting on the machine spindle or fixture.

- Clamping force 6 kN
- Fixed index positions 4x90°
- Required drawbar 3R-605.1RS
- Weight 2 kg.

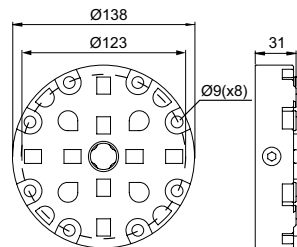


## Manual chuck (low profile), MacroMagnum, 90809.02

Chuck for MacroMagnum holder. For permanent mounting on the machine spindle or table.

Note: Master 3R-606.1 or 3R-686.1-HD required at installation.

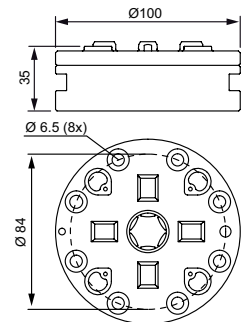
- Clamping force – Macro at 5 kN; 6 kN, MacroMagnum at 12 kN; 16 kN
- Fixed index positions 4x90°
- Required drawbar 3R-605.2RS
- Tightening torque Macro 4 Nm, MacroMagnum 10 Nm
- Weight 5 kg.



## Pneumatic chuck (low profile), Macro, 90945.01

Pneumatic chuck for permanent mounting on the machine table.

- Clamping force 6.2 kN
- Required drawbar 3R-605.2RS
- Fixed index positions 4x90°
- Weight 2 kg.

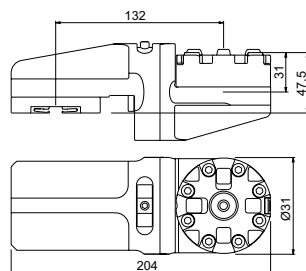


## Angle Tool, Macro, D-30215

Angle tool, Macro with vernier scale -90° to 0 to +90°.

Note: Macro chuck is required on the machine table for clamping.

- Clamping force 6 kN
- Required drawbar 3R-605.2RS
- Tightening torque 6 Nm
- Weight 3.5 kg.

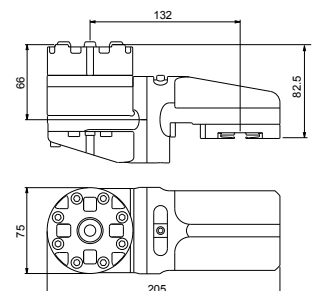


## Angle Swivel Tool, Macro, 90937.20

2-axes angle Swivel Tool, Macro with vernier scale -90° to 0 to +90° together with swivel in the front.

Note: Macro chuck is required on the machine table for clamping.

- Clamping force 6 kN
- Required drawbar 3R-605.2RS
- Tightening torque 6 Nm
- Maximum load 6 kg or 4 Nm.
- Weight 5 kg.

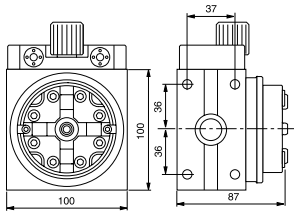


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## 3R-block, Macro, 3R-217-1

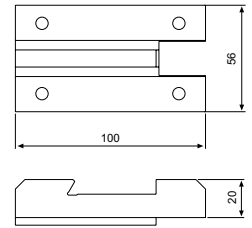
Manual Macro chuck. For vertical or horizontal mounting on the machine table, or alternatively the WEDM system with the aid of 3R-SP6435.

- Clamping force 6 kN
- Fixed index positions 24x15°
- Required drawbar 3R-605.2RS
- Tightening torque 6 Nm
- Vernier scale
- Weight 5.4 kg.



## Adapter, 3R-SP6435

Adapter element for mounting 3R-217-1 in the WEDM system.



## Angle shelf, 3R-201.5

Mounts directly on the machine table. For vertical mounting of a Macro chuck or short reference element in the machine.

- Weight 4.2 kg.

