



Workholding System



The Workholding System is a unique combination of control, machine and your ingenuity.

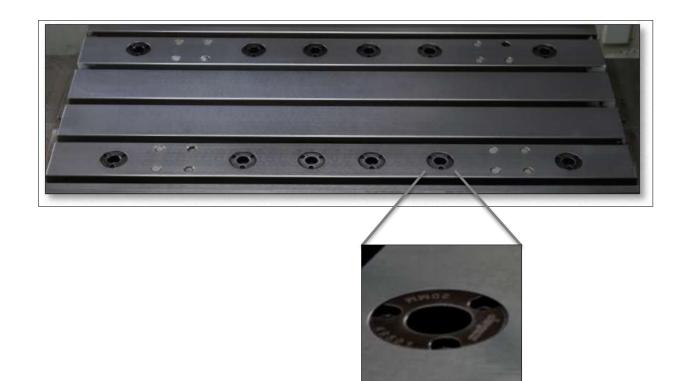
Objectives

- Drive set up labor to the minimum
- Enable rapid changeover from job to job



How it works

Jergens[™] Ball Lock receivers are integrated into the table





Fixtures are secured to the table with Clamping Devices









The receivers are located precisely into Primary and Secondary locations

Secondary in the back



Primary in the front



Three receiver locations are designated as Fixture Locations A, B and C.



The ProtoTRAK PMX CNC knows these Fixture Locations



In the Set Up Mode, just tell the ProtoTRAK which Fixture Offset you will use.

INCH		866 ALL OPS					
	ATC Pos 0 No Tool						
	ent	nagemei	Fixture Ma	Part			
	3		2	1		Part	
	16866 OPERATIO	ATIO 16	16866 OPER	OPERATIO	16866 (P/N
	NONE			A		Fixture Location	
	1	_	1	1		Fixture Number	
	0.0000		0.0000	0000	0.0	X Offset	
	0.0000		0.0000	0000	1.0	Y Offset	
	0.0000	2	0.0000	0000	0.0	Z Offset	
	1		1	1		Parts/Fixture	
	0.0000		0.0000	0000	105.00	X Shift	
	0.0000		0.0000	0000		Y Shift	
	0.0000		0.0000	0000	0.0	Z Shift	
		ure B	SET for Fix SET for Fix SET for Fix	2.	A 0	0.000 0.000 18.734	X Y Z
		Ą	OCATION :	FIXTURE L			
RETURN				Z SAFETY	GO TO	NOTES	PICTURE

Here, Fixture Location A has been entered.



	SET-UP MP/N 1686	6 ALL OPS	INCH				
		ATC Por					
	Part/Fixture Management						
	Part P/N	1 16866 OPERATIO 16	2 866 OPERATIO	3 16866 OPERATIO			
	Fixture Location Fixture Number	A 1	NONE 1	NONE 1			
	X Offset Y Offset	0.0000	0.0000	0.0000			
	Z Offset Parts/Fixture	0.0000	0.0000	0.0000			
	X Shift Y Shift	0.0000	0.0000 0.0000	0.0000			
	Z Shift	0.0000	0.0000	0.0000			
	X 0.0000 Y 0.0000 Z 18.7340) A 1.5 2.5	ET for Fixture A ET for Fixture B ET for Fixture C				
	FIXTURE LOCATION :						
	PICTURE NOTES	GO TO SAFETY			RETURN		
You can also apply	offsets.			The machine's position is displayed in order for you to use to input your			
				at is necessary.			

Now the ProtoTRAK PMX knows where your fixture is.



The Jergens[™] Ball Lock System makes placing and removing fixtures fast, easy and precise.

- The positioning accuracy is +/- 0.0002
- Clamping force is 2,250 lbs per ball lock post



Fixtures

There is no limit to the ingenuity you can apply to fixturing.

We can get you started from some clever things we've learned from our own shop as well as from some TRAK LPM users.

Make your own Fixture Plates by installing the Jergens™ Ball Lock Liners.



Fixtures

Use fixtures you already have with our optional Ball Lock Locating Guide Assembly





Fixtures

We offer fixture plates in three sizes





Fixtures

With some preparation, jobs can be changed over in a few quick motions.





The Workholding System

That isn't the end of the story, because the Job Management System allows you to

- Store and use fixture offsets
- Create and store notes about fixtures and set ups
- Capture photos of your set ups

See also: <u>TRAK LPM Job Management System</u> <u>TRAK LPM Tool Setting System</u>

Back to TRAK LPM