

Model KM-JB SWITCHABLE PERMANENT MAGNETIC HOLDER

Suitable as exclusive fixing jig for round steel bars and irregularly shaped workpieces!



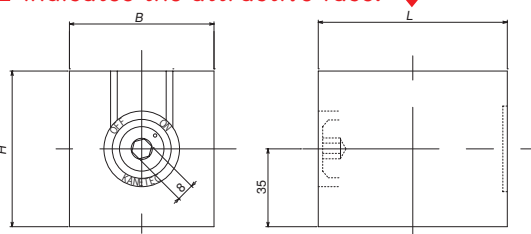
[Application]

In addition to using these holders as a fixing jig for small workpieces, they can be used as a block to support 3 points of a workpiece during grinding.

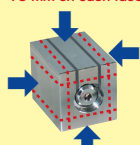
[Features]

- Each face can be worked additionally for up to 10mm. (The on/off operation face and rear face are excluded.)
- By using these holders as exclusive jigs for a particular workpiece, the work efficiency is improved.
- As these holders are of drip-proof construction, they can be used in liquid such as during electric discharge machining.

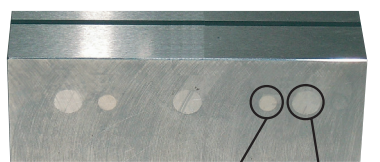
↑ indicates the attractive face. ↓



Additional work allowed area.
(Top/bottom/right/left)
Additionally workable up to 10 mm on each face.



KM-JB side face



Pin Counterbore

※ However, avoid making a hole in the pin and counterbore areas.

Model	Holding Power	Dimensions			Mass
		B	L	H	
KM-JB0709	392N (40kgf)	65 (2.55)	85 (3.34)	70 (2.75)	2.5kg/ 5.5 lb
KM-JB0812	883N (90kgf)	80 (3.14)	120 (4.72)	90 (3.54)	5.5kg/ 12.1 lb

※ The holding power is based on a test piece of □50 × 125, S15C. ※ A hex wrench key is included.

Model MM FREE BLOCK

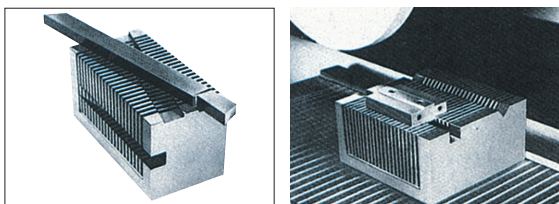
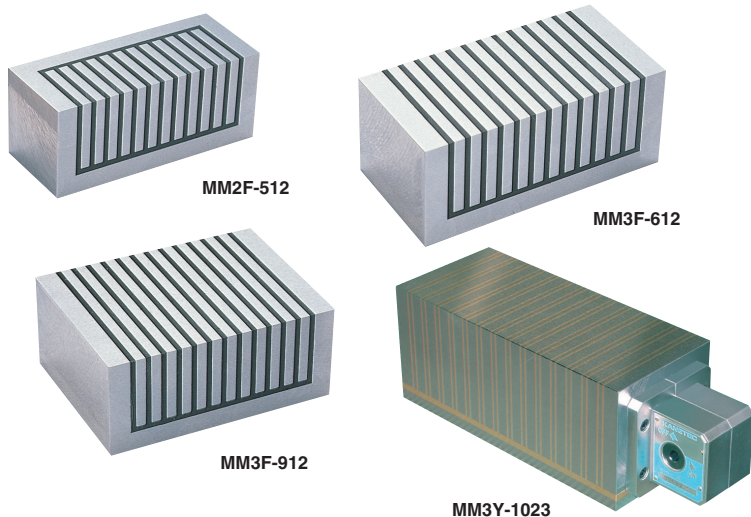
Freely workable permanent magnetic block

[Application]

These blocks are designed to allow deep engraving such as grooves and steps on the attractive face to fit workpiece shapes when holding workpieces.

[Features]

- The attractive face can be removed up to 10 mm deep from the surface of the new block.
- As workpieces can be fitted in grooves, a large machining pressure can be used. Also cemented carbide workpieces, which are difficult to hold by a magnetic chuck, can be secured by using these blocks to enable grinding.
- These blocks can be mounted on the magnetic chuck work face.
- There are two types; a magnetic force ON-OFF type and a type not equipped with an ON-OFF function.

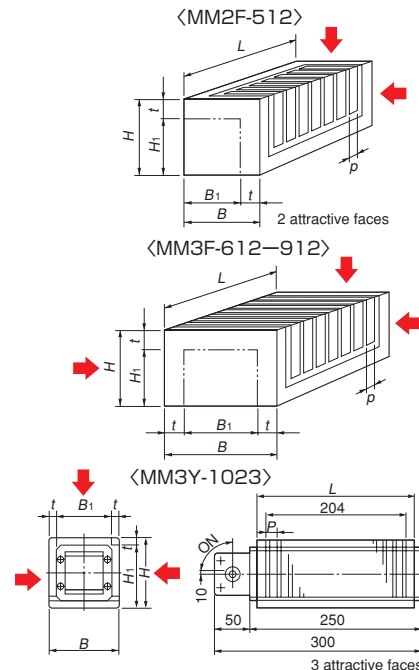


[mm (in)]

Model	Nominal Size	Holding Power	Dimensions						Pole Pitch P	Work Allowance t	Mag. Force ON/OFF	Mass
			B	L	H	B ₁	H ₁	H ₂				
MM2F-512	50 (1.96) × 120 (4.72)	200N (20kgf)	50 (1.96)			40 (1.57)	40 (1.57)	8 (3+5) 0.31 (0.11+0.19)	Max.10 (0.39)	Not provided	2kg/ 4.4 lb	
MM3F-612	60 (2.36) × 120 (4.72)	400N (40kgf)	60 (2.36)	120 (4.72)	50 (1.96)	70 (2.75)		20kg/ 44 lb				
MM3F-912	90 (3.54) × 120 (4.72)	600N (60kgf)	90 (3.54)									
MM3Y-1023	100 (3.93) × 230 (9.05)	750N (75kgf)	100 (3.93)	230 (9.05)	100 (3.93)	80 (3.15)	90 (3.54)	15.2 (0.59)		Provided		

※ The holding power is a reference value obtained using a test piece of S15C, □50 × 125, ground surface.
※ For MM3Y-1023, a dedicated handle is included.

※ Note that when workpieces are held on two or more faces simultaneously, the holding power of each face drops.



↑ indicates the attractive face.

ELECTROMAGNETIC CHUCKS

CHUCK CONTROLLERS

PERMANENT ELECTROMAGNETIC CHUCKS

PERMANENT ELECTROMAGNETIC CHUCKS

BLOCKS FOR MC

VACUUM CHUCKS

PROMELTA* SYSTEM

SINE BAR CHUCKS

BLOCKS, HOLDERS, MINI CHUCKS

HOLDING TOOLS

MEASURING TOOL HOLDERS

MAGNETIC HOLDERS

MAGNETIC TOOLS