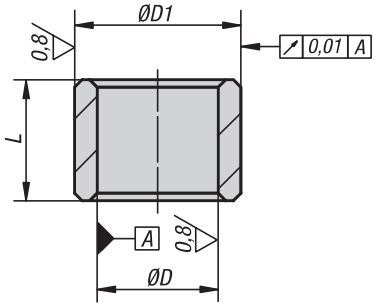
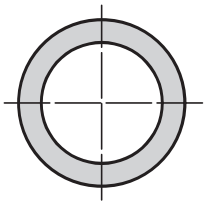
K0861

Locating bushings

for grid systems





Material:
Special case-hardened steel

Version:
Hardened and ground.

Sample order:
K0861.01508305002

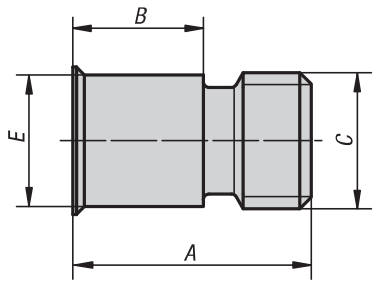
Note:
See next page for assembly instructions for changing locating bushings.

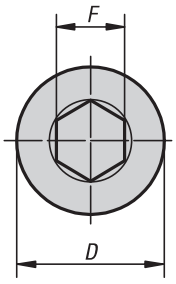
KIPP Locating bushings for grid systems

Order No.	D	D1	L
K0861.01508305002	12 H6	16 g5	8
K0861.01012304002	12 F7	18 g6	12
K0861.01016405002	16 F7	22 g6	16

K0862

Aluminium protection plugs





Material:
Aluminium.

Version:
Bright.

Sample order:
K0862.60108015

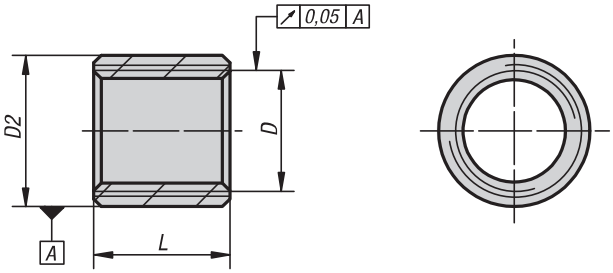
Note:
Use these plugs to seal grid holes and protect them from swarf and dirt.
Leave the protection plugs in holes not in use!
Aluminium plugs are used when aggressive coolants are used or when cutting dry.

KIPP Aluminium protection plugs

Order No.	A	B	C	D	E	F
K0862.60108015	15	7,5	M8	12,6	11,8	5
K0862.60112021	21	11,5	M12	13	11,6	6
K0862.60116026	26	15	M16	17	15,6	8

Threaded bushings

for grid systems



Material:
Carbon steel.

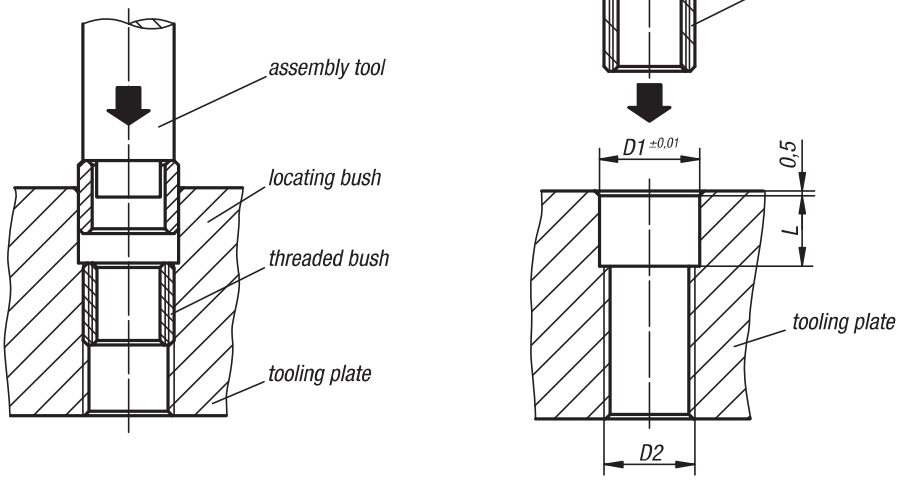
Version:
Tempered to 1100-1300 N/mm².

Sample order:
K0863.01508305003

Note:
Assembly instructions for changing threaded bushing.

Inserting the locating and threaded bushing
1. Remove grease from the locating and threaded bushing.
2. Apply adhesive (Loctite 638) in the hole.
3. Apply adhesive (Loctite 638) on the threaded bushing and screw in.
4. Apply adhesive (Loctite 638) to the locating bushing and insert it. If the locating bushing cannot be inserted by hand, please use an assembly tool as shown application example:.
5. Remove any adhesive pressed out by insertion of the locating and threaded bushing before it hardens.

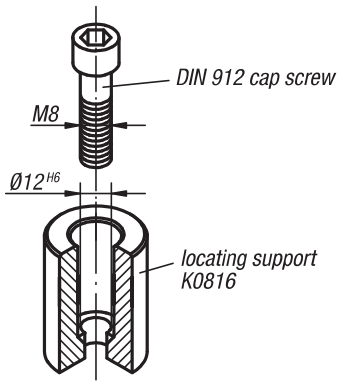
Assembly instructions for locating and threaded bushes

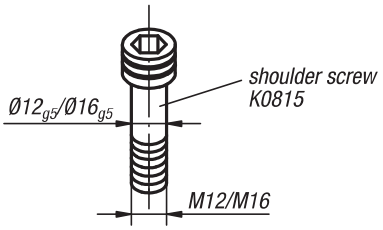


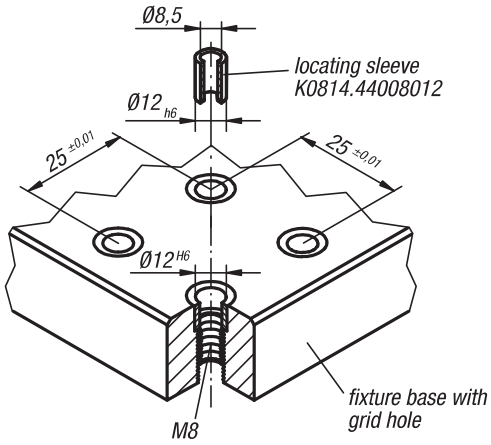
KIPP Threaded bushings for grid systems

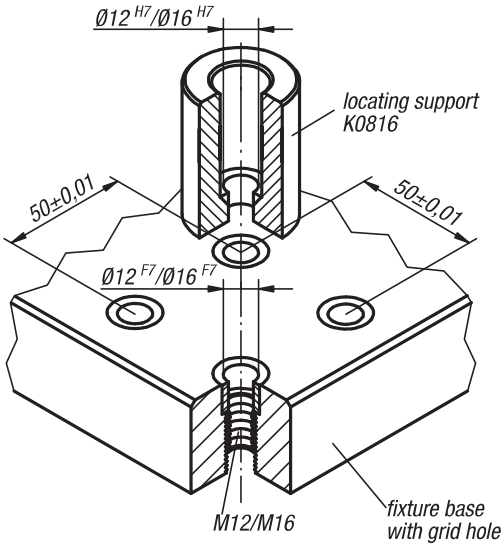
Order No.	D	D2	L
K0863.01508305003	M8	M12x1,75	12
K0863.01012304003	M12	M16x1,5	15
K0863.01016405003	M16	M20x1,5	18

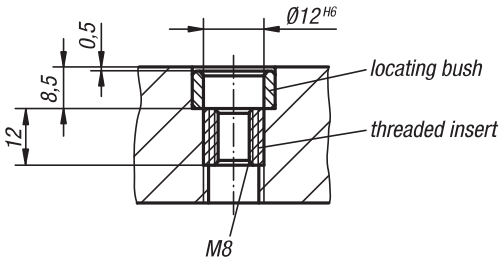
Grid holes and pitches

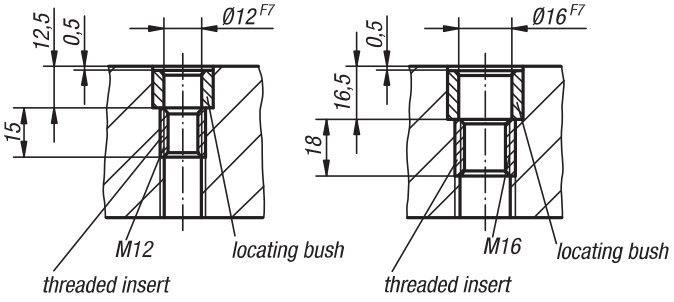












Grid hole:

The characteristic feature of the grid hole is its dual function: the coaxial arrangement of the locating and the threaded parts allows positioning and fastening at the same time with one grid hole (see illustrations). As a result, the size of the fixture elements can be reduced to a minimum and their flexibility increased accordingly.

Each grid hole consists of two parts:

a) reamed bush. Material: hardened tool steel.

b) threaded insert. Material: carbon steel, tempered to ca. 1100-1300 N/mm^2.

Since the reamed bushes are recessed 0.5 mm from the surface of the fixture bases, the mounting surfaces can be re-machined in the event of wear.