

Model **KM-JB** SWITCHABLE PERMANENT MAGNETIC HOLDER

suitable as exclusive fixing jig for round steel of extra-ordinary shape of work pieces!

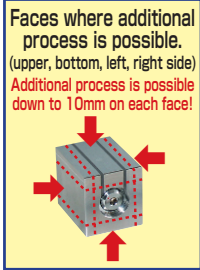


[Application]

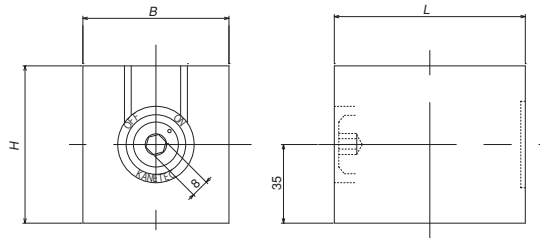
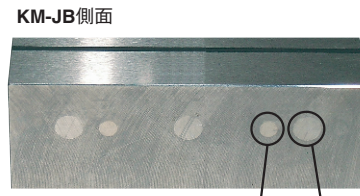
In addition to using it as a fixing device for small work pieces, it can be used as a block to support 3 parts of a work piece during grinding.

[Features]

- Holes can be made down to 10mm additionally on each face. (Except the face for on/off operation and rear face)
- By using it as exclusive jig to a particular work piece, working performance is improved.
- Due to its drip-proof structure, it can be used in liquid such as ED processing.



※However, please avoid making a hole on the part of pin and counter-bore.

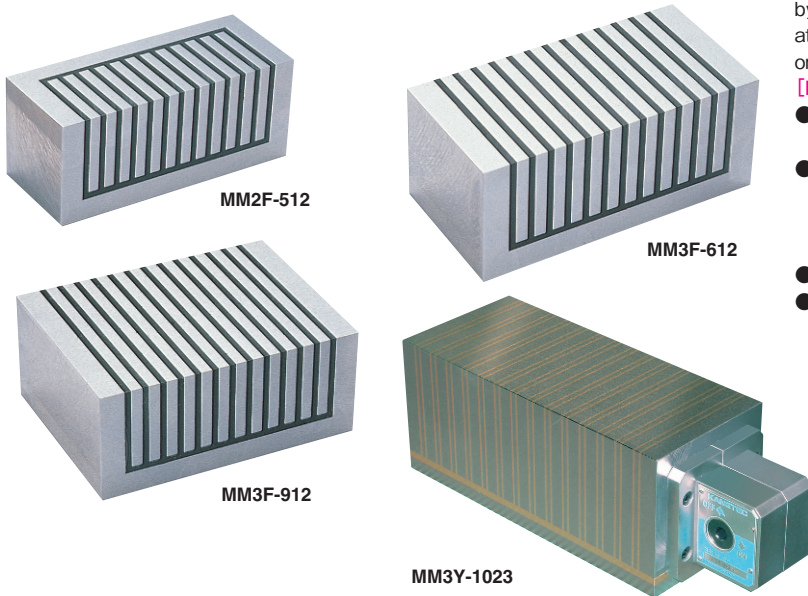


Model	Holding Power	Dimensions			Mass
		B	L	H	
KM-JB0709	392N (40kgf)	65 (2.55)	85 (3.34)	70 (2.75)	2.5kg/ 5.5 lb
KM-JB0812	883N (90kgf)	80 (3.14)	120 (4.72)	90 (3.54)	5.5kg/ 12.1 lb

※The holding power is based on a test piece of □50 x t25, S15C.
※The handle is a hexagonal wrench key.

Model **MM** FREE BLOCK

Freely workable permanent magnetic blocks

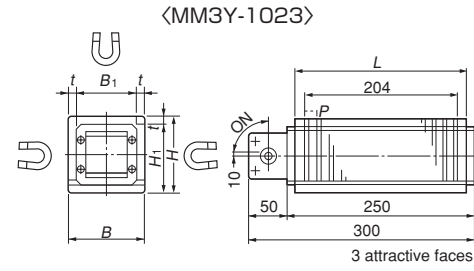
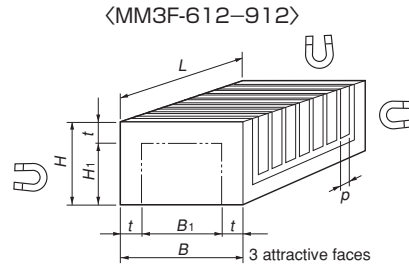
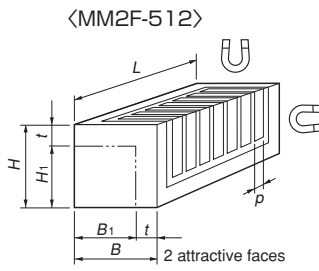
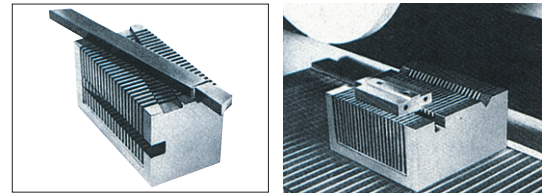


[Application]

These blocks are designed to allow deep engraving (machining by customer) such as grooves and steps on the magnetic attractive face to fit workpiece shapes when holding workpieces on these MM models.

[Features]

- The attractive face can be removed up to 10 mm deep from the surface of new blocks.
- As workpieces can be fitted in grooves, a large machining pressure can be used. Also cemented carbide workpieces, which are difficult to hold, can be held by using these blocks uniquely 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 ON-OFF function.



Model	Nominal Dimensions	Holding Power	Dimensions					Pole Pitch P	Work Area t	ON/OFF	Mass
			B	L	H	B ₁	H ₁				
MM2F- 512	50 (1.96) × 120 (4.72)	200N (20kgf)	50 (1.96)	120 (4.72)	50 (1.96)	40 (1.57)	40 (1.57)	8 (3+5) 0.31 (0.11+0.19)	Max.10 (0.39)	None	2kg/ 4.4 lb
MM3F- 612	60 (2.36) × 120 (4.72)	400N (40kgf)	60 (2.36)								3.5kg/ 7.7 lb
MM3F- 912	90 (3.54) × 120 (4.72)	600N (60kgf)	90 (3.54)	70 (2.75)	3.5kg/ 7.7 lb						
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	20kg/ 44 lb	

※The holding power applies to S15C, □50 x t25, ground surface and is presented for reference only.

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