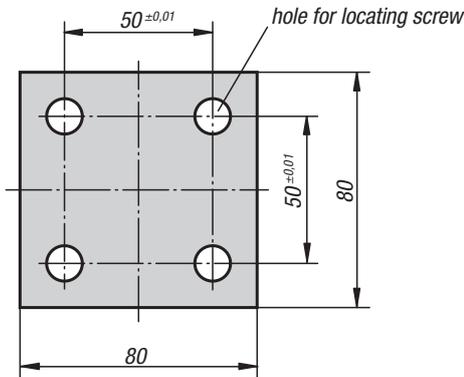
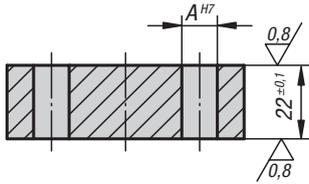


Accessories



Connecting blocks



Material:
Carbon steel.

Version:
Black oxidised.
Contact faces ground.

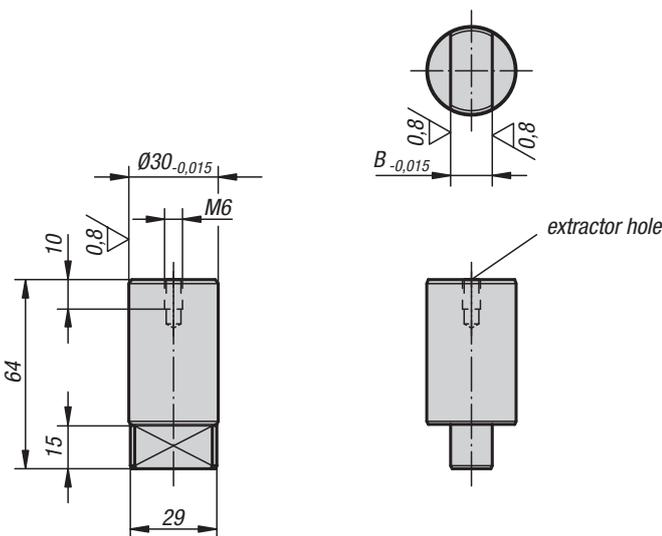
Sample order:
K0854.40012050

Note:
When several tooling plates K0800 are used, connecting blocks are needed to maintain the correct grid hole pitch from one plate to the next. They are secured using 4 shoulder screws K0815.1....

KIPP Connecting blocks

Order No.	A	Suitable shoulder screw
K0854.40012050	12	K0815.112055
K0854.40016050	16	K0815.116065

Locating pins



Material:
Carbon steel.

Version:
Tempered and black oxidised.
Precision diameters and guide faces ground.

Sample order:
K0855.12030

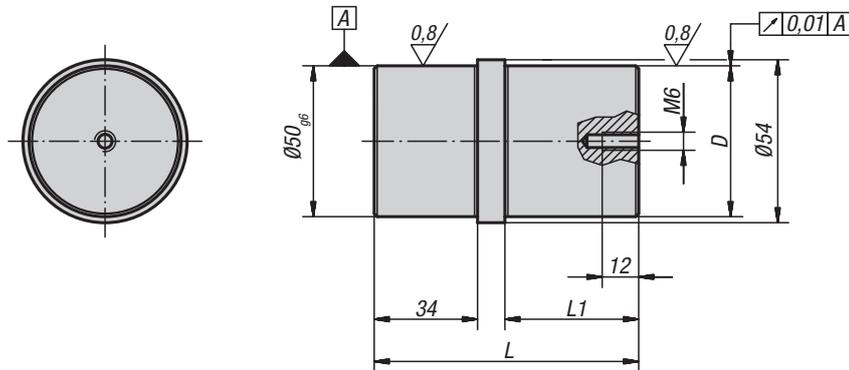
Note:
Locating pins are used for positioning grid plates K0800 on machine tables.

KIPP Locating pins

Order No.	B
K0855.12030	12
K0855.14030	14
K0855.18030	18
K0855.20030	20
K0855.22030	22

Centring pins

for central hole



Material:
Steel.

Version:
Case-hardened.
Toleranced diameter ground.

Sample order:
K0856.5025

Note:
Centring pins for central holes are suitable for basic elements K0806, K0802, K0803, K0804 and K0805.

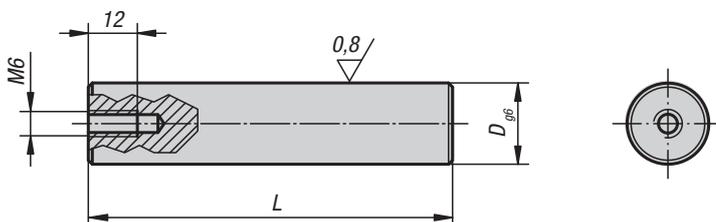
KIPP Centring pins for central hole

Order No.	D	L	L1
K0856.5025	25 g6	77	34
K0856.5030	30 h6	87	44
K0856.5050	50 g6	87	44

K0857

Centring pins

for aligning hole



Material:
Steel.

Version:
Case-hardened.
Toleranced diameter ground.

Sample order:
K0857.25125

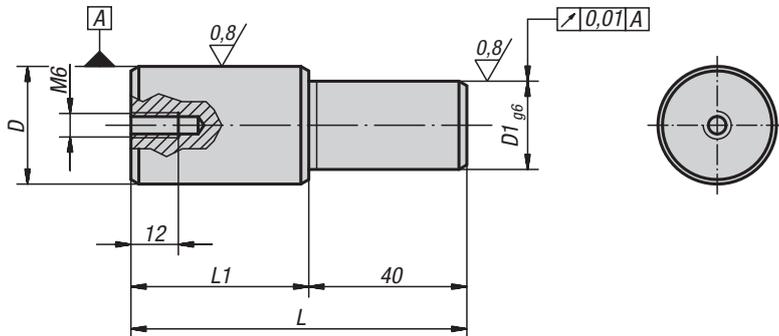
Note:
Centring pins for aligning holes are suitable for basic elements K0802, K0803 and K0805.

KIPP Centring pins for aligning hole

Order No.	D	L
K0857.20075	20	75
K0857.20089	20	89
K0857.25125	25	125

Centring pins

for aligning hole



Material:
Steel.

Version:
Case-hardened.
Toleranced diameter ground.

Sample order:
K0858.2520

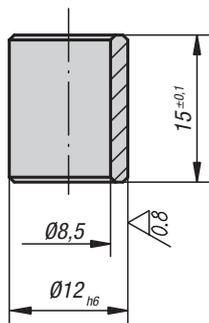
Note:
Centring pins for aligning holes are suitable for subplates K0806.

KIPP Centring pins for aligning hole

Order No.	D	D1	L	L1
K0858.2520	25 g6	20	75	35
K0858.3020	30 h6	20	85	45
K0858.3025	30 h6	25	85	45

K0814

Locating sleeve



Material:
Tool steel.

Version:
Hardened and black oxidised.
Toleranced diameter ground.

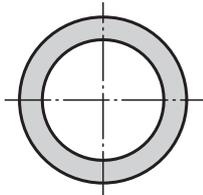
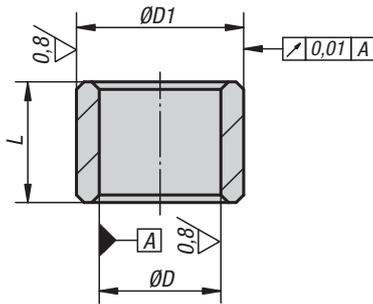
Sample order:
K0814.44008012

KIPP Locating sleeve

Order No.	Dimensions
K0814.44008012	see drawing

Locating bushings

for grid systems



Material:
Special case-hardened steel

Version:
Hardened and ground.

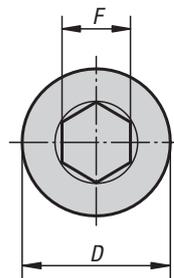
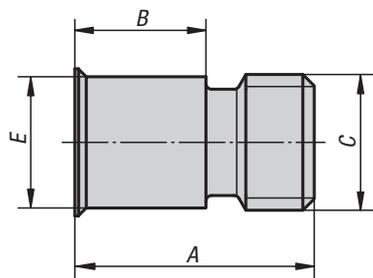
Sample order:
K0861.01508305002

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

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



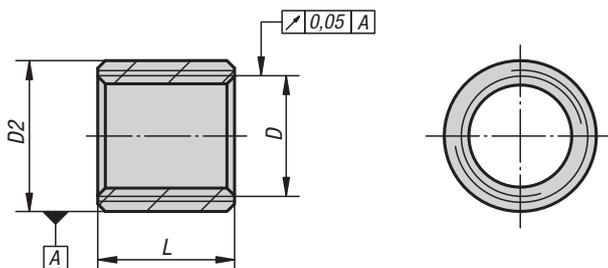
Material:
Carbon steel.

Version:
Tempered to 1100-1300 N/mm².

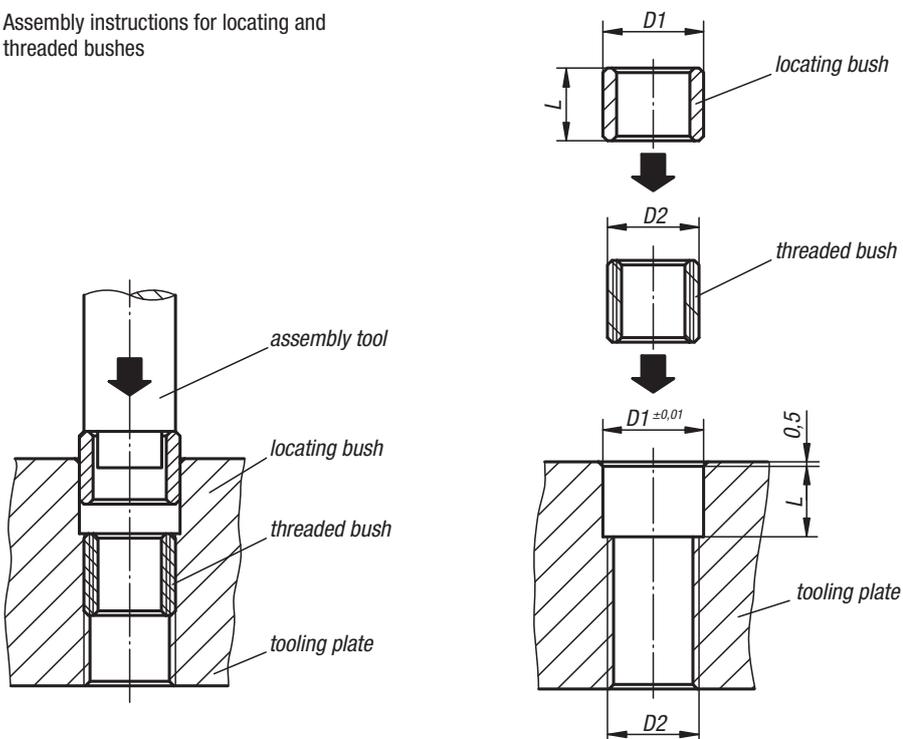
Sample order:
K0863.01508305003

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.



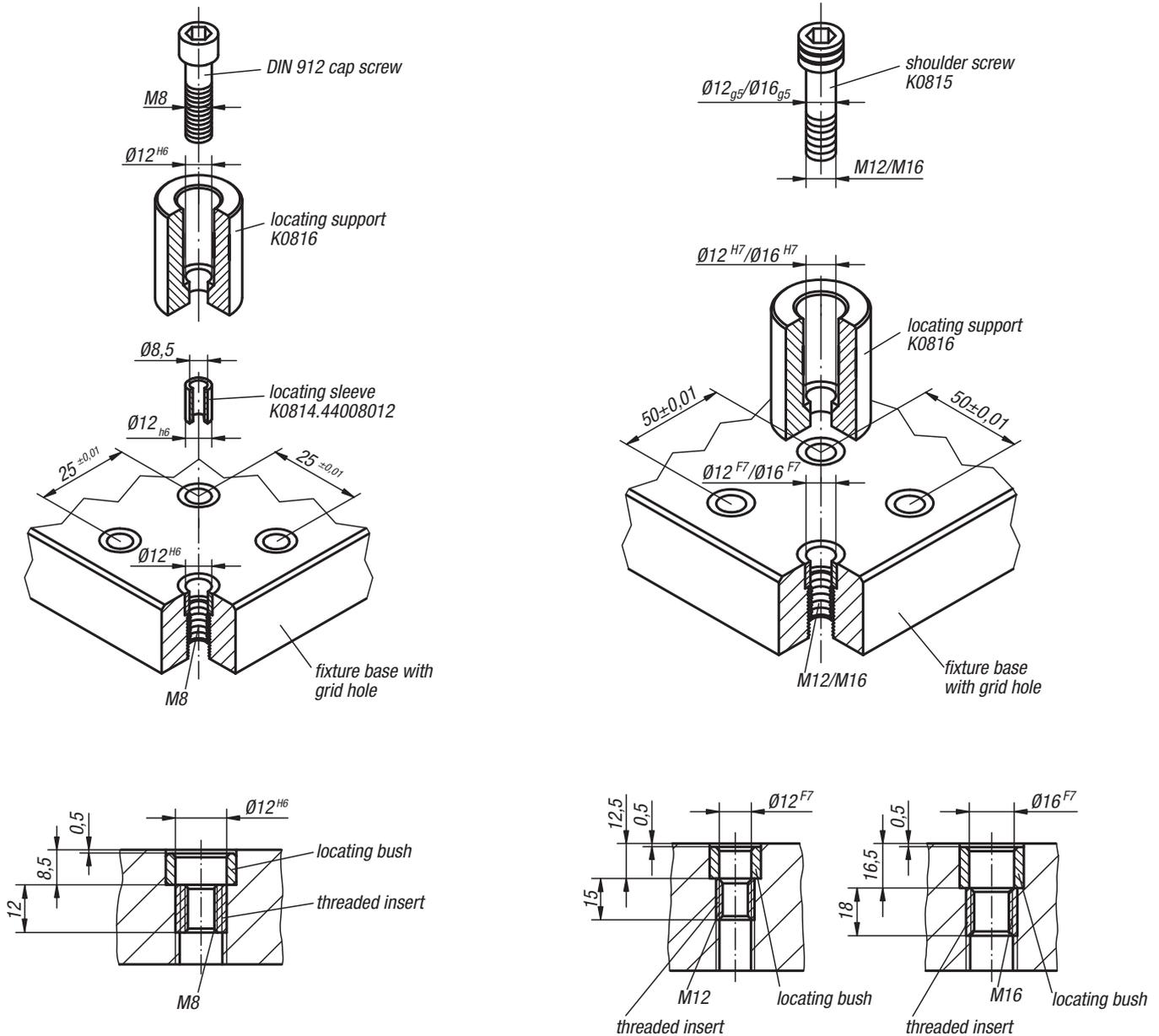
Assembly instructions for locating and threaded bushes



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:

- reamed bush. Material: hardened tool steel.
- threaded insert. Material: carbon steel, tempered to ca. 1100-1300 N/mm².

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.

