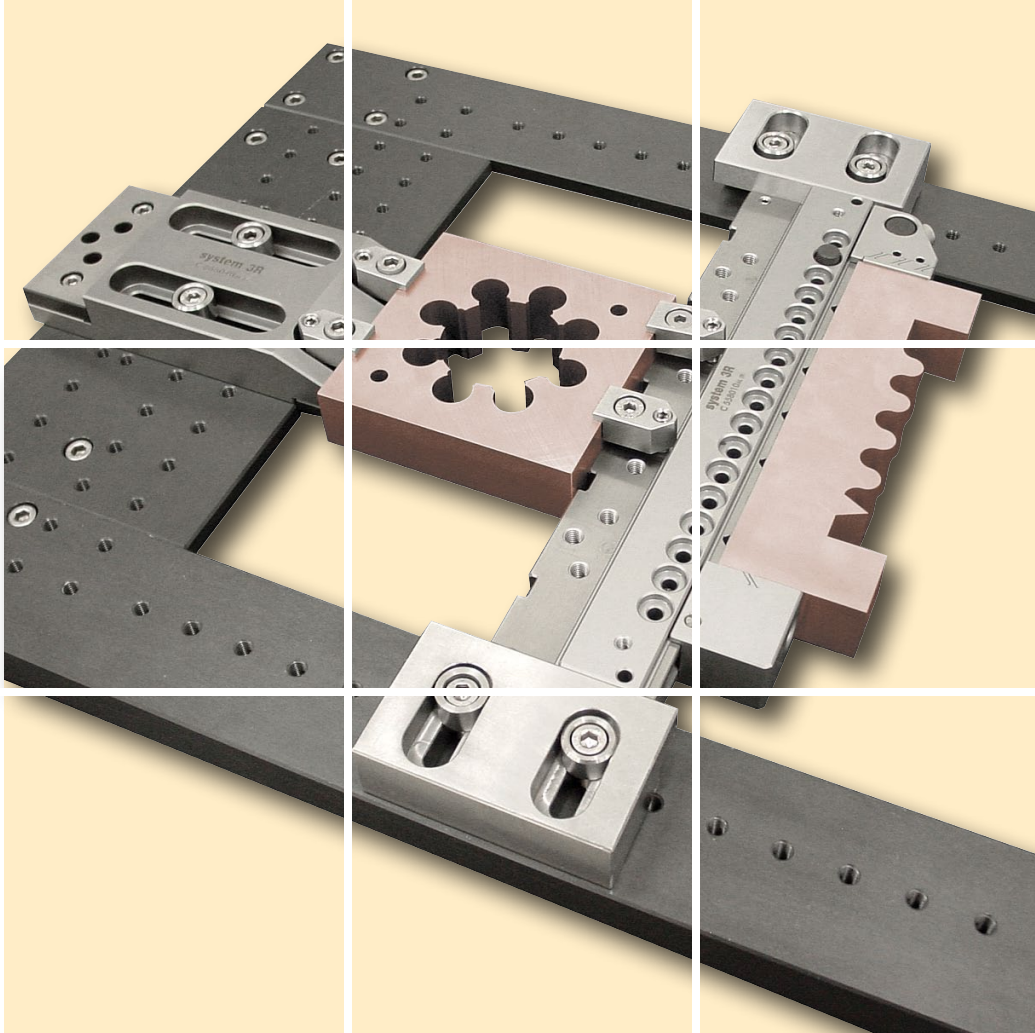
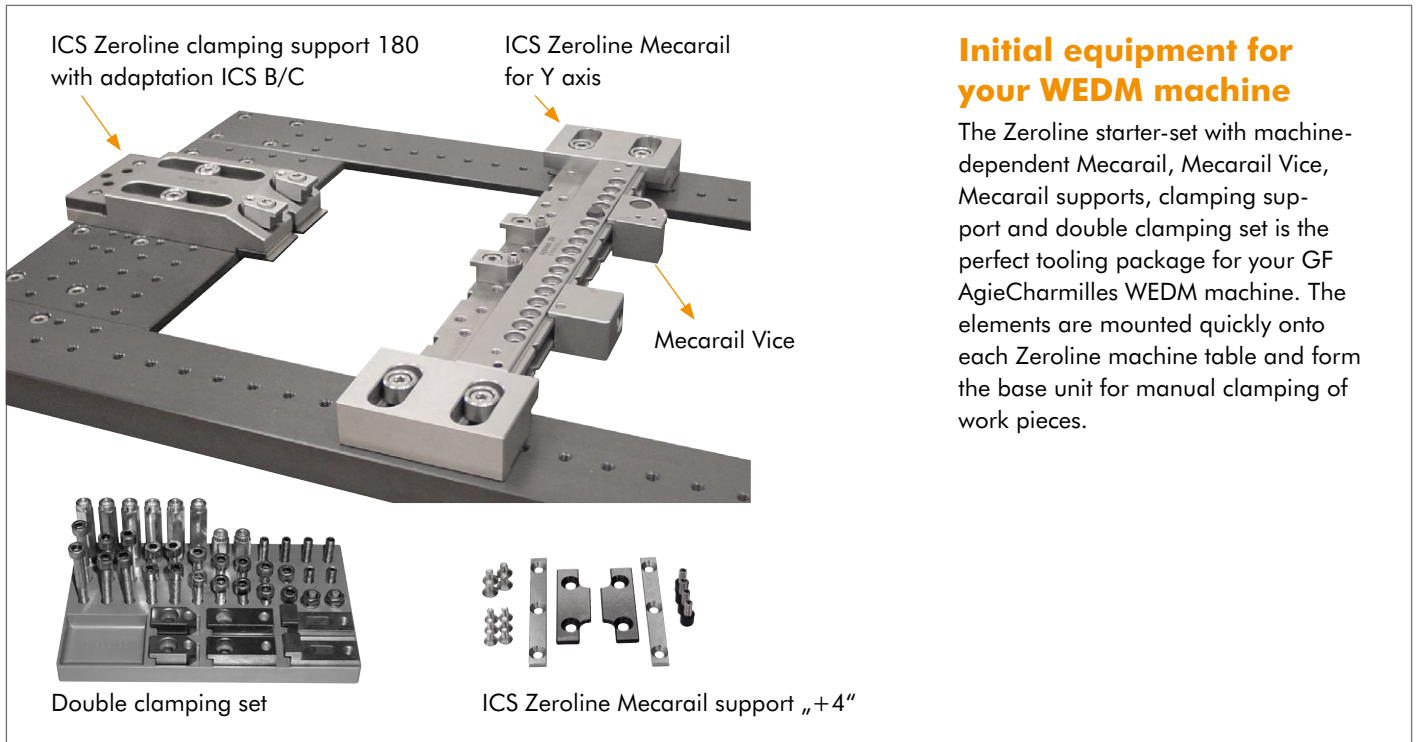


Starter-set Zeroline



STARTER-SET ZERO LINE

for ridged, stable and manual clamping of work pieces



Initial equipment for your WEDM machine

The Zeroline starter-set with machine-dependent Mecarail, Mecarail Vice, Mecarail supports, clamping support and double clamping set is the perfect tooling package for your GF AgieCharmilles WEDM machine. The elements are mounted quickly onto each Zeroline machine table and form the base unit for manual clamping of work pieces.

Set item numbers

For each GF AgieCharmilles wire machine there is a starter-set. The following table shows the Zeroline starter-set item number according to machine type.

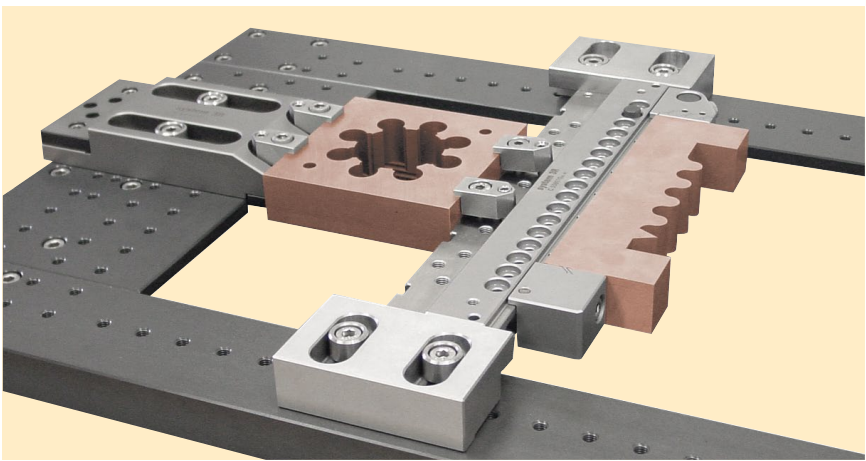
CUT 20	S 160 400
CUT 30	S 160 450
CUT 200 FI 240 CCS / SLP	S 160 300
CUT 300 FI 440 CCS / SLP	S 160 350
CUT 2000 AC Vertex 2 AC Classic V2 AC Progress V2 AC Challenge V2	S 160 400
CUT 3000 AC Vertex 3 AC Classic V3 AC Progress V3 AC Challenge V3	S 160 350

Quick installation

The ICS Zeroline Mecarail with the assembled Mecarail Vice is mounted in Y axis of the WEDM machine. With the additional use of the Zeroline clamping support, the clamping elements enable a versatile and secure set-up of parts in the cutting envelope of the WEDM machine.

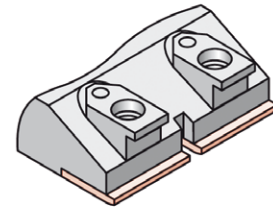
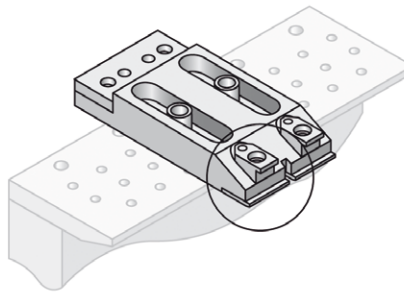
Application

The set applies mainly to clamp, support and hold parts in the cutting envelope of the WEDM machine. The Zeroline starter-set can be expanded with clamping elements and adapters from the ICS B & C range.

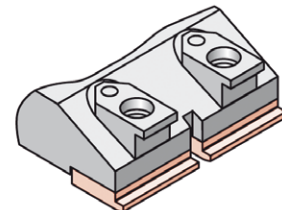


Collision free clamping

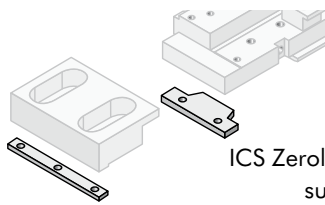
The supports „+4“, are included in the set, they lift the Mecarail's support lips above zero line to remove any possibility of collision with the bottom wire guide. For the clamping support special support lips „0“ and „+4“ are included.



support lips „+4“
for collision free clamping



support lips „0“



ICS Zeroline Mecarail
supports „+4“

Support-clamping of work pieces

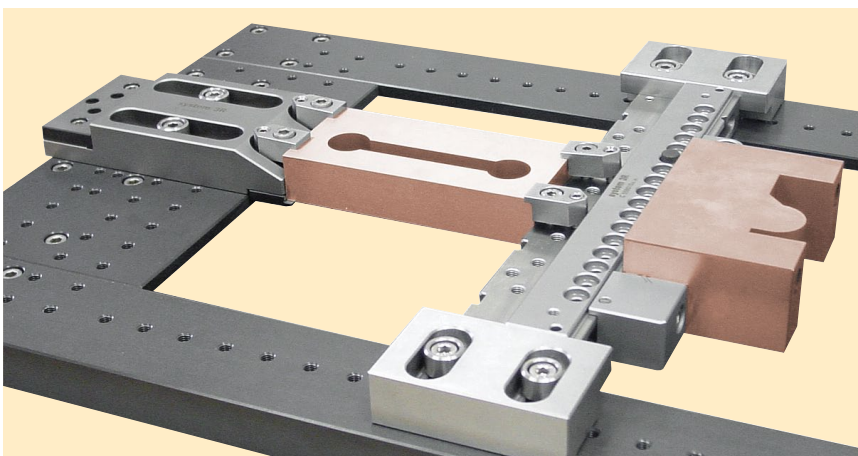
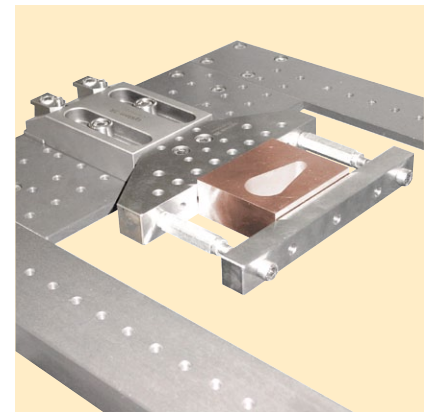
With the Mecarail's clamping bar side and the clamping support plate-shaped and cubic work pieces are „support-clamped“ on „0“ or collision free on „+4“ in the cutting envelope of the WEDM machine.

For „overhung clamping“ of work pieces the clamping support is suitable to only a limited extent for flat and small lightweight parts.

Overhung clamping with the Mecarail-Vice

The most frequently application of the Mecarail Vice is collision free clamping and machining of plates and cubic work pieces of different sizes.

The Mecarail Vice jaw set consists of a fixed and a movable jaw. The guided jaws can be placed according to requirements and in such a way that the gripping mechanism is actuated from left or right hand side. The fixed jaw can be positioned with mechanical stops in several positions. The wire-cut contour in both jaws triggers the pull-down effect when clamping.



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