

# Centre Marking Tool for Stamping Unit

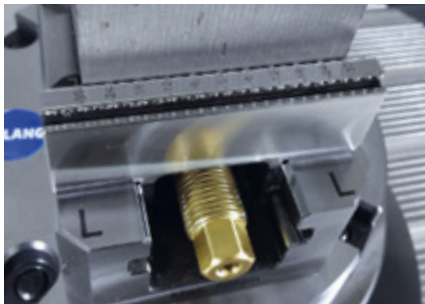
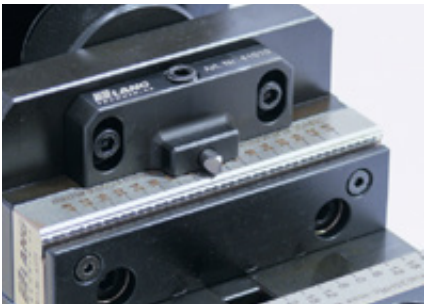
The centre marking tool plunges a notch above the stamping contour at the centre of the part.  
This marking allows the exact and centric positioning of parts in Makro·Grip® 5-Axis Vices without any endstops.



## CENTRE MARKING TOOL

ITEM NO.	DESCRIPTION	PRICE
41010	Centre marking tool	
41010-01	Spare marking stud	

The centre marking tool will be mounted to the moveable jaw of the stamping unit with two M 6 × 14 screws (included).



# Gauging Blocks for measuring wear of Stamping Jaws



## GAUGING BLOCKS FOR MEASURING WEAR OF STAMPING JAWS

ITEM NO.	UNIT	PRICE
41020	1 set (3 pcs.)	

Creating trust! Always the same clamping quality. To ensure consistent holding power in the clamping device, it is necessary to check the wear of the stamping teeth regularly.



Position one gauging block with slots on each side of the stamping jaws. Tighten the jaws by hand only, do not actuate the switch!



Make sure that the stamping teeth are placed in the grooves of the gauging blocks.



When the indicator block fits between the stamping contour, the jaws need to be sent in for reconditioning.

# Stamping Jaws – Standard and High-End version



## STANDARD STAMPING JAWS WITH 3 MM PARALLELS

ITEM NO.	FOR MATERIALS	UNIT	PRICE
41111	up to 35 HRC	1 pair	

Standard stamping jaws for all materials up to 35 HRC.



## HIGH-END STAMPING JAWS WITH 3 MM PARALLELS

ITEM NO.	FOR MATERIALS	UNIT	PRICE
41112	up to 45 HRC	1 pair	

Standard stamping jaws for all materials up to 45 HRC.

## Reconditioning Stamping Jaws



## RECONDITIONING STAMPING JAWS

ITEM NO.	VERSION	PRICE
41111-01	Standard stamping jaws	
41112-01	High-End stamping jaws	

When the stamping teeth are worn out the jaws can be reconditioned up to 6 times per pair. The original thickness of a stamping jaw is 18 mm. With every reconditioning process the thickness is reduced by 0.5 mm until it has reached 15 mm (measured at the highest stamping tooth tip). If a stamping tooth is broken off more than the regular 0.5 mm per reconditioning is required. The total amount of possible reconditioning processes is reduced accordingly.

**Note for dual stamping:** With every reconditioning process we generally supply shims. The thickness of these shims is determined by the remaining thickness of the stamping jaw. Thickness of stamping jaw and shim will always amount to 18 mm. This guarantees that stamping jaws which have been reconditioned at different intervals can be used together, applying the same pressure on the workpiece.

### Tip for your benefit:

In order to bridge the time of the reconditioning process we suggest keeping a second pair of stamping jaws in reserve!

