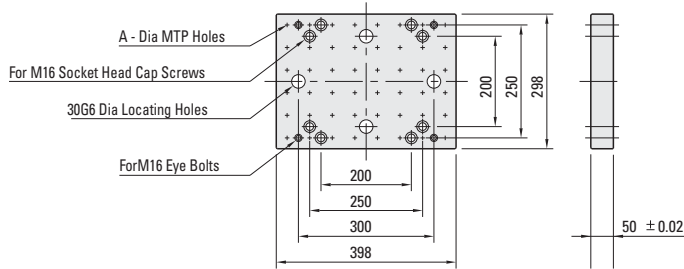
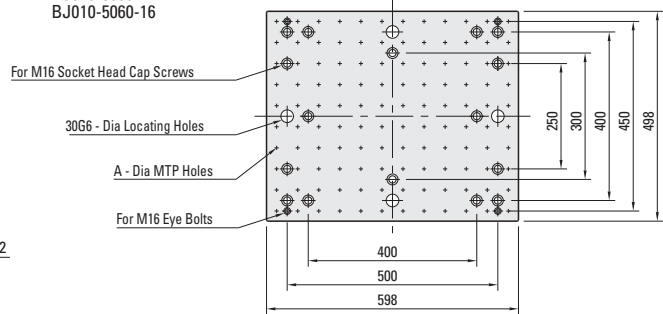
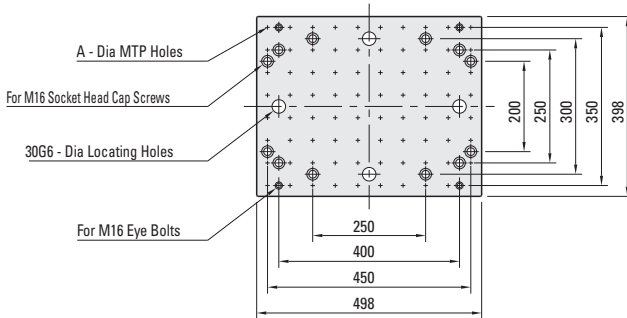
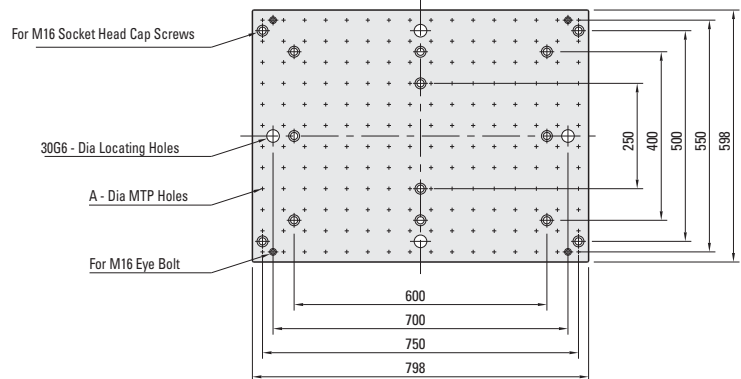


## RECTANGULAR GRID PLATES



BJ010-3040-12

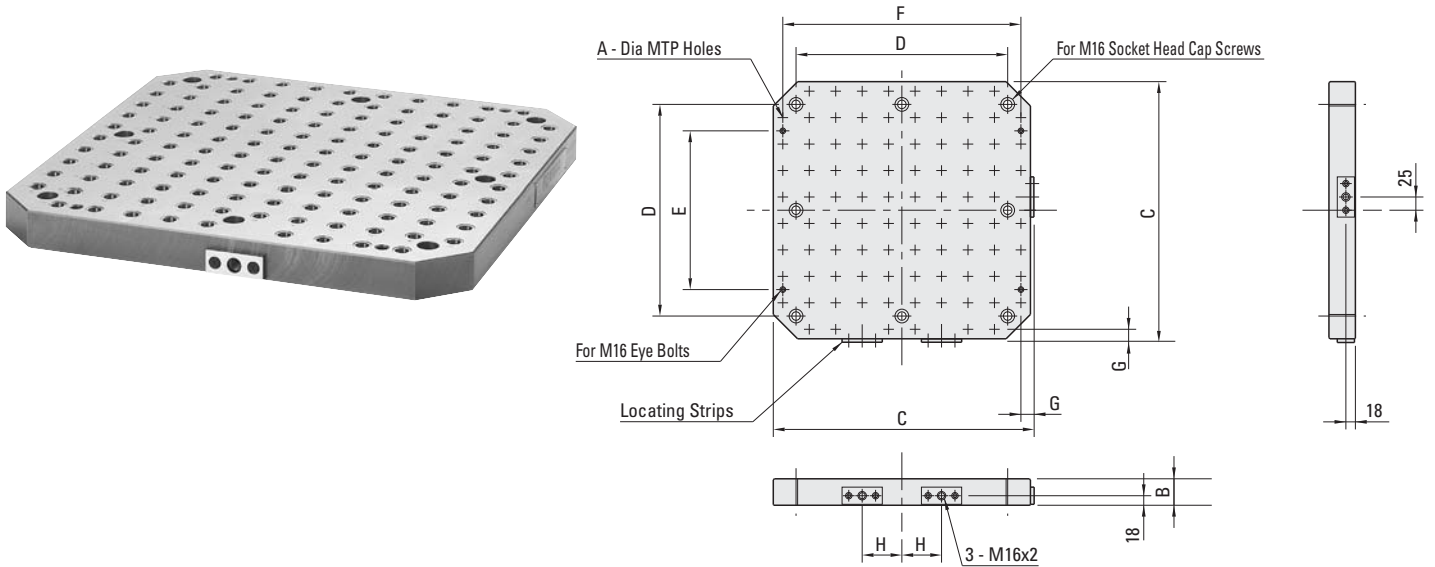
BJ010-5060-12  
BJ010-5060-16BJ010-4050-12  
BJ010-4050-16BJ010-6080-12  
BJ010-6080-16

The body is made from FC250 cast iron – annealed and precision ground. The alignment bushings are made from SUJ2 steel. The thread inserts are made from SAE-1045 alloy steel and heat treated. MTP hole spacing is 50mm +/-0.02. Includes protection plugs and eyebolts. Each MTP hole is lettered and numbered for addressing holes. See page 377 for MTP hole construction.

Part #	(F7) A mm	A Thread mm	No. of MTP Holes	No. of Mounting Holes
BJ010-3040-12	12	M12X1.75	48	8
BJ010-4050-12	12	M12X1.75	80	12
BJ010-4050-16	16	M16X2	80	12
BJ010-5060-12	12	M12X1.75	120	16
BJ010-5060-16	16	M16X2	120	16
BJ010-6080-12	12	M12X1.75	192	14
BJ010-6080-16	16	M16X2	192	14

See page 377 for F7 tolerance specifications.

## SQUARE GRID PLATES

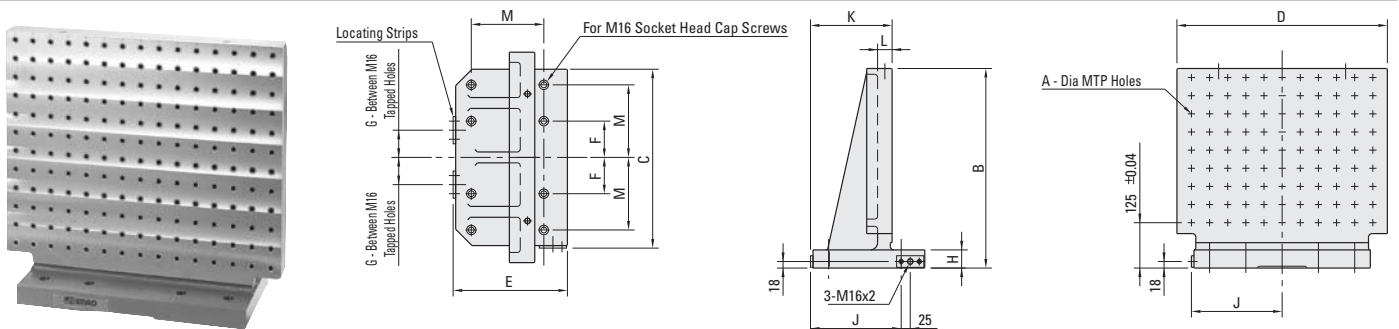


The body is made from FC250 cast iron – annealed and precision ground. The alignment bushings are made from SUJ2 steel. The thread inserts are made from SAE-1045 alloy steel and heat treated. MTP hole spacing is 50mm +/-0.02. Includes protection plugs and eyebolts. Each MTP hole is lettered and numbered for addressing holes. See page 377 for MTP hole construction.

Part #	(F7) A mm	A Thread mm	+/-0.02 B mm	C mm	D mm	E mm	F mm	+/-0.04 G mm	H mm	Number of MTP Holes	Number of Mounting Holes
BJ040-4040-12	12	M12X1.75	50	393	320	200	350	25	55	59	4
BJ040-4040-16	16	M16X2	50	393	320	200	350	25	55	59	4
BJ040-5050-12	12	M12X1.75	50	493	400	300	450	25	75	93	8
BJ040-5050-16	16	M16X2	50	493	400	300	450	25	75	93	8
BJ040-6363-12	12	M12X1.75	50	623	500	400	550	40	100	139	8
BJ040-6363-16	16	M16X2	50	623	500	400	550	40	100	139	8
BJ040-8080-12	12	M12X1.75	60	793	640	500	750	25	135	237	8
BJ040-8080-16	16	M16X2	60	793	640	500	750	25	135	237	8

See page 377 for F7 tolerance specifications.

## ANGLE GRID PLATES

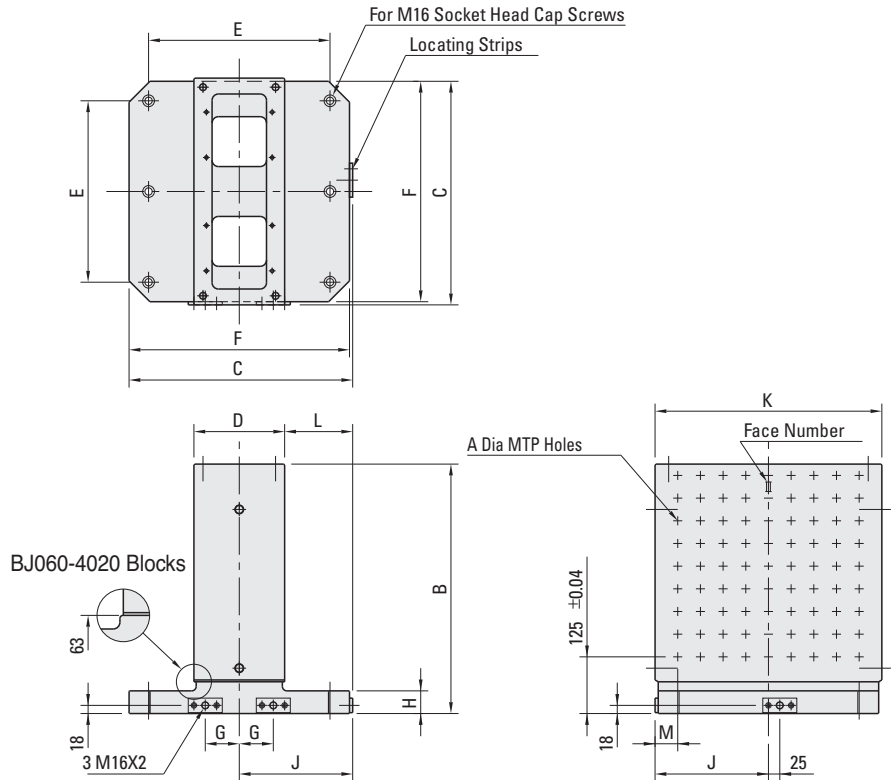
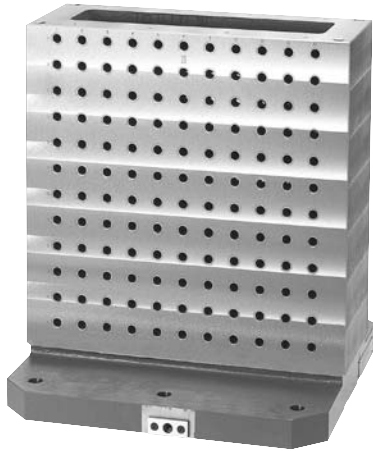


The body is made from FC300 cast iron – annealed and precision machined. The alignment bushings are made from SUJ2 steel. The thread inserts are made from SAE-1045 alloy steel and heat treated. MTP hole spacing is 50mm +/-0.02. Includes protection plugs and eyebolts. Each MTP hole is lettered and numbered for addressing holes. See page 377 for MTP hole construction.

Part #	(F7) A mm	A Thread mm	B mm	C mm	D mm	E mm	F mm	G mm	H mm	+/-0.04 J mm	+/-0.04 K mm	L mm	M mm	Number of MTP Holes	No. of Mounting Holes
BJ050-4101-12	12	M12X1.75	450	393	470	265	-	55	45	200	175	40	160	63	4
BJ050-4101-16	16	M16X2	450	393	470	265	-	55	45	200	175	40	160	63	4
BJ050-5101-12	12	M12X1.75	550	493	580	315	100	75	50	250	225	40	200	99	8
BJ050-5101-16	16	M16X2	550	493	580	315	100	75	50	250	225	40	200	99	8
BJ050-6101-12	12	M12X1.75	700	623	760	380	125	100	55	315	265	50	250	180	8
BJ050-6101-16	16	M16X2	700	623	760	380	125	100	55	315	265	50	250	180	8
BJ050-8101-12	12	M12X1.75	800	793	900	465	160	135	60	400	350	50	320	238	8
BJ050-8101-16	16	M16X2	800	793	900	465	160	135	60	400	350	50	320	238	8

See page 377 for F7 tolerance specifications.

## TWO-SIDED GRID BLOCKS

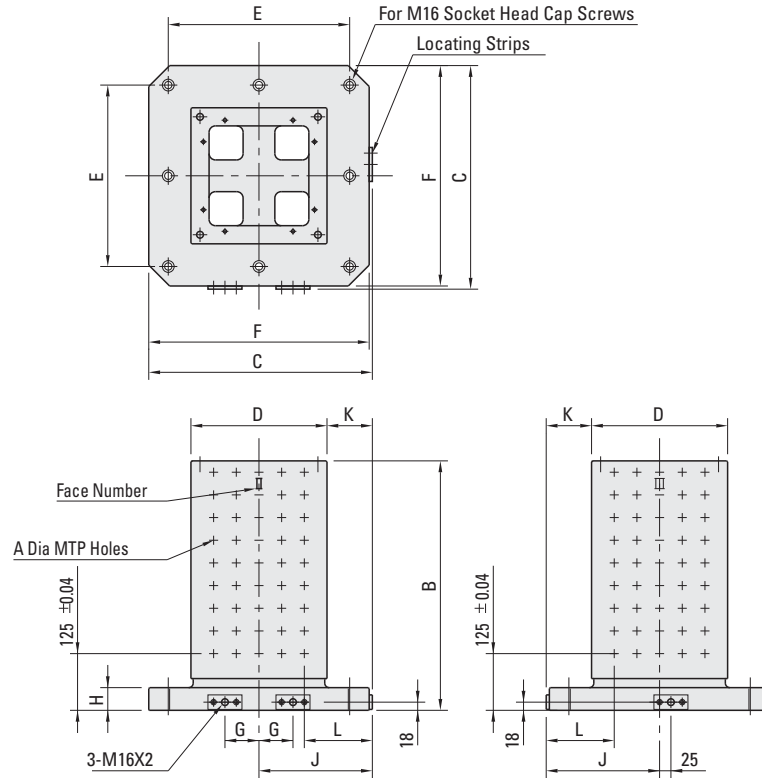
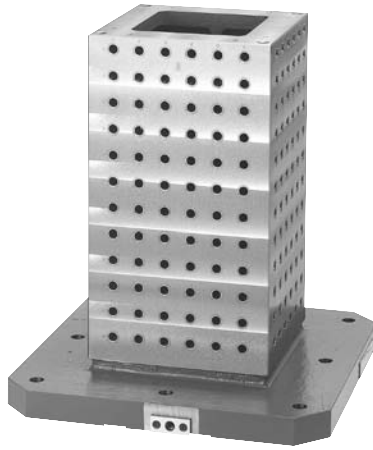


The body is made from FC300 cast iron – annealed and precision machined. The alignment bushings are made from SUJ2 steel. The thread inserts are made from SAE-1045 alloy steel and heat treated. MTP hole spacing is 50mm +/-0.02. Includes protection plugs and eyebolts. Each MTP hole is lettered and numbered for addressing holes. See page 377 for MTP hole construction.

Part #	(F7) A mm	A Thread mm	B mm	C mm	+/-04 D mm	E mm	F mm	G mm	H mm	J mm	K mm	+/-04 L mm	+/-04 M mm	Number of MTP Holes	No. of Mounting Holes
BJ060-4015-12	12	M12X1.75	450	393	150	320	386	55	50	200	400	125	50	98	4
BJ060-4015-16	16	M16X2	450	393	150	320	386	55	50	200	400	125	50	98	4
BJ060-5020-12	12	M12X1.75	550	493	200	400	486	75	50	250	500	150	50	162	6
BJ060-5020-16	16	M16X2	550	493	200	400	486	75	50	250	500	150	50	162	6
BJ060-6325-12	12	M12X1.75	700	623	250	500	616	100	55	315	630	190	65	264	6
BJ060-6325-16	16	M16X2	700	623	250	500	616	100	55	315	630	190	65	264	6
BJ060-8030-12	12	M12X1.75	800	793	300	640	786	135	60	400	800	250	50	420	6
BJ060-8030-16	16	M16X2	800	793	300	640	786	135	60	400	800	250	50	420	6
BJ061-4015-12	12	M12X1.75	550	393	150	320	386	55	50	200	400	125	50	126	4
BJ061-4015-16	16	M16X2	550	393	150	320	386	55	50	200	400	125	50	126	4
BJ061-5020-12	12	M12X1.75	650	493	200	400	486	75	50	250	500	150	50	198	6
BJ061-5020-16	16	M16X2	650	493	200	400	486	75	50	250	500	150	50	198	6
BJ061-6325-12	12	M12X1.75	800	623	250	500	616	100	55	315	630	190	65	308	6
BJ061-6325-16	16	M16X2	800	623	250	500	616	100	55	315	630	190	65	308	6

See page 377 for F7 tolerance specifications.

## FOUR-SIDED GRID BLOCKS



The body is made from FC300 cast iron – annealed and precision machined. The alignment bushings are made from SUJ2 steel. The thread inserts are made from SAE-1045 alloy steel and heat treated. MTP hole spacing is 50mm +/-0.02. Includes protection plugs and eyebolts. Each MTP hole is lettered and numbered for addressing holes. See page 377 for MTP hole construction.

Part #	(F7) A mm	A Thread mm	B mm	C mm	+/-0.04 D mm	E mm	F mm	G mm	H mm	J mm	+/-0.04 K mm	+/-0.04 L mm	Number of MTP Holes	No. of Mounting Holes
BJ070-4025-12	12	M12X1.75	450	393	250	320	386	55	50	200	75	125	112	4
BJ070-4025-16	16	M16X2	450	393	250	320	386	55	50	200	75	125	112	4
BJ070-5030-12	12	M12X1.75	550	493	300	400	486	75	50	250	100	150	180	8
BJ070-5030-16	16	M16X2	550	493	300	400	486	75	50	250	100	150	180	8
BJ070-6335-12	12	M12X1.75	700	623	350	500	616	100	55	315	140	190	288	8
BJ070-6335-16	16	M16X2	700	623	350	500	616	100	55	315	140	190	288	8
BJ070-8050-12	12	M12X1.75	800	793	500	640	786	135	60	400	150	200	504	8
BJ070-8050-16	16	M16X2	800	793	500	640	786	135	60	400	150	200	504	8
BJ071-4025-12	12	M12X1.75	550	393	250	320	386	55	50	200	75	125	144	4
BJ071-4025-16	16	M16X2	550	393	250	320	386	55	50	200	75	125	144	4
BJ071-5030-12	12	M12X1.75	650	493	300	400	486	75	50	250	100	150	220	8
BJ071-5030-16	16	M16X2	650	493	300	400	486	75	50	250	100	150	220	8
BJ071-6335-12	12	M12X1.75	800	623	350	500	616	100	55	315	140	190	336	8
BJ071-6335-16	16	M16X2	800	623	350	500	616	100	55	315	140	190	336	8

See page 377 for F7 tolerance specifications.

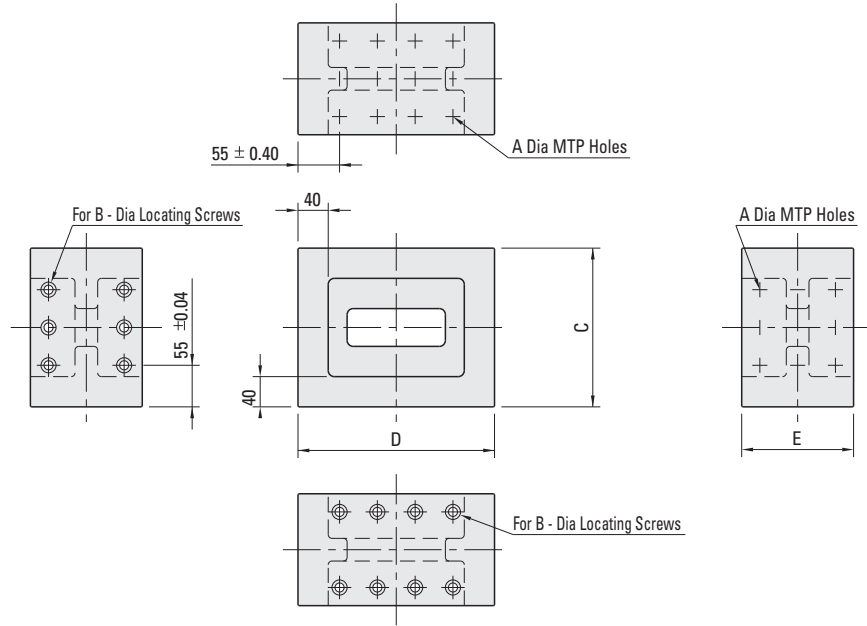
## METAL PROTECTION PLUGS



Used to keep chips and dirt out of unused MTP holes. Made from zinc die cast.

Part #	Thread
BJ770-12001	M12
BJ770-16001	M16

## RISER BLOCKS

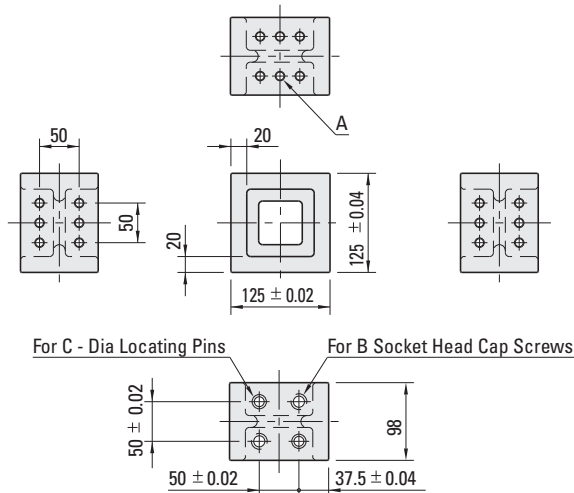


The body is made from FC300 cast iron – annealed and precision ground. The alignment bushings are made from SUJ2 steel. The thread inserts are made from SAE-1045 alloy steel and heat treated. MTP hole spacing is 50mm +/-0.02. Includes protection plugs. Locate on tooling plate or block using BJ700 locating screws. See page 377 for MTP hole construction.

Part #	(F7) A mm	A Thread mm	B mm	+/- .02 C mm	+/- .02 D mm	E mm	Number of MTP Holes	No. of Mounting Holes	Use Locating Screw
BJ090-1621-12	12	M12X1.75	12	160	210	148	15	10	BJ700-12065
BJ090-2126-12	12	M12X1.75	12	210	260	148	21	14	BJ700-12065
BJ090-1621-16	16	M16X2	16	160	210	148	15	10	BJ700-16075
BJ090-2126-16	16	M16X2	16	210	260	148	21	14	BJ700-16075

See page 377 for F7 tolerance specifications.

## COMPACT RISER BLOCKS

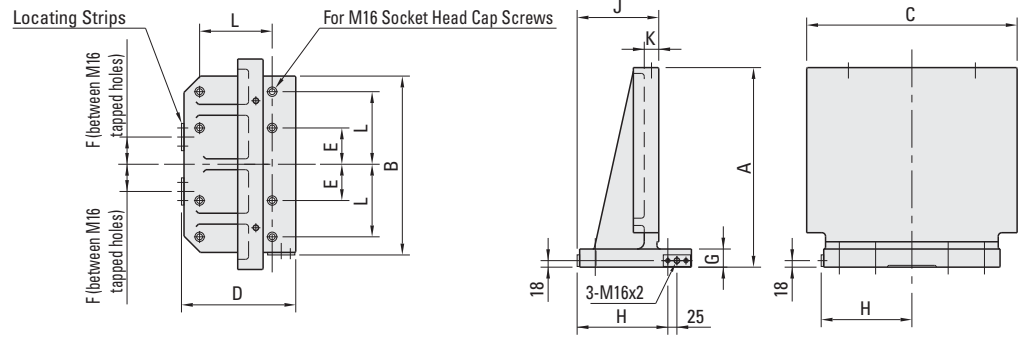


The body is made from FC300 cast iron – annealed and precision ground. The alignment bushings are made from SUJ2 steel. The thread inserts are made from SAE-1045 alloy steel and heat treated. Hole spacing is 50mm +/-0.02.

Part #	A Thread mm	B mm	(F7) C mm
BJ091-12125	M12X1.75	M12	12
BJ091-16125	M16X2	M16	16

See page 377 for F7 tolerance specifications.

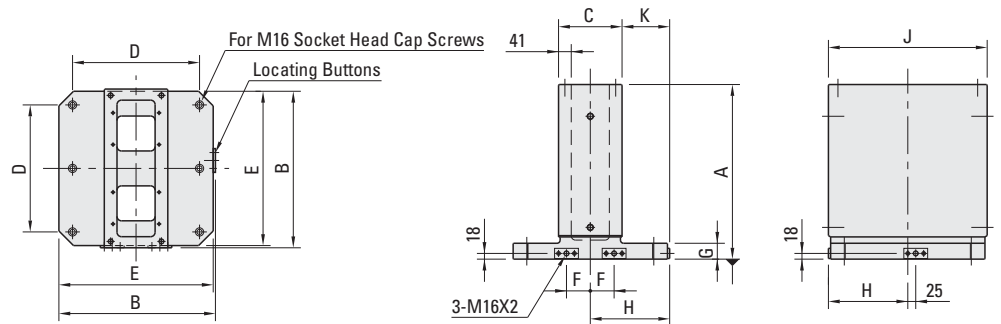
## BLANK ANGLE BLOCKS



The body is made from FC300 cast iron – annealed and semi-finish machined.

Part #	A mm	B mm	C mm	D mm	E mm	F mm	G mm	H mm	+/-2 J mm	K mm	L mm	No. of Mounting Holes
BJ050-4101-00	450	393	470	265	-	55	45	200	176	40	160	4
BJ050-5101-00	550	493	580	315	100	75	50	250	226	40	200	8
BJ050-6101-00	700	623	760	380	125	100	55	315	266	50	250	8
BJ050-8101-00	800	793	900	465	160	135	60	400	351	50	320	8

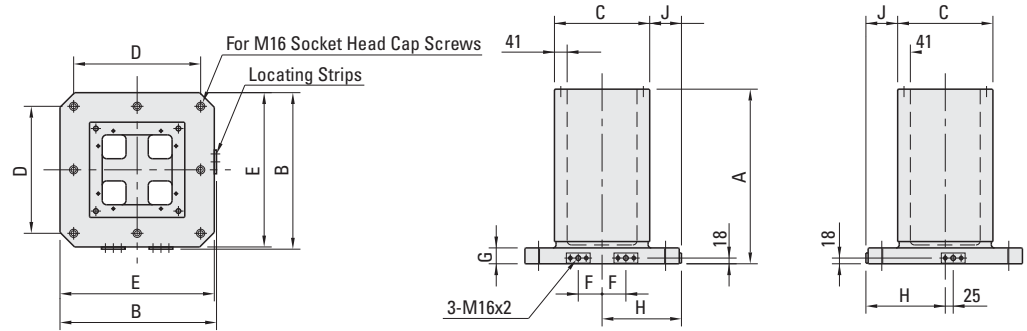
## BLANK TWO SIDED BLOCKS



The body is made from FC300 cast iron – annealed and semi-finish machined.

Part #	A mm	B mm	+/-2 C mm	D mm	E mm	F mm	G mm	H mm	J mm	+/-2 K mm	No. of Mounting Holes
BJ060-4015-00	450	393	151	320	386	55	50	200	400	124.5	4
BJ060-5020-00	550	493	201	400	486	75	50	250	500	149.5	6
BJ060-6325-00	700	623	251	500	616	100	55	315	630	189.5	6
BJ060-8030-00	800	793	301	640	786	135	60	400	800	249.5	6
BJ061-4015-00	550	393	151	320	386	55	50	200	400	124.5	4
BJ061-5020-00	650	493	201	400	486	75	50	250	500	149.5	6
BJ061-6325-00	800	623	251	500	616	100	55	315	630	189.5	6

## BLANK FOUR SIDED BLOCKS



The body is made from FC300 cast iron – annealed and semi-finish machined.

Part #	A mm	B mm	+/-2 C mm	D mm	E mm	F mm	G mm	H mm	+/-2 J mm	No. of Mounting Holes
BJ070-4025-00	450	393	251	320	386	55	50	200	74.5	4
BJ070-5030-00	550	493	301	400	486	75	50	250	99.5	8
BJ070-6335-00	700	623	351	500	616	100	55	315	139.5	8
BJ070-8050-00	800	793	501	640	786	135	60	400	149.5	8
BJ071-4025-00	550	393	251	320	386	55	50	200	74.5	4
BJ071-5030-00	650	493	301	400	486	75	50	250	99.5	8
BJ071-6335-00	800	623	351	500	616	100	55	315	139.5	8

# FLEX FIXTURING SYSTEM

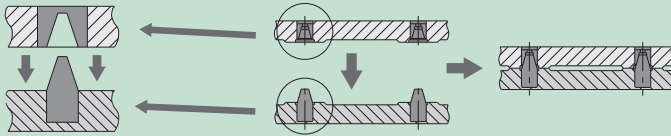
The Flex (Flexible) Quick Change Fixturing System consists of a base plate that can be used with both the fixture plates and angle plates.

## Together this system allows for:

- Fast and Accurate Fixture Changes
- Mounting the Same Fixture on Different Machines
- Machining from Five Sides on One Fixture
- Quick Fixture Setup

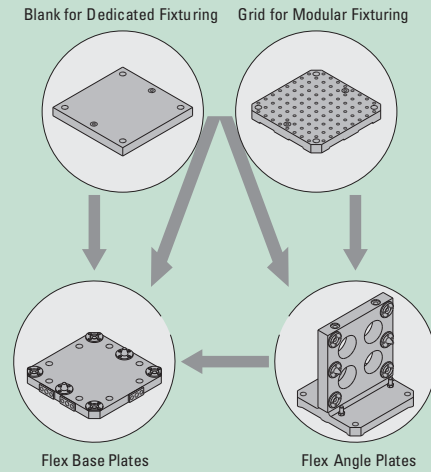
## Repeatability

The two tapered pins on the base plate mate with receiver bushings on the fixture plates or angle plates for highly accurate locating repeatability.



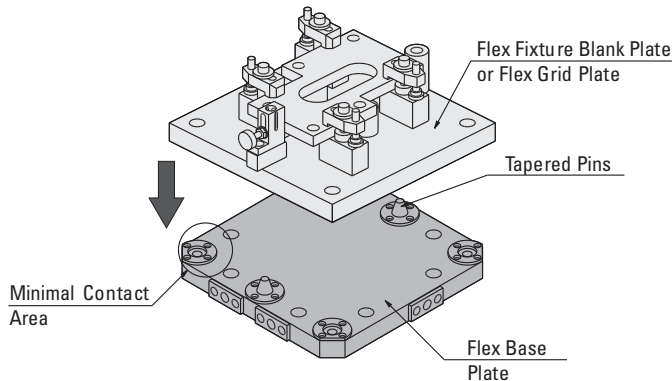
## Flexibility

This system can be used in various configurations to mount the Flex Fixture Plates as shown below.



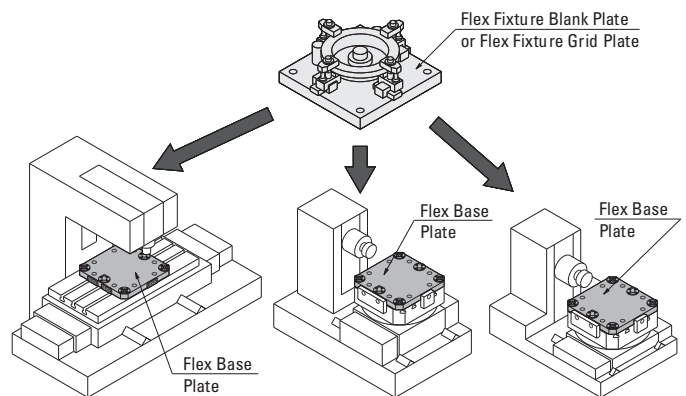
## Fast and Accurate Fixture Changes

The two tapered pins allow simply locating a Flex Fixture Plate or Flex Angle Plate on a Flex Base Plate. These plates sit on the Flex Base Plate with minimal contact area which allows for easy and accurate fixture changes.



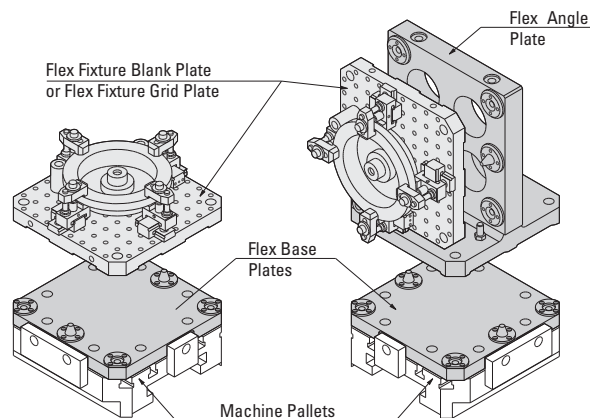
## Mounting the Same Fixture on Different Machines

Once a Flex Base Plate is installed on different machines, the same fixture can then be easily and accurately mounted on any of those machines.



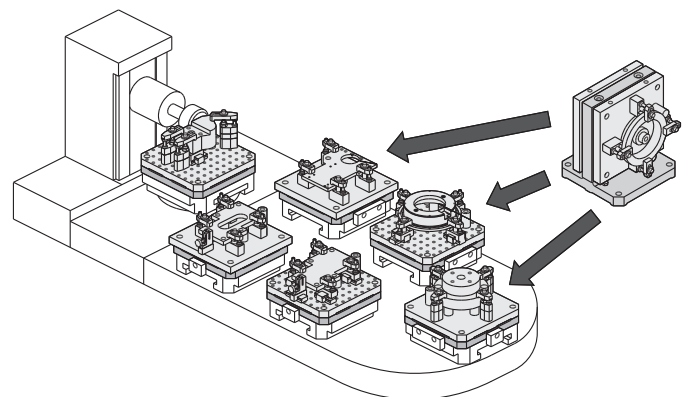
## Machining from Five Sides on One Fixture

Using a Flex Angle Plate with a Flex Base Plate allows mounting the same fixture horizontally and vertically on the same pallet for machining from five sides. Centering is not required when a fixture is turned over.



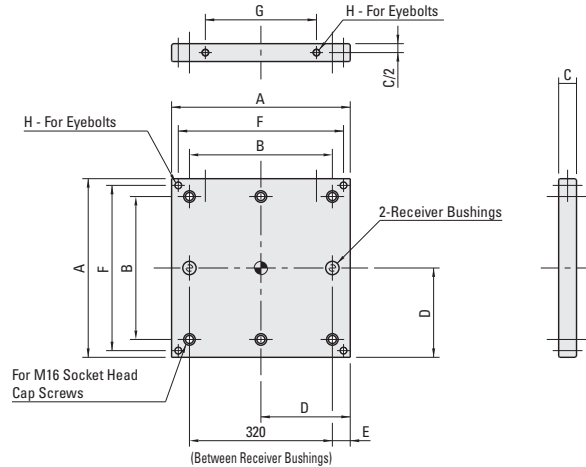
## Quick Fixture Setup

Because there is no need for fixture centering, fixtures can be set up quicker with excellent repeatability.





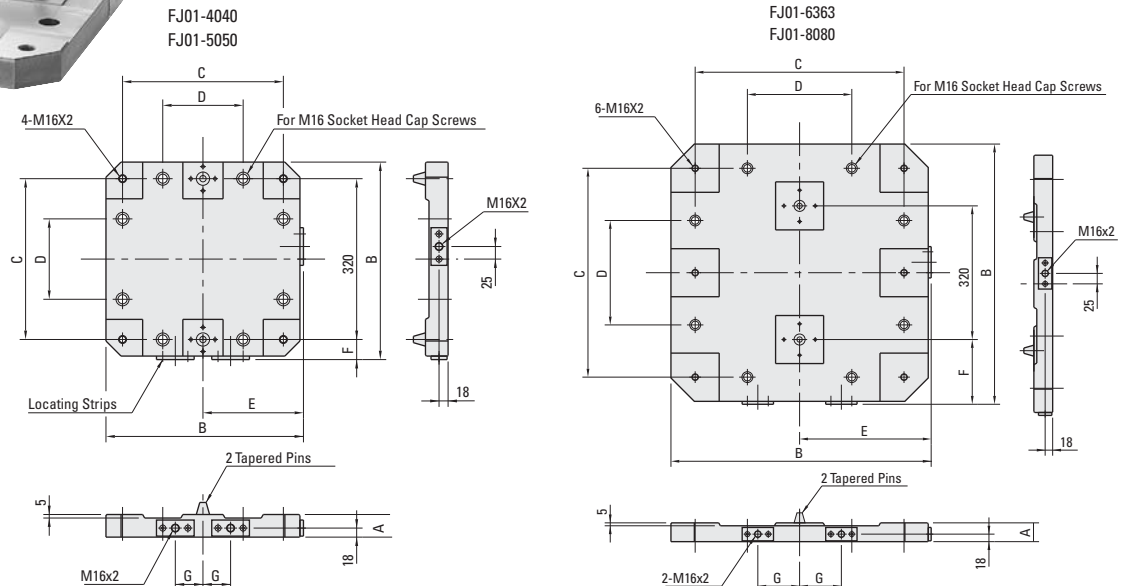
## FLEX BLANK FIXTURE PLATES



Designed for dedicated fixturing that mounts on Flex Base Plates and Flex Angle Plates. Machining references are provided for better machining. The body is made from S50C steel – precision ground. The tapered pins and receiver bushings are made from SAE-1045 alloy steel, precision ground and heat treated. Eyebolts included. It is recommended that the user does not grind the bottom of these plates to preserve the accurate fit of its receiver bushings with the tapered pins of the sub-plate.

Part #	A mm	B mm	+0.30/+0.15 C mm	+/-0.1 D mm	E mm	F mm	G mm	H mm	No. of Mounting Holes
FJ12-4040-00	400	320	40	200	40	370	280	M12X1.75	4
FJ12-5050-00	500	400	40	250	90	460	350	M12X1.75	4
FJ12-6363-00	630	500	40	315	155	540	460	M16X2	6
FJ12-8080-00	800	640	45	400	240	680	570	M16X2	6

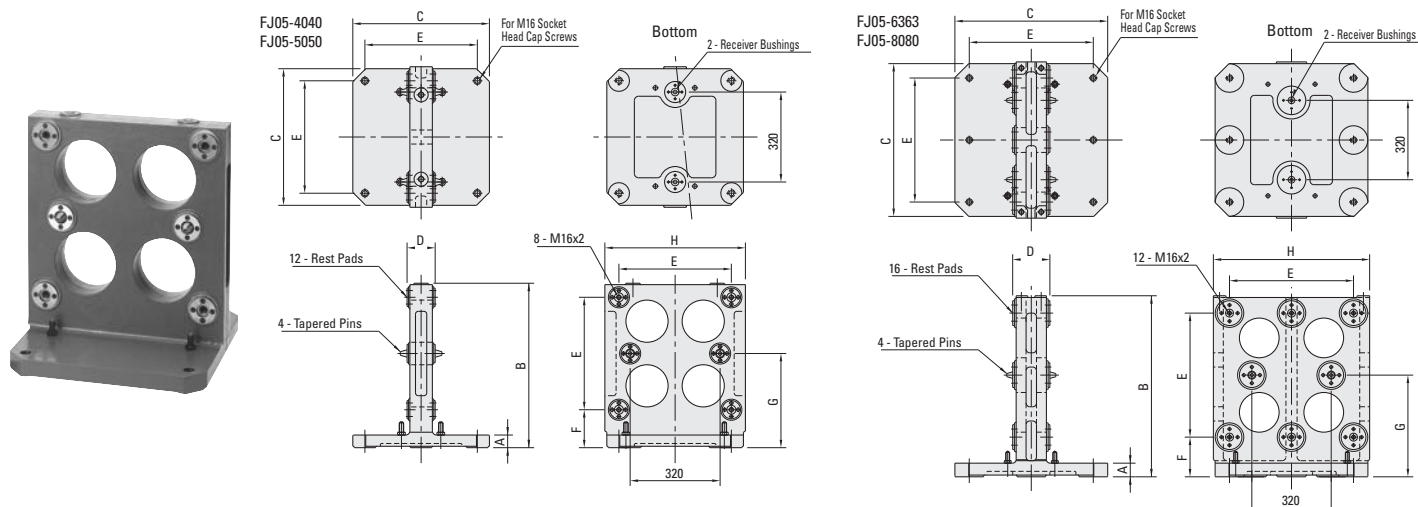
## FLEX BASE PLATES



These Flex Base Plates are designed to mount on the machining center pallet to JIS B 6337 standards. Manufactured from FC250 cast iron – annealed and precision ground. The tapered pins are made from SAE-1095 alloy steel, heat treated and precision ground. Eyebolts are included.

Part #	+/-0.02 A mm	B mm	C mm	D mm	+/-0.04 E mm	+/-0.04 F mm	G mm	No. of Mounting Holes
FJ01-4040N	40	393	320	160	200	40	55	8
FJ01-5050N	40	493	400	200	250	90	75	8
FJ01-6363N	40	623	500	250	315	155	100	8
FJ01-8080N	45	793	640	320	400	240	135	8

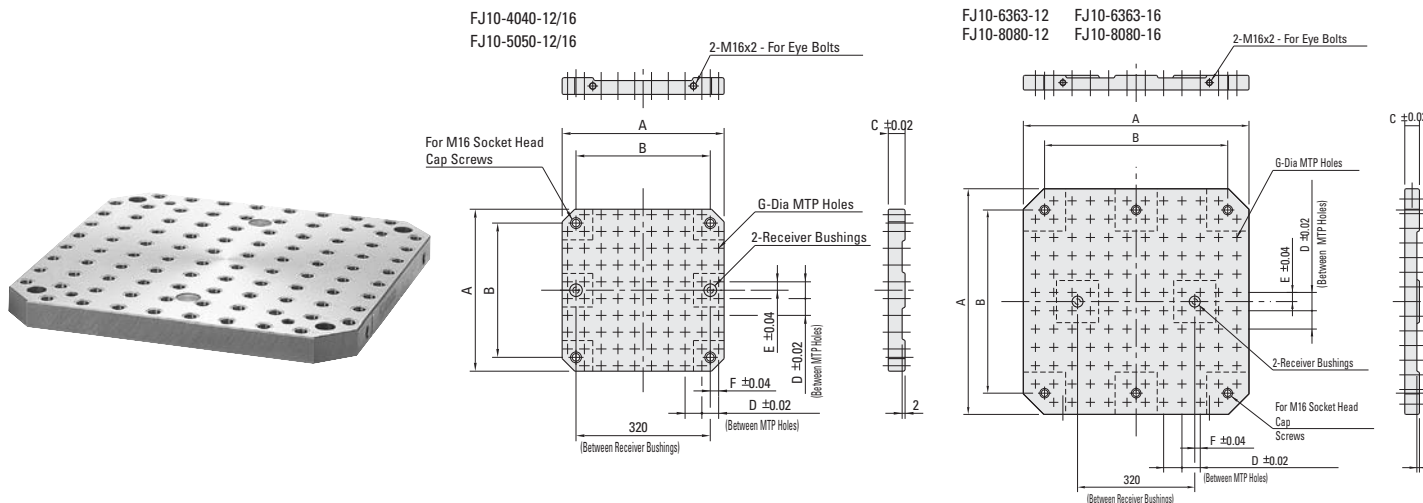
## FLEX ANGLE BASES



Mounts on a Flex Base Plate and accepts Flex Fixture Plates. Made from FC300 cast iron – annealed and precision machined. The rest pads are made from SAE-1045 alloy steel, precision ground and heat treated with black oxide finish. The tapered pins and receiver bushings are made from SAE-1095 alloy steel, heat treated and precision ground. Eyebolts are included.

Part#	A mm	B mm	C mm	+/- .04 D mm	E mm	F mm	+/- .04 G mm	H mm	No. of Mounting Holes
FJ05-4040	40	465	386	80	320	100	260	400	4
FJ05-5050	45	585	486	100	400	135	335	500	4
FJ05-6363	55	730	616	150	500	160	410	630	6
FJ05-8080	60	930	786	200	640	210	530	800	6

## FLEX GRID FIXTURE PLATES

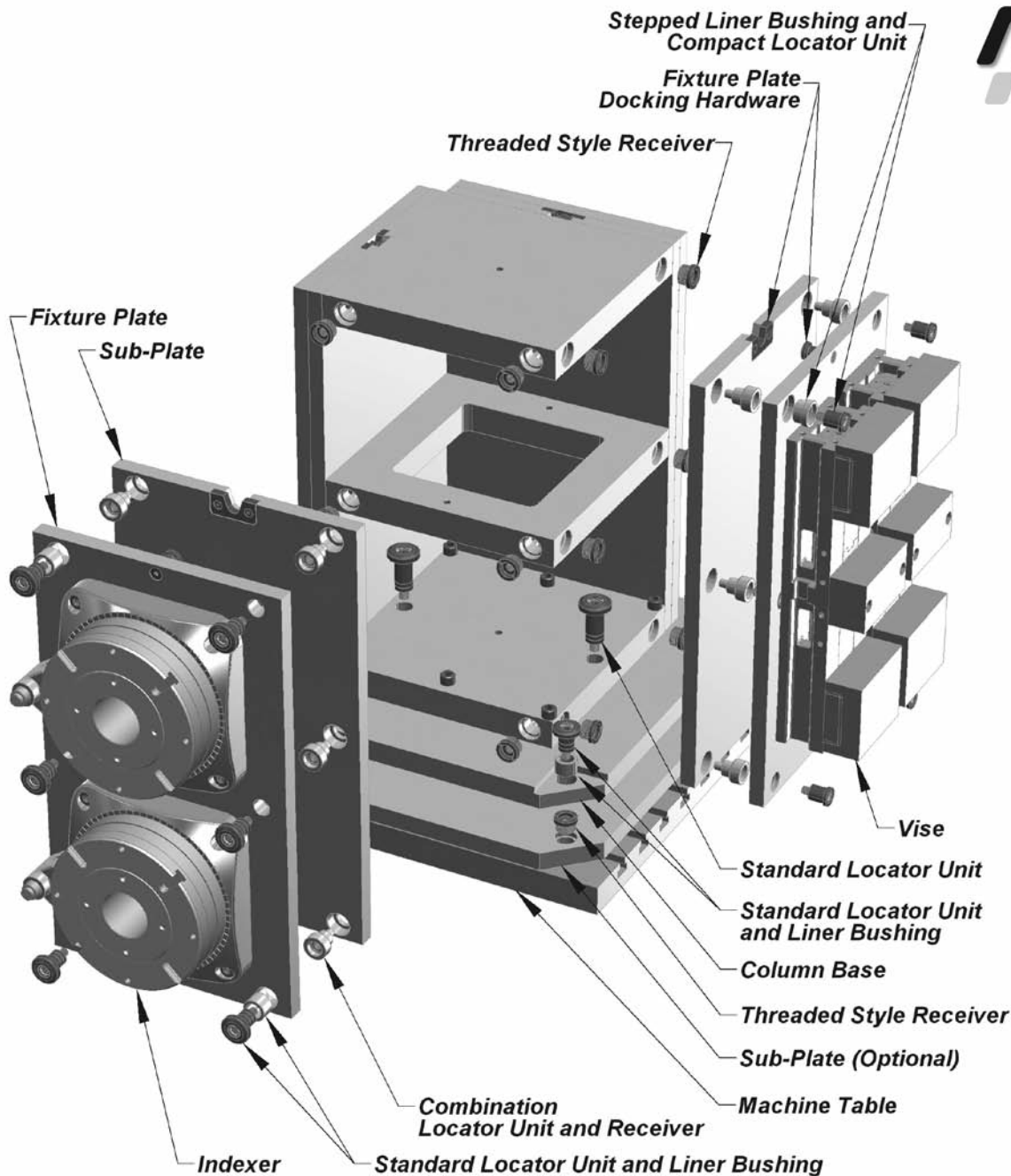


Mounts on Flex Base Plates and Flex Angle Plates. The body is made from FC250 cast iron – annealed and precision ground. The tapered pins and receiver bushings are made from SAE-1045 alloy steel, precision ground and heat treated with black oxide finish. Protection plugs and eyebolts are included. MTP hole spacing is +/- .02mm. Each MTP hole is lettered and numbered for addressing holes. See page 377 for MTP hole construction.

Part#	A mm	B mm	C mm	D mm	E mm	F mm	(F7) G mm	Threads G mm	No. of MTP Holes	No. of Mounting Holes
FJ10-4040-12	386	320	40	50	25	15	12	M12X1.75	60	4
FJ10-4040-16	386	320	40	50	25	15	16	M16X2	60	4
FJ10-5050-12	486	400	40	50	25	15	12	M12X1.75	96	4
FJ10-5050-16	486	400	40	50	25	15	16	M16X2	96	4
FJ10-6363-12	616	500	40	50	25	15	12	M12X1.75	140	6
FJ10-6363-16	616	500	40	50	25	15	16	M16X2	140	6
FJ10-8080-12	786	640	45	50	25	15	12	M12X1.75	240	6
FJ10-8080-16	786	640	45	50	25	15	16	M16X2	240	6

See page 377 for F7 tolerance specifications.

**MODULAR TOOLING COLUMNS**

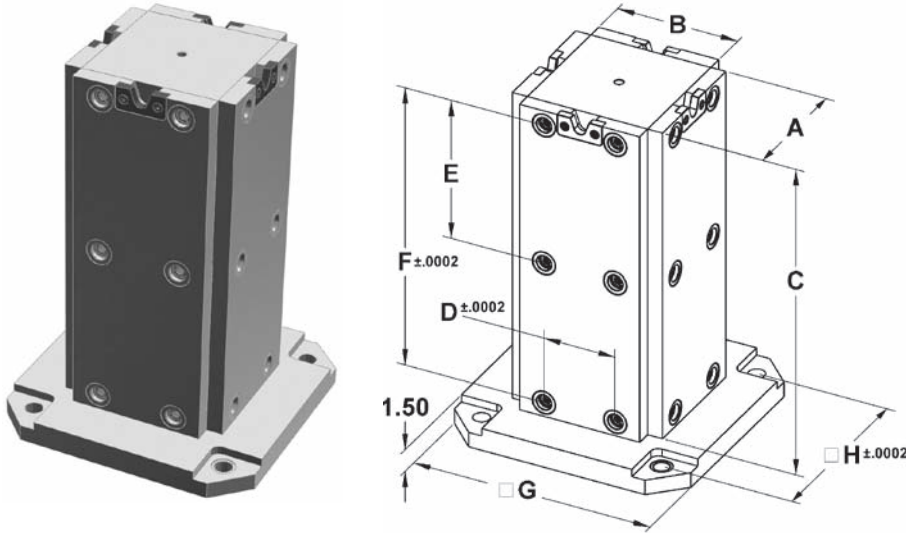


The Mod-Loc Modular Tooling Columns feature a unique design that consists of structural support brackets and sub-plates to form a tooling column that is as rigid and strong as traditional cast tombstones. These tooling columns are easily adapted to a variety of setups to help maximize the use of machining center's functional envelope. Because they are modular in design they permit flexible configurations that fully utilize the speed and accuracy of the SpeedLoc precision mounting and locating system.

The open architecture allows these columns to easily accommodate hydraulic and electrical systems inside the column. This design also reduces the overall weight of the columns. All the tooling columns are supplied with four aluminum or steel sub-plates. Each sub-plate comes with six Speedloc receivers for fast and accurate fastening of fixture plates to the sub-plates. The supplied sub-plates are available in MIC-6 aluminum or A36 steel. All sub-plates are precision ground to a minimum  $\pm .005$ " tolerance. The plates are edge prepped by grinding or milling to  $\pm .005$ ". The part numbers on the following page are supplied with docking plate hardware (MPDH-10001) on each of the four column faces. Tooling columns without docking plates are available by request. The bases are made from A36 steel.

Part numbers on the following page ending with SL are supplied with four base mounting holes as shown on the drawing. Two holes are supplied with precision liners to be used with the SpeedLoc mounting system. Part numbers ending with XX designate user specified base mounting hole spacing. The following pages show just some of the sizes and options available. Fixtureworks can assist you to customize any of these products to meet your exact needs.

# MODULAR TOOLING SQUARE COLUMNS



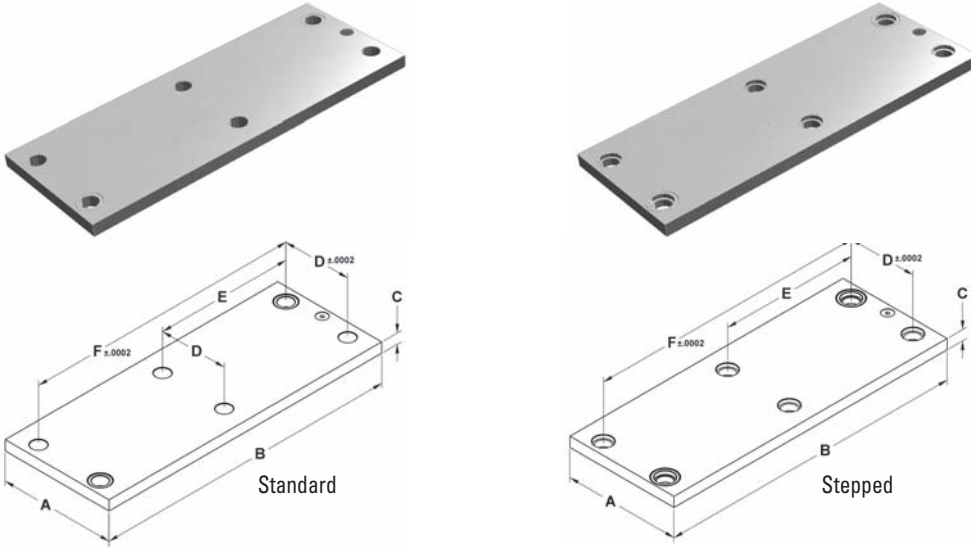
## Aluminum

Part #	Face Size A	Face Size B	Height C	Hole Spacing D	Hole Spacing E	Hole Spacing F	Base Size G mm	Hole Spacing H	Receiver Size mm	Weight Lbs.
MPCA-080821-400SL	8.00	8.00	21.00	4.75	9.50	19.05	400	12.00	25	145
MPCA-080821-400XX	8.00	8.00	21.00	4.75	9.50	19.05	400	—	25	145
MPCA-080821-500SL	8.00	8.00	21.00	4.75	9.50	19.05	500	16.00	25	165
MPCA-080821-500XX	8.00	8.00	21.00	4.75	9.50	19.05	500	—	25	165
MPCA-080821-630SL	8.00	8.00	21.00	4.75	9.50	19.05	630	20.00	25	215
MPCA-080821-630XX	8.00	8.00	21.00	4.75	9.50	19.05	630	—	25	215
MPCA-101024-400SL	10.00	10.00	24.00	6.75	11.00	22.05	400	12.00	25	195
MPCA-101024-400XX	10.00	10.00	24.00	6.75	11.00	22.05	400	—	25	195
MPCA-101024-500SL	10.00	10.00	24.00	6.75	11.00	22.05	500	16.00	25	215
MPCA-101024-500XX	10.00	10.00	24.00	6.75	11.00	22.05	500	—	25	215
MPCA-101024-630SL	10.00	10.00	24.00	6.75	11.00	22.05	630	20.00	25	265
MPCA-101024-630XX	10.00	10.00	24.00	6.75	11.00	22.05	630	—	25	265
MPCA-121224-500SL	12.00	12.00	24.00	8.75	11.00	22.05	500	16.00	25	250
MPCA-121224-500XX	12.00	12.00	24.00	8.75	11.00	22.05	500	—	25	250
MPCA-121224-630SL	12.00	12.00	24.00	8.75	11.00	22.05	630	20.00	25	280
MPCA-121224-630XX	12.00	12.00	24.00	8.75	11.00	22.05	630	—	25	280
MPCA-161628-630SL	16.00	16.00	28.00	12.75	13.00	26.05	630	20.00	25	425
MPCA-161628-630XX	16.00	16.00	28.00	12.75	13.00	26.05	630	—	25	425

## Steel

Part #	Face Size A	Face Size B	Height C	Hole Spacing D	Hole Spacing E	Hole Spacing F	Base Size G mm	Hole Spacing H	Receiver Size mm	Weight Lbs.
MPCS-080821-400SL	8.00	8.00	21.00	4.75	9.50	19.05	400	12.00	25	385
MPCS-080821-400XX	8.00	8.00	21.00	4.75	9.50	19.05	400	—	25	385
MPCS-080821-500SL	8.00	8.00	21.00	4.75	9.50	19.05	500	16.00	25	440
MPCS-080821-500XX	8.00	8.00	21.00	4.75	9.50	19.05	500	—	25	440
MPCS-080821-630SL	8.00	8.00	21.00	4.75	9.50	19.05	630	20.00	25	535
MPCS-080821-630XX	8.00	8.00	21.00	4.75	9.50	19.05	630	—	25	535
MPCS-101024-400SL	10.00	10.00	24.00	6.75	11.00	22.05	400	12.00	25	515
MPCS-101024-400XX	10.00	10.00	24.00	6.75	11.00	22.05	400	—	25	515
MPCS-101024-500SL	10.00	10.00	24.00	6.75	11.00	22.05	500	16.00	25	575
MPCS-101024-500XX	10.00	10.00	24.00	6.75	11.00	22.05	500	—	25	575
MPCS-101024-630SL	10.00	10.00	24.00	6.75	11.00	22.05	630	20.00	25	670
MPCS-101024-630XX	10.00	10.00	24.00	6.75	11.00	22.05	630	—	25	670
MPCS-121224-500SL	12.00	12.00	24.00	8.75	11.00	22.05	500	16.00	25	685
MPCS-121224-500XX	12.00	12.00	24.00	8.75	11.00	22.05	500	—	25	685
MPCS-121224-630SL	12.00	12.00	24.00	8.75	11.00	22.05	630	20.00	25	780
MPCS-121224-630XX	12.00	12.00	24.00	8.75	11.00	22.05	630	—	25	780
MPCS-161628-630SL	16.00	16.00	28.00	12.75	13.00	26.05	630	20.00	25	1,135
MPCS-161628-630XX	16.00	16.00	28.00	12.75	13.00	26.05	630	—	25	1,135

## MODULAR TOOLING COLUMN FIXTURE PLATES



These pre-machined fixture plates allow for fast and accurate fixture assembly and setup using SpeedLoc locators. They are designed for precise fit with the ModLoc tooling columns and will also work with any machine configuration requiring a fixture plate. Each plate includes six pre-drilled holes for locating and fastening with the SpeedLoc locators to the ModLoc tooling column sub-plates (Two holes are lined with bushings for precise locating). The fixture plates are available with either standard or stepped liners. Thickness tolerance is a minimum  $\pm .005"$ . The aluminum sub-plates are made from MIC-6 aluminum. The steel sub-plates are made from A36 steel. These fixture plates can be supplied with positioning studs installed for use with the docking hardware. The parts below show just some of the sizes and options available. Fixtureworks can assist you to customize any of these products to meet your exact needs.

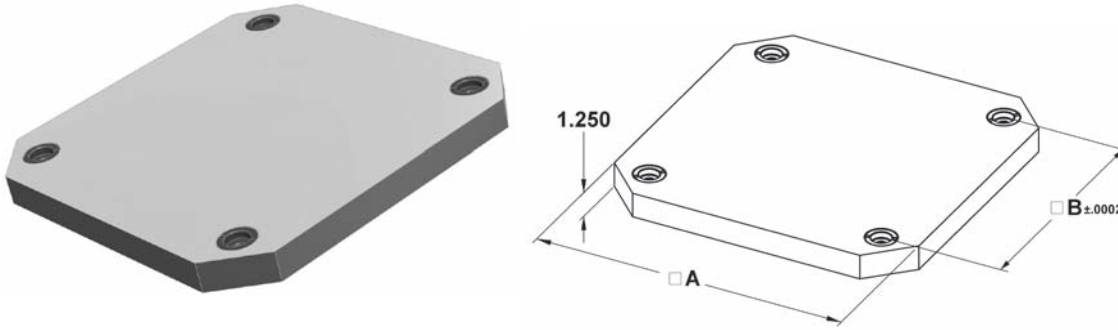
### Aluminum

Standard Liner Part #	Stepped Liner Part #	Width A	Length B	Thickness C	Hole Spacing D	Hole Spacing E	Hole Spacing F	Liner Size mm	Weight Lbs.
MPFPA-0821075-SL	MPFPA-0821075-CH	8.00	21.00	.75	4.75	9.50	19.05	25	12
MPFPA-0821100-SL	MPFPA-0821100-CH	8.00	21.00	1.00	4.75	9.50	19.05	25	16
MPFPA-1024075-SL	MPFPA-1024075-CH	10.00	24.00	.75	6.75	11.00	22.05	25	17
MPFPA-1024100-SL	MPFPA-1024100-CH	10.00	24.00	1.00	6.75	11.00	22.05	25	23
MPFPA-1224075-SL	MPFPA-1224075-CH	12.00	24.00	.75	8.75	11.00	22.05	25	21
MPFPA-1224100-SL	MPFPA-1224100-CH	12.00	24.00	1.00	8.75	11.00	22.05	25	27
MPFPA-1628075-SL	MPFPA-1628075-CH	16.00	28.00	.75	12.75	13.00	26.05	25	32
MPFPA-1628100-SL	MPFPA-1628100-CH	16.00	28.00	1.00	12.75	13.00	26.05	25	42

### Steel

Standard Liner Part #	Stepped Liner Part #	Width A	Length B	Thickness C	Hole Spacing D	Hole Spacing E	Hole Spacing F	Liner Size mm	Weight Lbs.
MPFPS-0821075-SL	MPFPS-0821075-CH	8.00	21.00	.75	4.75	9.50	19.05	25	36
MPFPS-0821100-SL	MPFPS-0821100-CH	8.00	21.00	1.00	4.75	9.50	19.05	25	48
MPFPS-1024075-SL	MPFPS-1024075-CH	10.00	24.00	.75	6.75	11.00	22.05	25	51
MPFPS-1024100-SL	MPFPS-1024100-CH	10.00	24.00	1.00	6.75	11.00	22.05	25	68
MPFPS-1224075-SL	MPFPS-1224075-CH	12.00	24.00	.75	8.75	11.00	22.05	25	62
MPFPS-1224100-SL	MPFPS-1224100-CH	12.00	24.00	1.00	8.75	11.00	22.05	25	82
MPFPS-1628075-SL	MPFPS-1628075-CH	16.00	28.00	.75	12.75	13.00	26.05	25	96
MPFPS-1628100-SL	MPFPS-1628100-CH	16.00	28.00	1.00	12.75	13.00	26.05	25	127

**MODULAR TOOLING COLUMN SUB-PLATES**



These machined column sub-plates attach to the machine table to allow for fast and accurate removal/fastening of the tooling columns. They are supplied with four Speedloc receivers so the user can utilize Speedloc locators to quickly and accurately attach the tooling column or fixture plate. The aluminum sub-plates are made from MIC-6 aluminum. The steel sub-plates are made from A36 steel. Hard anodized finish on the aluminum sub-plates is available by request. The 500 and 630mm plates can be supplied with additional hole configurations on the same plate to fit multiple column sizes on the same sub-plate. The part numbers ending with XX designate the user must specify the required mounting hole spacing. Parts without the XX are supplied without mounting holes. The following part numbers show just some of the sizes and options available. Fixtureworks can assist you to customize any of these products to meet your exact needs.

**Aluminum**

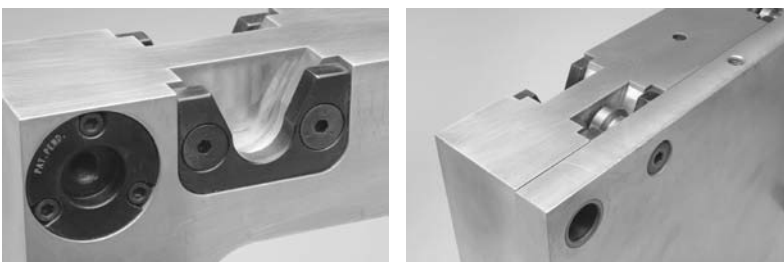
Part #	Width A mm	Receiver Hole Spacing B	Receiver Size mm	Weight Lbs.
MPSPA-400	400	12.00	25	29
MPSPA-400XX	400	12.00	25	29
MPSPA-500	500	16.00	25	45
MPSPA-500XX	500	16.00	25	45
MPSPA-630	630	20.00	25	72
MPSPA-630XX	630	20.00	25	72

**Steel**

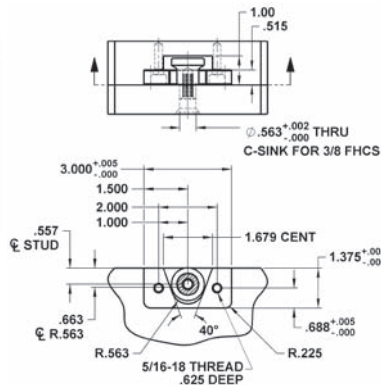
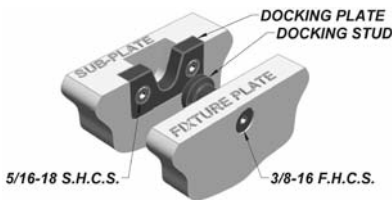
Part #	Width A mm	Receiver Hole Spacing B	Receiver Size mm	Weight Lbs.
MPSPS-400	400	12.00	25	88
MPSPS-400XX	400	12.00	25	88
MPSPS-500	500	16.00	25	137
MPSPS-500XX	500	16.00	25	137
MPSPS-630	630	20.00	25	218
MPSPS-630XX	630	20.00	25	218

**PRECISION LOCATING & MOUNTING SYSTEM**

**Docking Hardware**



Docking hardware allows a user to position a fixture plate, before fastening the surfaces together with SpeedLoc locators. This allows for faster set ups and eliminates the need for additional personnel or lifting aids to mount fixture plates. The docking hardware consists of two parts: The docking plate and docking stud. The docking hardware can be installed on any conventional tooling column. The docking plate is installed into the top of a tooling column and mates with the positioning studs mounted to the fixture plate. Made from alloy steel with black oxide finish.



Part #	Description
MPDH-10001	Plate with Fasteners
MPDH-10003	Positioning Stud with Fasteners – For 1" Plate
MPDH-10007	Positioning Stud with Fasteners – For 3/4" Plate