

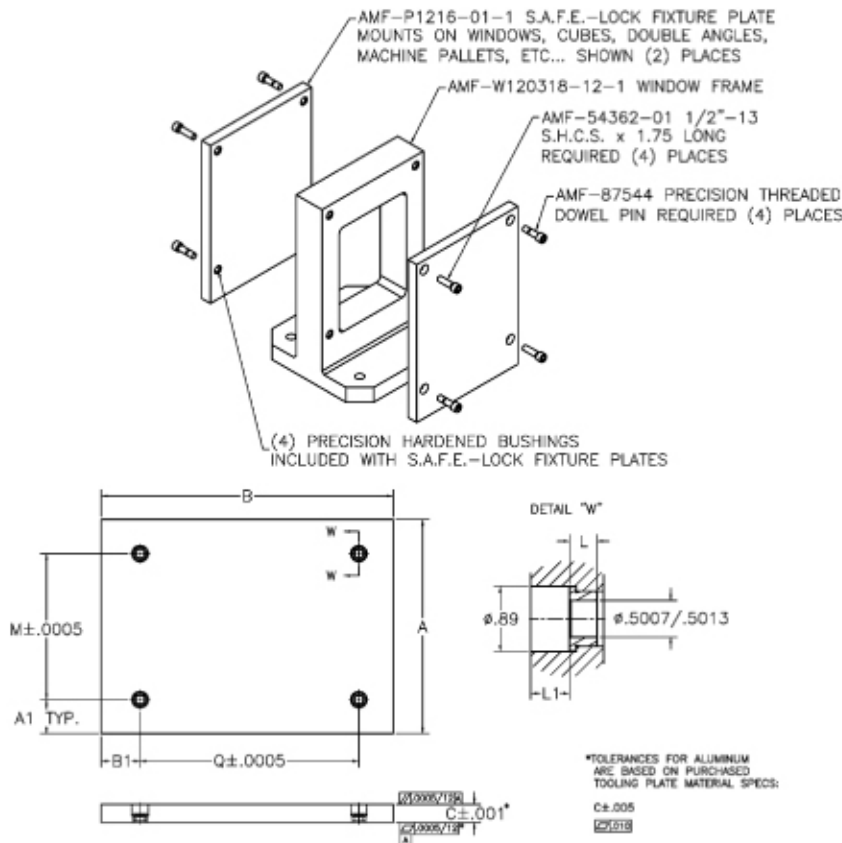
PRECISION GRID BASES

Fixture Plates

Fixture Plates with S.A.F.E.-LOCK System

These precision fixture plates will mount on any of our grid bases and are not limited to use with the example mating tombstones shown below (cubes, double angles, single angles, etc.). Mounting horizontally or vertically for quick-change dedicated machining, they locate accurately by using any Two of the Four precision hardened bushing holes with our precision dowel screws (AMF-87544). Please specify material when ordering (steel, aluminum, or cast iron).

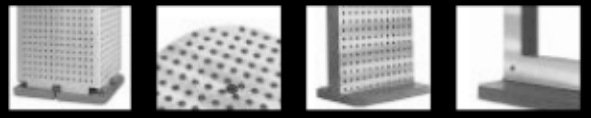
Custom sizes are available upon request.



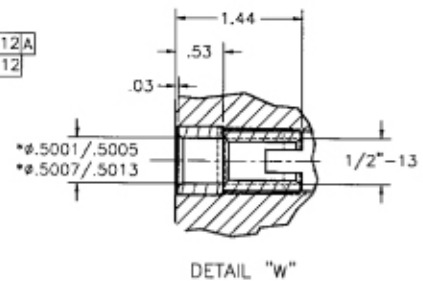
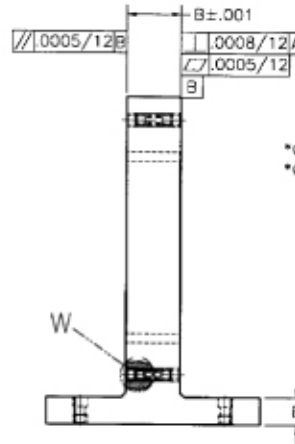
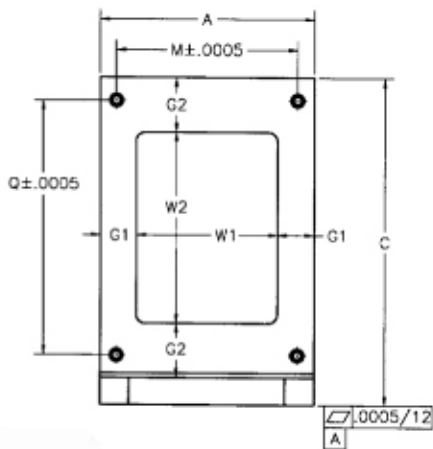
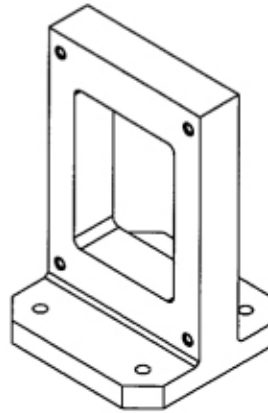
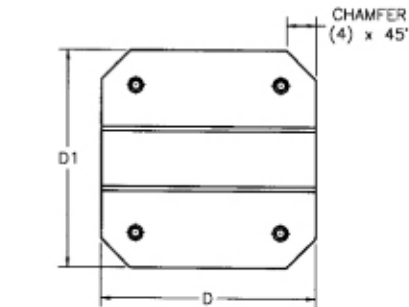
Nominal Size	Dimensions (in.)									Aluminum Weight (lbs)	Cast Iron Weight (lbs)	Steel Weight (lbs)	Plate Part# AMF-	Example Mating Tombstone Part# AMF-
	A	M	A1 Typ.	B	Q	B1	C	L	L1					
12 x 16	11.75	10.0000	0.88	15.90	12.0000	1.95	1	0.38	0.53	18	48	52	P1216-01-1	W120318-12-1
16 x 22	15.70	12.0000	1.85	21.90	18.0000	1.95	1	0.38	0.53	34	90	97	P1622-01-1	W160324-16-1
20 x 25	19.60	14.0000	2.80	25.00	20.0000	2.5	1	0.38	0.53	49	128	138	P2025-01-1	W200428-20-1
25 x 29	24.50	18.0000	3.25	29.00	24.0000	2.5	1.25	0.5	0.69	89	231	250	P2529-01-1	W250532-25-1
31 x 37	31.00	26.0000	2.50	37.00	32.0000	2.5	1.25	0.5	0.69	143	373	403	P3137-01-1	W320840-32-1
6 x 18	5.90	4.0000	0.95	17.90	14.0000	1.95	1	0.38	0.53	11	28	30	P0618-01-1	C060620-12-1
8 x 8	7.90	6.0000	0.95	7.90	6.0000	0.95	1	0.38	0.53	6	17	18	P0808-01-1	C101018-16-1
8 x 20	7.90	4.0000	1.95	19.50	16.0000	1.75	1	0.38	0.53	16	41	44	P0820-01-1	C080822-16-1
10 x 10	9.90	8.0000	0.95	9.90	8.0000	0.95	1	0.38	0.53	10	26	28	P1010-01-1	C121213-20-1
10 x 20	9.90	6.0000	1.95	19.90	14.0000	2.95	1	0.38	0.53	20	51	55	P1020-01-1	C101024-16-1
12 x 12	11.90	8.0000	1.95	11.90	8.0000	1.95	1	0.38	0.53	14	37	40	P1212-01-1	C121218-16-1
12 x 24	11.90	8.0000	1.95	23.90	20.0000	1.95	1	0.38	0.53	28	74	80	P1224-01-1	C121228-20-1
14 x 26	13.90	10.0000	1.95	25.90	22.0000	1.95	1	0.38	0.53	36	93	101	P1426-01-1	C141428-20-1
16 x 16	15.90	12.0000	1.95	15.90	12.0000	1.95	1	0.38	0.53	25	66	71	P1616-01-1	C161624-25-1
16 x 26	15.90	12.0000	1.95	25.90	22.0000	1.95	1	0.38	0.53	41	107	116	P1626-01-1	S1630-18-1
18 x 18	17.90	14.0000	1.95	17.90	12.0000	2.95	1	0.38	0.53	32	83	90	P1818-01-1	D180424-16-1
20 x 20	19.90	16.0000	1.95	19.90	14.0000	2.95	1	0.38	0.53	39	103	111	P2020-01-1	C202024-25-1
20 x 22	19.50	16.0000	1.75	21.50	14.0000	3.75	1	0.38	0.53	43	113	122	P2022-01-1	D200624-20-1
25 x 26	24.50	20.0000	2.25	25.90	22.0000	1.95	1.25	0.5	0.69	65	168	182	P2526-01-1	D250629-25-1

See AMROK® Tombstone catalog for more sizes.

PRECISION GRID BASES



Window Frames

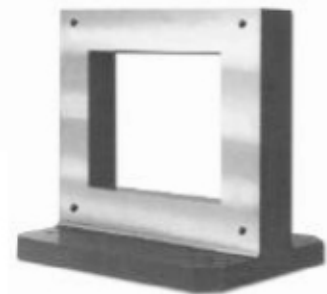


DETAILS:

G (UNC)	dia. D *	L	L ₁
1/2 - 13	.5001/.5005	.53	1.44
1/2 - 13	.5007/.5013	.53	1.44

Custom grid bases are available upon request.

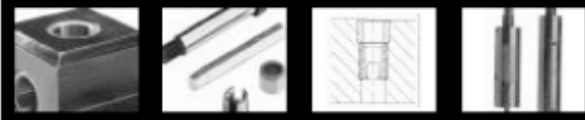
* Specify bushing I.D. used for system.



Note: Geometric tolerances shown are Class I. Please specify Class I or Class II and cast iron or aluminum. Refer to page 16.

Dimensions (in.)											Chamfer (4) x 45°	Cast Iron Weight (lbs)	Alum. Weight (lbs)	Window Part Number AMF-	Mating Plate Part Number AMF-
A	B	C	D sq. or D x D1	E	M	Q	W1	W2	G1	G2					
11.81	3	18	300 mm	1.5	10	12	7.8	10.5	2	3	1.60	143	55	W120318-12-1	P1216-01-1
15.75	3	24	400 mm	1.5	12	18	9.75	14.5	3	4	2.00	267	103	W160324-16-1	P1622-01-1
15.75	4	24	400 mm	1.5	12	18	9.75	14.5	3	4	2.00	323	124	W160424-16-1	P1622-01-1
19.68	4	28	500 mm	2	14	20	11.68	16	4	5	2.35	540	208	W200428-20-1	P2025-01-1
19.68	5	28	500 mm	2	14	20	11.68	16	4	5	2.35	624	240	W200528-20-1	P2025-01-1
24.80	5	32	630 mm	2	18	24	14.8	18	5	6	2.75	941	362	W250532-25-1	P2529-01-1
24.80	6	32	630 mm	2	18	24	14.8	18	5	6	2.75	1065	410	W250632-25-1	P2529-01-1
31.5	8	40	800 mm	2	26	32	15.5	22	8	8	3.00	2100	809	W320840-32-1	P3137-01-1

See AMROK® Tombstone catalog for more sizes.

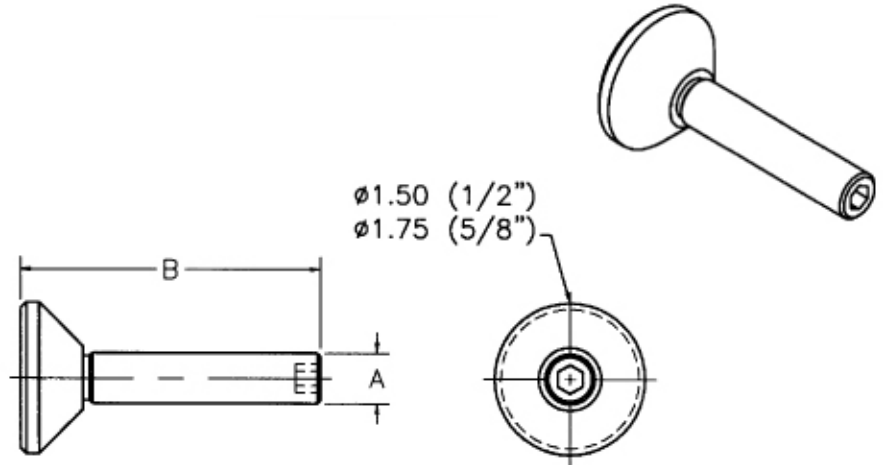


STANDARD ACCESSORIES

Heel Rests

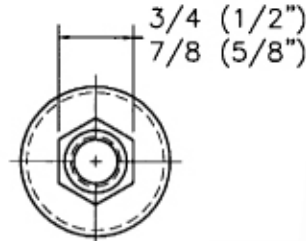
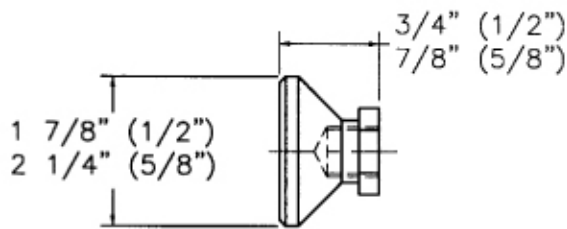
- For use with clamps with tapped through holes

HEEL RESTS		
Dimensions (In)		Part # AMF-
A	B	
1/2"-13	3	59575
1/2"-13	4	59576
1/2"-13	5	59577
5/8"-11	4	59578
5/8"-11	5	59579
5/8"-11	6	59580



Leveling Rest Pads

- For use with clamping screws

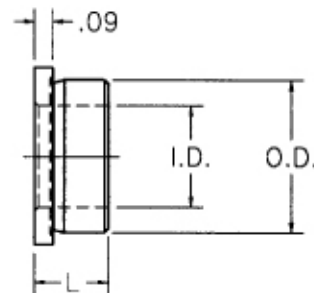
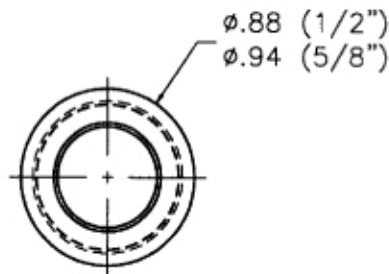


AMF-59677 (1/2"-13)
AMF-59678 (5/8"-11)

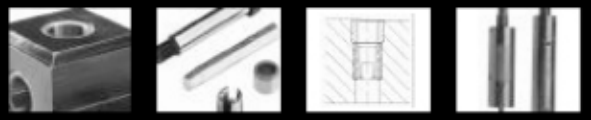
Head Liner Bushings

- Hardened
- Precision I.D. and concentric precision O.D. within .0001
- Field replaceable without reworking bored hole.
- Used with fixture plates
- Great for lining precision bores on plates as thin as 1"
- The length listed refers to the overall length, not its length under the head

HEAD LINER BUSHINGS			
Dimensions (In)			Part # AMF-
∅ I.D.	∅ O.D.	L	
∅.5001/.5005	∅.7516/.7518	.38	59660
∅.5001/.5005	∅.7516/.7518	.50	59662
∅.5007/.5013	∅.7516/.7518	.38	59661
∅.5007/.5013	∅.7516/.7518	.50	59663
∅.6251/.6255	∅.8768/.8770	.50	59679
∅.6257/.6263	∅.8768/.8770	.50	59680



STANDARD ACCESSORIES

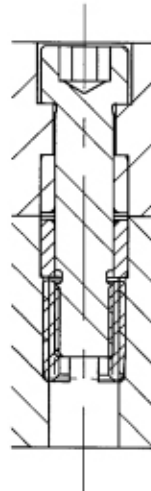
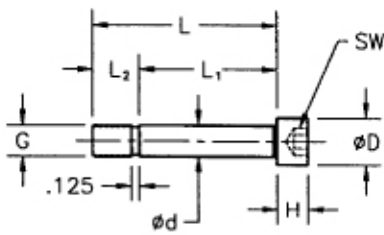


Threaded Dowel Pins



For positioning and clamping of S.A.F.E. units and universal fixture elements on grid bases, hardened and ground precision screws are used. These screws are also useful for locating fixture plates.

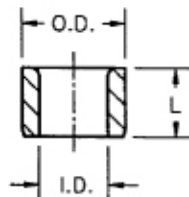
- Black oxide finish
- Precision Shoulder (+.0000/-.0005)
- Accurate height
- Provides optimum utilization of AMFLEX® high precision components



THREADED DOWEL PINS								
G (UNC)	D (in)	d (in)	L (in)	L1 (in)	L2 (in)	H (in)	SW	Part Number AMF-
1/2-13	0.75	0.50	1.469	0.719	0.75	0.50	3/8	87543
1/2-13	0.75	0.50	1.719	0.969	0.75	0.50	3/8	87544
1/2-13	0.75	0.50	1.953	1.203	0.75	0.50	3/8	87970
1/2-13	0.75	0.50	2.070	1.320	0.75	0.50	3/8	87991
1/2-13	0.75	0.50	2.187	1.437	0.75	0.50	3/8	87992
1/2-13	0.75	0.50	2.305	1.555	0.75	0.50	3/8	87993
1/2-13	0.75	0.50	2.422	1.672	0.75	0.50	3/8	87994
1/2-13	0.75	0.50	2.539	1.789	0.75	0.50	3/8	87995
1/2-13	0.75	0.50	2.646	1.906	0.75	0.50	3/8	87996
1/2-13	0.75	0.50	2.773	2.023	0.75	0.50	3/8	87997
1/2-13	0.75	0.50	2.891	2.141	0.75	0.50	3/8	87998
1/2-13	0.75	0.50	3.000	2.250	0.75	0.50	3/8	87983
1/2-13	0.75	0.50	3.150	2.400	0.75	0.50	3/8	87985
1/2-13	0.75	0.50	3.400	2.650	0.75	0.50	3/8	87986
1/2-13	0.75	0.50	3.650	2.900	0.75	0.50	3/8	87987
1/2-13	0.75	0.50	3.750	3.000	0.75	0.50	3/8	87984
1/2-13	0.75	0.50	3.900	3.150	0.75	0.50	3/8	87988
1/2-13	0.75	0.50	4.150	3.400	0.75	0.50	3/8	87989
1/2-13	0.75	0.50	5.000	4.250	0.75	0.50	3/8	59505
1/2-13	0.75	0.50	5.500	4.750	0.75	0.50	3/8	59506
5/8-11	0.94	0.625	2.016	1.078	0.937	0.625	1/2	87887
5/8-11	0.94	0.625	2.266	1.328	0.937	0.625	1/2	87886
5/8-11	0.94	0.625	2.375	1.437	0.937	0.625	1/2	87885
5/8-11	0.94	0.625	2.750	1.812	0.937	0.625	1/2	87884
5/8-11	0.94	0.625	2.828	1.891	0.937	0.625	1/2	87883
5/8-11	0.94	0.625	3.312	2.375	0.937	0.625	1/2	87882

Dimensions (In)			Part # AMF-
I.D.	O.D.	L	
Ø.5001/.5005	Ø.7516/.7518	.50	80991
Ø.5001/.5005	Ø.7887/.7889	.50	80992
Ø.5001/.5005	Ø.8261/.8263	.50	80953
Ø.5007/.5013	Ø.7516/.7518	.50	80995
Ø.5007/.5013	Ø.7887/.7889	.50	80992-01
Ø.5007/.5013	Ø.8261/.8263	.50	80953-01
Ø.6251/.6255	Ø.8768/.8770	.75	80989
Ø.6251/.6255	Ø.9053/.9055	.75	80990
Ø.6251/.6255	Ø.9254/.9256	.75	80952
Ø.6257/.6263	Ø.8768/.8770	.75	80989-02
Ø.6257/.6263	Ø.9053/.9055	.75	80990-01
Ø.6257/.6263	Ø.9254/.9256	.75	80952-01

Bushings



- Hardened (60 HRC)
- Precision I.D. and concentric precision O.D. (.0001)
- Field replaceable without reworking bored hole



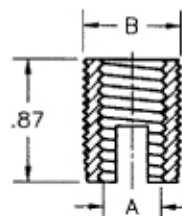
AMF-80991 (Shown above)

Threaded Inserts



AMF-87321 (Shown above)

- Case hardened (60 HRC)
- Clear chromate coated
- High pull-out strength
- Strong wear resistant threads
- Vibration resistant
- Fast easy installation
- Field replaceable without reworking tapped hole.



Dimensions (In)		Part # AMF-
A (Thread)	B (Thread)	
1/2"-13	M18 x 1.5	87321
1/2"-13	M20 x 1.5	87787
5/8"-11	M20 x 1.5	87293
5/8"-11	M22 x 1.5	87788