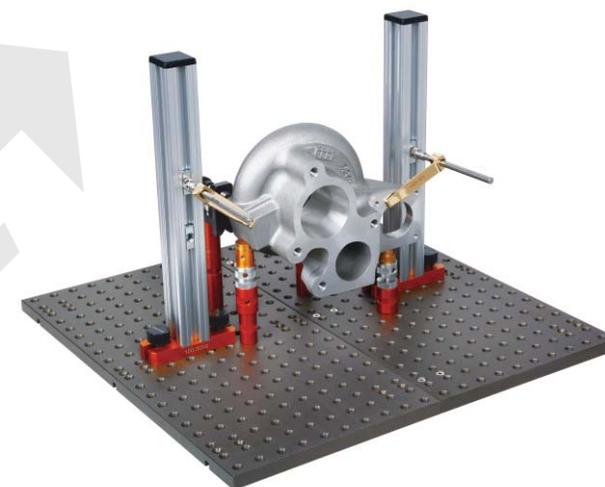
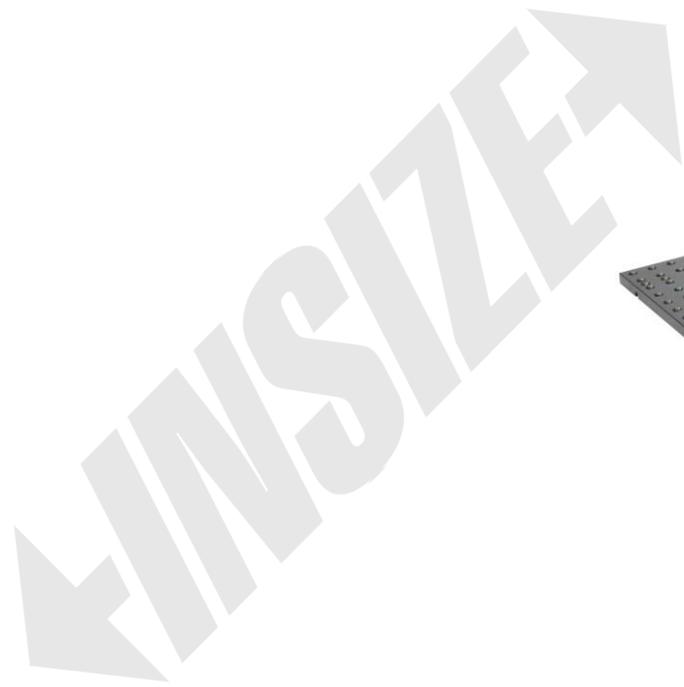




www.insize.cn



**ISY-100
JIG SET FOR CMM
OPERATION MANUAL**



Standard delivery

Product	Code	Size (mm)	Quantity
stand	ISY-100-1001	Ø16×30	5
	ISY-100-1002	Ø16×50	5
	ISY-100-1003	Ø16×100	3
	ISY-100-1004	Ø20×30	5
	ISY-100-1005	Ø20×50	5
	ISY-100-1006	Ø20×100	3
stand with fine adjustment	ISY-100-2001	Ø16×45~60	2
	ISY-100-2003	Ø20×45~60	2
horizontal spring stand	ISY-100-4001	—	2
horizontal screw stand	ISY-100-5001	—	2
magnetic stand	ISY-100-7001	Ø20×25	3
stand for slice parts	ISY-100-8001		2
clamping stand for slice parts	ISY-100-8002		1
clip	ISY-100-1201	—	2
clip	ISY-100-1301	—	2

Product	Code	Size (mm)	Quantity
clip stand	ISY-100-1401	Ø6×60	2
	ISY-100-1402	Ø6×100	2
vertical square column	ISY-100-3003	30×30×250	2
sliding support plate	ISY-100-1801	78×20×10	3
clamping screw	ISY-100-2301	Ø8×20	6
screw	ISY-100-2302		6
base plate	ISY-600-400200	400×400×12	2 pieces /per set
wrench	ISY-100-3701	Ø3.8×70	1
wrench	ISY-100-3801	M2.5	1
	ISY-100-3802	M5	1
	ISY-100-3803	M6	1
45° stand	ISY-100-9001	—	2
V shaped support	ISY-100-1901	—	2
V shaped support	ISY-100-1902	—	2
support head	ISY-100-2701	—	4*
	ISY-100-2702	—	4*

*2pcs in aluminum, 2pcs in plastic

Product	Code	Size (mm)	Quantity
support head	ISY-100-2703	—	4*
	ISY-100-2704	—	4*
	ISY-100-2705	—	4*
	ISY-100-2706	—	4*
	ISY-100-2707	—	4*
dust cleaner	ISY-100-3501	—	1
lubricating oil	ISY-100-3601	—	1
marker	ISY-6100-1501	—	52**

*2pcs in aluminum, 2pcs in plastic

**letter A~Z, number 0~25

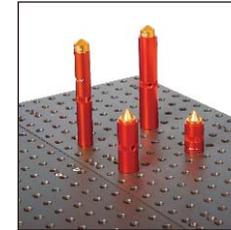
Product introduction

The three-coordinate jig set is used on CMM. Using its modular support and reference components to fix the workpiece.

- ◆ The main part is the base plate, it can protect the accuracy of the marble platform. Avoid the workpiece direct contact with the marble table.
- ◆ The jig set can fix many kinds of product and more complex products by combining with different components in jig set.
- ◆ Each set has a code number, and can record the clamping method of each workpiece. It is convenient for later measurement and use.

1. Stand

The stand is a support pillar connecting the base plate and other moving parts. It can be combined with various types of stand to fix workpiece at different heights.



2. Stand with fine adjustment

The stand with fine adjustment is a pillar with adjustable height. The height adjustment ranges from 45mm to 60mm.



3. Horizontal spring stand

Horizontal spring stand is a stand for pressing the workpiece with constant compressive force exerted by spring.



4. Horizontal screw stand

Horizontal screw stand is used to fix the workpiece by rotating and pressing the workpiece with screw.



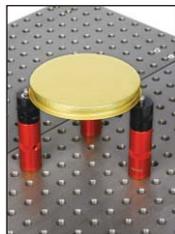
5. Magnetic stand

The magnetic stand is a pillar with magnetism on the top surface, which can be installed on the support parts. It is used to fix the magnetic metal workpiece.



6. Stand for slice parts and clamping stand for slice parts

The stand for slice parts and clamping stand for slice parts must be used together to fix the thin workpiece.



7. Clip

The clip is used to press to fix the big workpiece by metal spring piece.



8. Clip

The clip is used to press to fix the thin and small workpiece by thinner metal spring piece.



9. Vertical square column

The vertical square column is a stand connect the base plate and other components. The other components can move up and down along the guide rail.



10. Sliding support plate

Sliding support plate is fixed on the base plate by screw. Sliding support plate can rotate and move around the screw at any position, which is convenient for fixing the workpiece.



11. 45° stand

45° stand is fixed on other component. The rotating part can be rotated and fixed in any direction to connect other component to fix or support the workpiece.



12. V shaped support

The V shaped support is used with other components to support the big shaft workpiece.



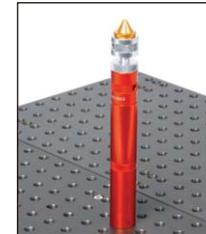
13. V shaped support

The V shaped support is used to support the small shaft workpiece.



14. Support head

Support head is used to fix or support the bottom, side, corner, hole, shaft part and other characteristics of the workpiece.



15. Marker

Marker is used to mark the position of different combination. Easily put the jigs in the right position when change the combination

