

MacroJunior & MacroCombi

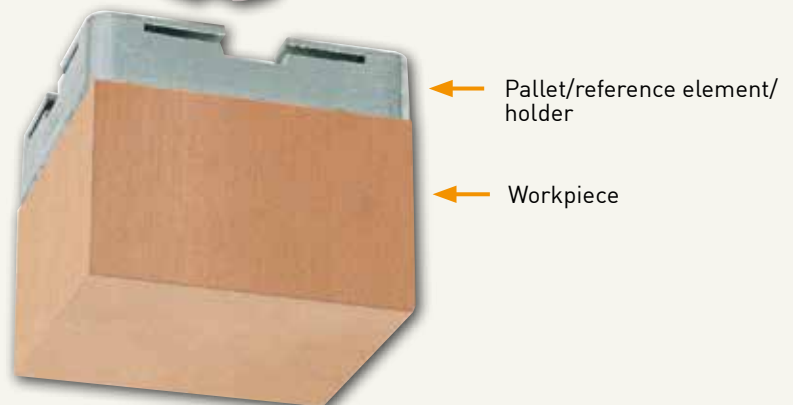
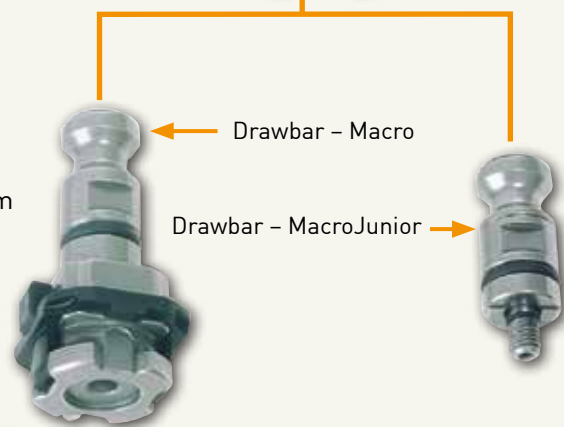
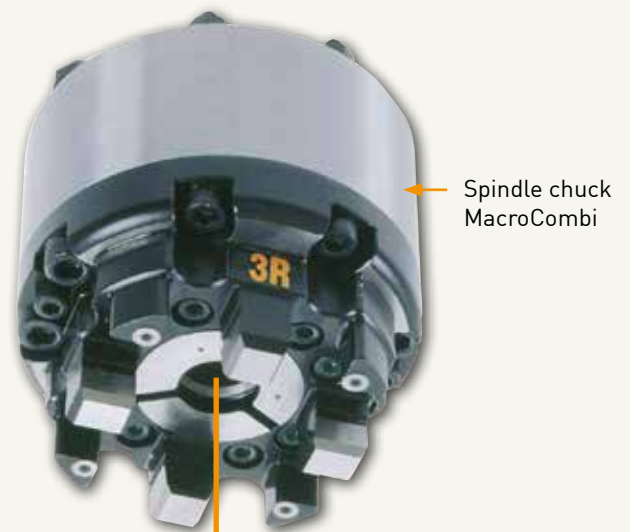
- ... gives extreme flexibility
- ... one chuck, two systems
- ... reduces setting-up times.
- ... ensures precision and quality
- ... is suitable for automatic changing with System 3R's automation program.

MacroCombi profitability in tool manufacturing is determined largely by the extent to which machine downtime can be minimised. A reference system which allows presetting away from the machine – followed by super-rapid tooling-up in the machine when the time comes – is a highly efficient way of working. MacroCombi is such a reference system.

The MacroCombi system offers extreme flexibility both in electrode production and in die-sinking EDM. Small and large electrodes in the same chuck – without adapter elements!

The MacroCombi chucks accept two completely different types of electrode holder. Both Macro with its immovable stability and precision, and MacroJunior with its highly economical holders. The limitations are few, the possibilities many.

- + Clamping force – 5000 N
- + Fixed index positions Macro 4x90° and MacroJunior 3x120°
- + Required air pressure, pneumatic chuck – 6±1 bar
- + Recommended tightening torque, manual chuck – 4 Nm



MacroJunior & MacroCombi – Chucks



Drawbar

MacroJunior pallet/holder/reference element



Drawbar

Macro & MacroJunior pallet/holder/reference element

Spindle chucks	Article number	Drawbar	Feature
Manual	3R-400.34	3R-405.11	
Pneumatic	3R-460.83-2	3R-405.16 / 3R-405.11	machine-adapted
Pneumatic	3R-460.86-2	3R-405.16 / 3R-405.11	machine-adapted
Manual	3R-400.24-11	3R-405.11	



Drawbar → Macro pallet/holder/reference element

3R-460.32

Lathe chuck	Article number	Drawbar	Feature
Manual	3R-460.32	3R-405.16/3R-405.11	

Macro or MacroJunior pallet/holder/reference element

Drawbar

MacroJunior pallet/holder/reference element

Drawbar



Table chucks	Article number	Drawbar	Feature
Manual	3R-460.31-5	3R-405.16 / 3R-405.11	horizontal and vertical
Manual	3R-460.34	3R-405.16 / 3R-405.11	
Manual	3R-460.37	3R-405.16 / 3R-405.11	
Pneumatic	3R-460.46	3R-405.16 / 3R-405.11	
Manual	3R-400.34	3R-405.11	

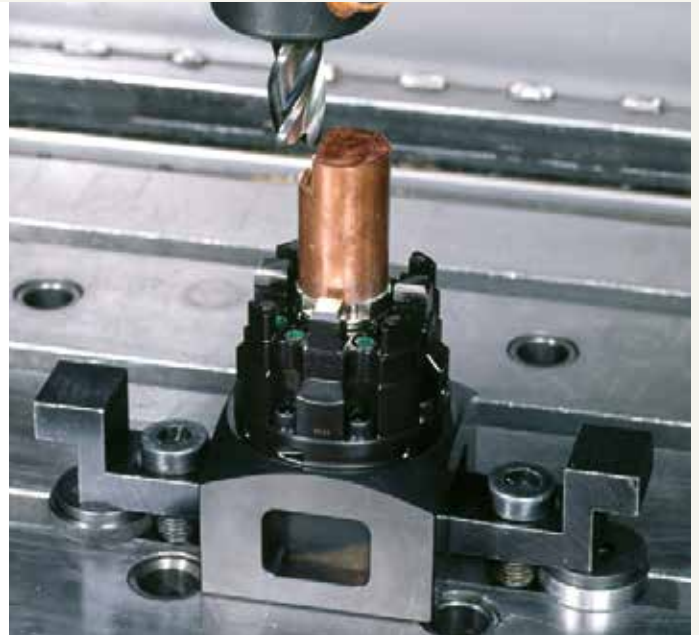
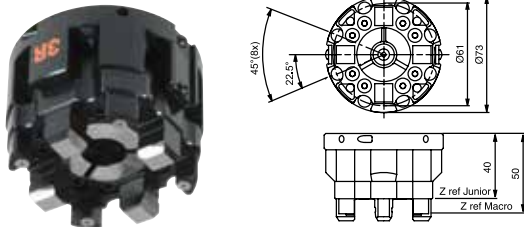
Built-in chucks	Article number	Drawbar	Feature
Manual	3R-400.24-11	3R-405.11	
Manual	3R-400.34	3R-405.11	
Manual	3R-460.34	3R-405.16 / 3R-405.11	
Pneumatic	3R-SP18286	3R-405.16 / 3R-405.11	
Pneumatic	3R-SP19047	3R-405.16 / 3R-405.11	
Manual	3R-SP19143		

MacroCombi – Chucks

Manual chuck, MacroCombi, 3R-460.34

For mounting in the machine spindle by means of 3R-A11489, or on the machine table by means of 3R-A19724 or alternatively 3R-A21944, or in a fixture.

- Required drawbar for Macro holder 3R-405.16
- Required drawbar for MacroJunior holder 3R-405.11
- Weight 1.8 kg

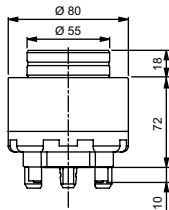


Pneumatic chuck, MacroCombi, 3R-460.83-2

Pneumatic chuck for mounting directly on the machine spindle. All X/Y/Z references in hardened and ground steel.

Note: When ordering state machine make and type.

- Four M6 clearance holes 67x20 mm
- Required drawbar for Macro holder 3R-405.16
- Required drawbar for MacroJunior holder 3R-405.11
- Required air pressure 6 ± 1 bar
- Air-blast cleaning of the Z-references
- Flushing connection
- Weight 2.1 kg

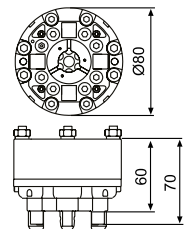


Pneumatic chuck, MacroCombi, 3R-460.86-2

Pneumatic chuck for mounting directly on the machine spindle. All X/Y/Z references in hardened and ground steel.

Note: When ordering state machine make and type.

- Four M6 clearance holes, 67x20 mm and four M5 clearance holes, 63x26 mm
- Required drawbar for Macro holder 3R-405.16
- Required drawbar for MacroJunior holder 3R-405.11
- Required air pressure 6 ± 1 bar
- Air-blast cleaning of the Z-references
- Flushing connection
- Weight 1.9 kg

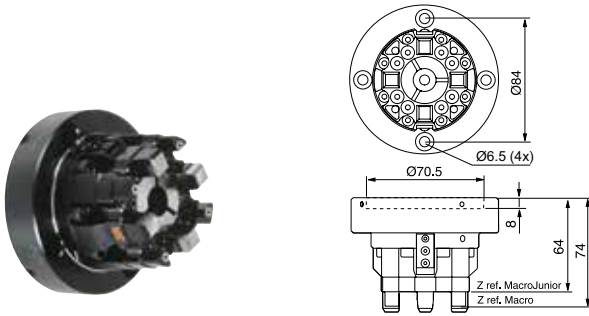


MacroCombi – Chucks

Manual lathe chuck, MacroCombi, 3R-460.32

For mounting on a lathe taper.

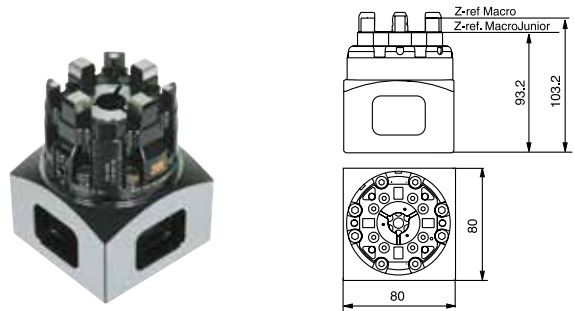
- Required drawbar for Macro holder 3R-405.16
- Required drawbar for MacroJunior holder 3R-405.11
- Weight 2.0 kg.



Manual chuck, MacroCombi, 3R-460.31-5

Chuck in HighPerformance version. Five ground surfaces for vertical or horizontal mounting on the machine table.

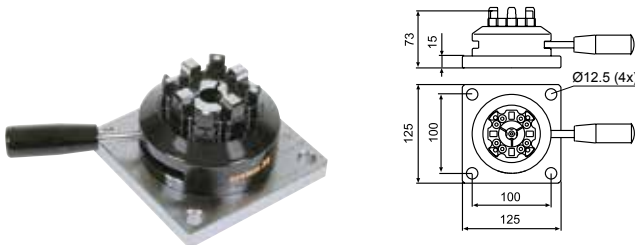
- Required drawbar for Macro holder 3R-405.16
- Required drawbar for MacroJunior holder 3R-405.11
- Weight 3.5 kg.



Manual chuck, MacroCombi, 3R-460.37

The locking mechanism is operated by a removable handle.

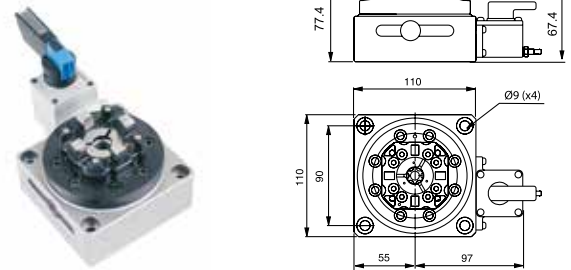
- Required drawbar for Macro holder 3R-405.16
- Required drawbar for MacroJunior holder 3R-405.11
- Weight 4.5 kg.



Pneumatic chuck, MacroCombi, 3R-460.46

Pneumatic chuck with integral air unit.

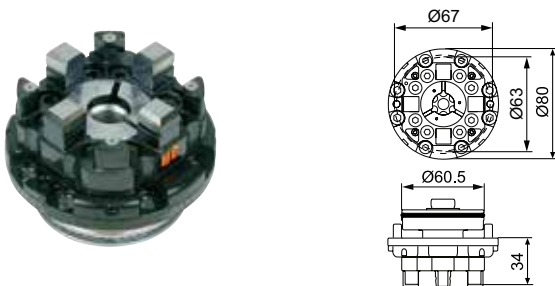
- Required drawbar for Macro holder 3R-405.16
- Required drawbar for MacroJunior holder 3R-405.11
- Required air pressure 6 ± 1 bar
- Air-blast cleaning of Z-references
- Turbo locking
- Weight 4.4 kg.



Pneumatic chuck, MacroCombi, 3R-SP18286

Pneumatic chuck for building-in, for example in a fixture, dividing head or B-axis.

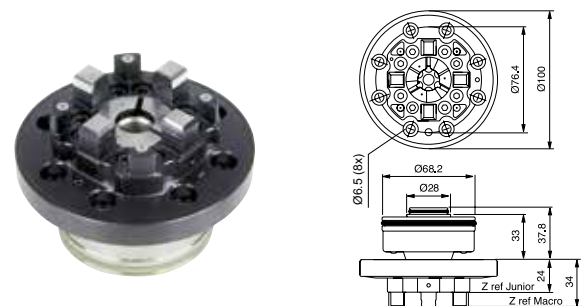
- Required drawbar for Macro holder 3R-405.16
- Required drawbar for MacroJunior holder 3R-405.11
- Required air pressure 6 ± 1 bar
- Air-blast cleaning of the Z-references
- Turbo locking
- Weight 1.1 kg.



Pneumatic chuck, MacroCombi, 3R-SP19047

Pneumatic chuck for building-in, for example in a fixture, dividing head or B-axis.

- Required drawbar for Macro holder 3R-405.16
- Required drawbar for MacroJunior holder 3R-405.11
- Required air pressure 6 ± 1 bar
- Air-blast cleaning of Z-references
- Turbo locking
- Weight 2.1 kg.



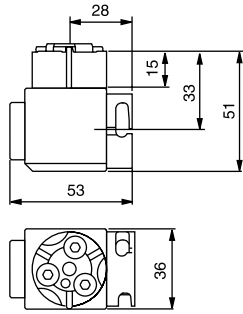
MacroJunior – Chuck adapter

Manual chuck adapter 90°, Junior-Junior, 3R-467.9-1

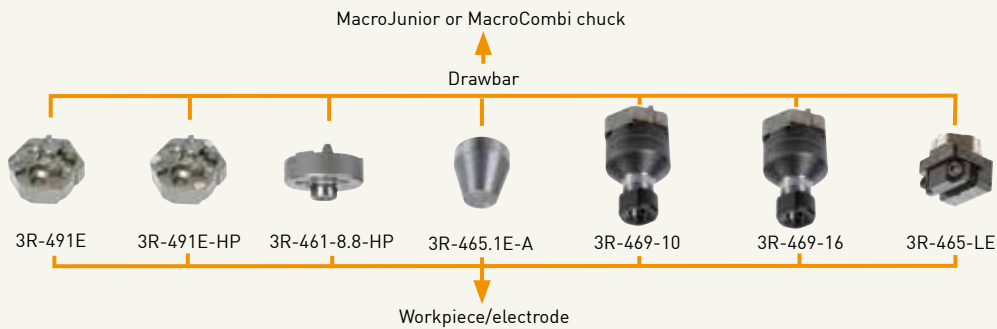
For horizontal mounting of MacroJunior holders. Screw locking.

Note: For EDM machining only.

- Fixed index positions 3x120°
- Weight 0.6 kg.



MacroJunior – Pallets & Holders



Holders	Article number	Feature
Sintered pallet Ø25 mm MacroJunior	3R-491E	
Sintered pallet Ø25 mm MacroJunior	3R-491E-HP	parallel ground
Holder Ø26 mm MacroJunior	3R-461-8.8-HP	parallel-ground. Journal Ø8.8 mm
Holder Ø28 mm MacroJunior	3R-465.1E-A	taper
Collet chuck ETS10, MacroJunior	3R-469-10	Ø0.1-10 mm
Collet chuck ER16, MacroJunior	3R-469-16	Ø0.5-10 mm
Holder, MacroJunior	3R-465-LE	Ø4-8 or <8x18 mm

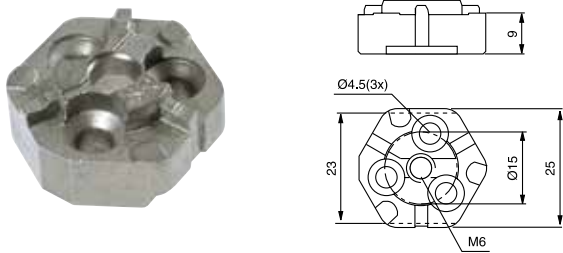
MacroJunior – Pallets & Holders

Pallet 25 mm, MacroJunior, 3R-491E

For copper or graphite electrodes.

NOTE: The electrode is installed with screw and adhesive assembly, or alternatively brazing.

- Adapted for automatic changing
- Supplied in sets of 30.

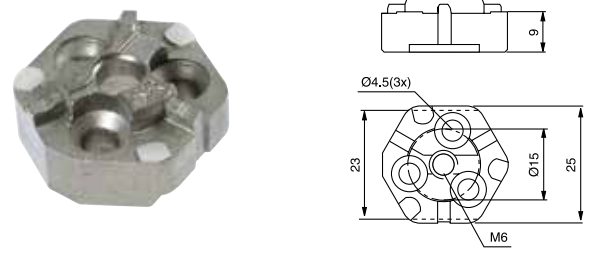


Ground pallet 25 mm, MacroJunior, 3R-491E-HP

Top and bottom faces parallel-ground to within 0.002 mm.

NOTE: The electrode is installed with screw and adhesive assembly, or alternatively brazing.

- Adapted for automatic changing
- Supplied in sets of 30.



Holder with journal , 3R-461.1E-GA

Journal Ø10x10 mm. Intended mainly for graphite electrodes. To be mounted on 3R-491E with three MFT4x12 screws and adhesive.

- Supplied in sets of 30.

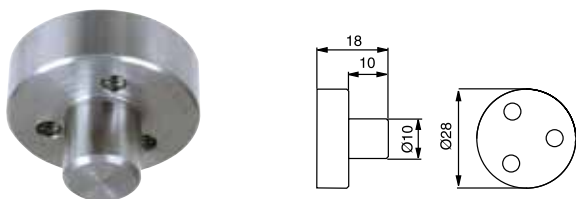


Plate 5.5 mm, 3R-SP19270

Used in combination with 3R-491E when electrode blanks are mounted with adhesive and screws*. Permits mounting in MacroCombi chucks.

- Supplied in sets of 30
- *Accessory 3R-PI4.5x25E.



✓ Except 3R-SP19269

Plate 10 mm, 3R-SP19269

Used in combination with 3R-491E when soldering round (<50 mm) or square (<40 mm) copper blanks. Permits mounting in MacroCombi chucks.

- Supplied in sets of 30
- Accessory 3R-MFT4x16E.

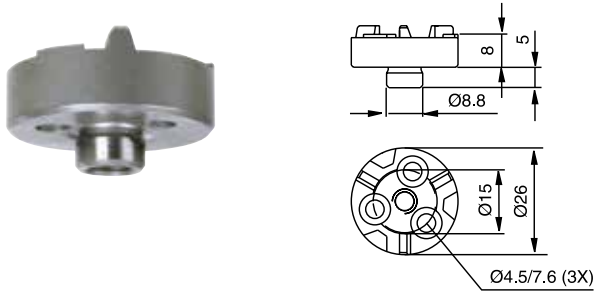


MacroJunior – Holders

Holder 25 mm, MacroJunior, 3R-461-8.8-HP

Upper and lower faces ground parallel within 0.002 mm. Locating pin $\varnothing 8.8$ mm (0/0.05 mm).

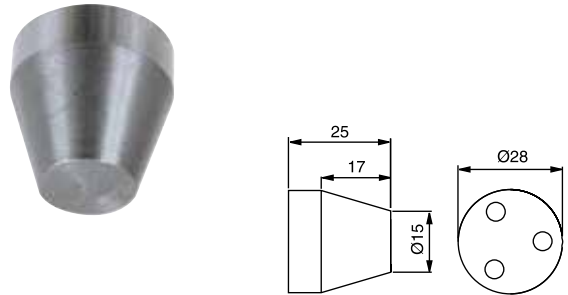
- Not intended for automatic changing
- Supplied singly.



Holder with taper, 3R-465.1E-A

The taper is machined suitably for attaching very small electrodes. To be mounted on 3R-491E with three screws MFT4x12.

- Supplied in sets of 30.



Collet chucks, MacroJunior

3R-469-10

- For collets ETS10
- Electrode sizes 0.1-2 mm
- Building-in height 47 mm
- Weight 0.1 kg.

3R-469-16

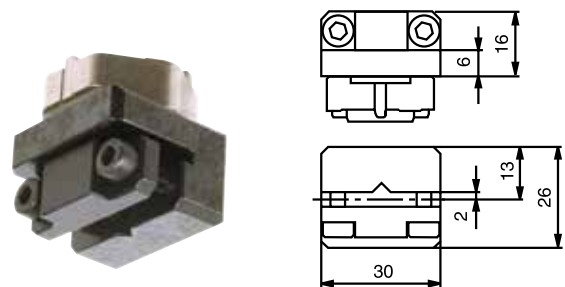
- For colles ER16
- Electrode sizes 0.5-10 mm
- Building-in height 59.5 mm
- Weight 0.2 kg.



Holder, MacroJunior, 3R-465-LE

For round electrodes $\varnothing 4-8$ mm or square $< 8 \times 18$ mm, and with maximum height 30 mm.

- Supplied in sets of 5.



MacroJunior & MacroCombi – Accessories

3Ready-to-Run, 3R-494-XXX

Blanks mounted on MacroJunior holders for the manufacture of electrodes. The stock range is matched to local preferences and ways of working. This applies to electrode materials, different grades of graphite and copper, and to dimensions. Contact your local 3R representative for further information.

The Vällingby factory can supply holders with factory-mounted copper blanks in sets of ten, as shown in the table.



Article number

3R-494-D10x50
3R-494-D12x50
3R-494-D16x50
3R-494-D22x50
3R-494-D26x50
3R-494-D32x50
3R-494-D40x50
3R-494-D50x50
3R-494-S12x50
3R-494-S22x50
3R-494-S26x50
3R-494-S32x50
3R-494-S40x50
3R-494-32x22x50
3R-494-40x22x50

Dimensions

Round blank Ø10x50 mm
Round blank Ø12x50 mm
Round blank Ø16x50 mm
Round blank Ø22x50 mm
Round blank Ø26x50 mm
Round blank Ø32x50 mm
Round blank Ø40x50 mm
Round blank Ø50x50 mm
Square blank 12x12x50 mm
Square blank 22x22x50 mm
Square blank 26x26x50 mm
Square blank 32x32x50 mm
Square blank 40x40x50 mm
Square blank 32x22x50 mm
Square blank 40x22x50 mm

Drawbar, 3R-405.11E

Drawbar Ø15 mm to mount MacroJunior holders in chucks 3R-400.XX and 3R-460.XX.

- Supplied in sets of 10.



Check ruler, 3R-406.11

For setting angular positions and for centring.

- Measuring length 60 mm.



Check mandrel, 3R-406.23

Check mandrel with ground C-reference.

- Measuring length 50 mm
- Weight 0.6 kg.



Drawbar, 3R-405.16E

Drawbar Ø15 mm to mount Macro holders in chucks 3R-460-XX.

- Supplied in sets of 10.



Fixed measuring probes

3R-US400.3

For machines with measurement cycle function.

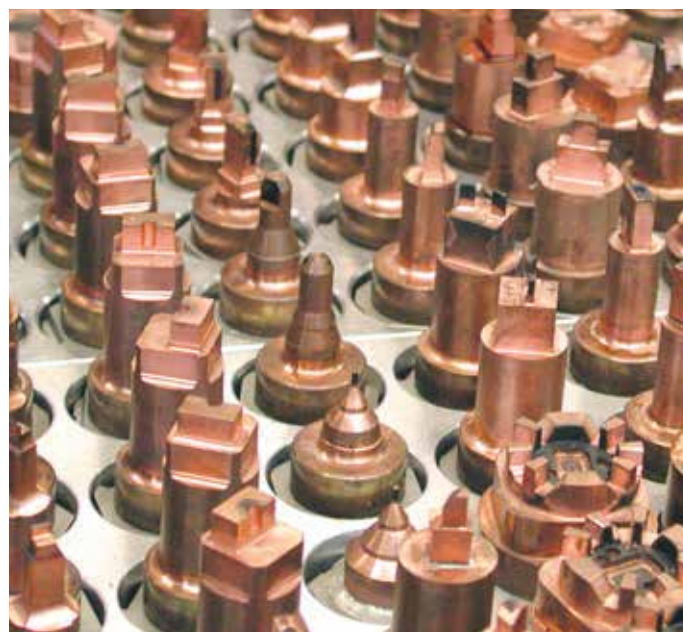
- Measuring ball Ø3 mm
- Overall length 102 mm
- Weight 0.3 kg.



3R-US400.5

For machines with measurement cycle function.

- Measuring ball Ø5 mm
- Overall length 103 mm
- Weight 0.3 kg.



MacroJunior & MacroCombi – Accessories

TORX screwdriver, 3R-333-T20

For screws 3R-PI4.5x20E and 3R-PI4.5x25E.



Torque wrench, 3R-614-04

For manual MacroJunior and MacroCombi chucks. Also for 3Refix mandrels Ø10 mm, 3R-901-10E.

- 4 Nm.



TORX screws M4, 3R-MFT4x12E

For mounting electrode blanks.

- Length 12 mm
- Supplied in sets of 100, including a TORX screwdriver.



Self tapping TORX-screws, 3R-PI4.5x20E

For mounting electrode blanks.

- Length 20 mm
- Supplied in sets of 100.



Self tapping TORX-screws, 3R-PI4.5x25E

For mounting electrode blanks.

- Length 25 mm
- Supplied in sets of 100.



Soldering kit, 3R-404-25

For soldering electrode blanks on 3R-491E or 3R-SP19269.

- Supplied with flux.
- Supplied in sets of 100.



Cassette insert, 3R-650/8-JR

For storing MacroJunior holders in 3R-650/8x5 and 3R-150/5.

- Supplied in sets of 8.



MacroJunior & MacroCombi – Kit & accessories

User kit, 3R-468.31-S

3R-405.11	Drawbar, MacroJunior	x5
3R-405.16	Drawbar, Macro	x5
3R-460.31-5	Manual table chuck, Macro	x1
3R-465-L	Holder, MacroJunior	x2
3R-465-V	Holder, MacroJunior	x2
3R-491	Holder, MacroJunior	x30
3R-651.7-S	Reference element, 54x54 mm, Macro	x6
3R-656.1	Check ruler, Macro	x1
3R-658.1-S	Intermediate plate, 54x54 mm, Macro	x2
3R-658.2-S	Holder, 54x54 mm, Macro	x2
3R-658.4-S	Holder, 54x54 mm, Macro	x2
3R-333-T20	Screwdriver, TORX	x1
3R-PI4.5x20	TORX screw	x100
3R-614-04	Torque wrench, 4 Nm	x1



Splash guard, 90027.02

Intended for MacroCombi chucks. Can also be used as a cover for unused chucks.



Ring with code carrier, 3R-863.25-10

With pre-programmed unique identity, designed for MacroJunior 25 mm, 3R-491E.

- Supplied in sets of 10.



Clamping force meter kit, 3R-SSP115-BASE

For both pneumatic and manual chucks. This stand alone unit in combination with individual drawbars or drawbar kits, able to cover MacroJunior, Macro, MacroMagnum and Dynafix.

Note: Require drawbars with bayonet interface similar to 3R-605.1.

- Add-on kit for use in MacroJunior, 3R-SSP115-JUN
- Operating temp. +10 to +40° C
- Gauge size Ø90x47 mm
- Working range 1-22 kN
- Deviation ± 0.1 kN.
- Weight:
Display 0.34 kg.
Gauge 1.3 kg.



Add-on kit, 3R-SSP115-Jun

Add-on kit for 3R-SSP115-BASE.



MacroJunior & MacroCombi – Accessories

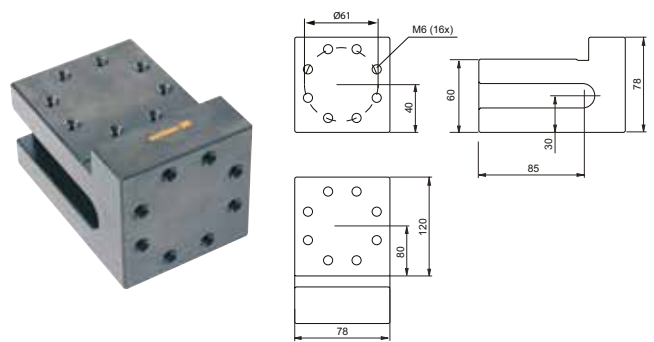
Lathe taper, 3R-TXXXX

Taper attachment for mounting chucks in taper spindles.
 Note: Manufactured on request. State machine type, taper (1), drawbar thread (2) and which 3R chuck is to be mounted. Use the order form at the end of the catalogue.



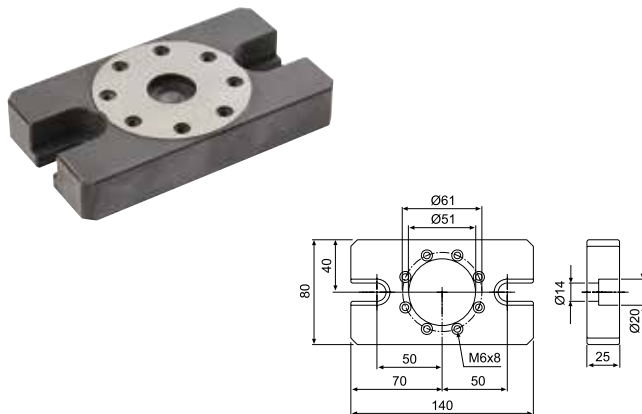
Angle shelf, 3R-A21944

For vertical or horizontal mounting of 3R-400.34, 3R-460.34 and 3R-600.24-S on the machine table. Intended for milling.
 Note: Chuck to be ordered separately.



Adapter plate, 3R-A19724

For mounting of 3R-400.34, 3R-460.34 and 3R-600.24-S on machine table. Supplied with fixing screws for chuck and table.



Air unit, 3R-611.46

Unit for operation of pneumatic chucks. Three positions – open/neutral/closed.

