**Model JMC** MAGNETIC FIXTURE BLOCK

[Application]
Permanent magnetic blocks to hold workpieces strongly on machines such as the MC and NC.

Two types of clamping are available; magnet type and mechanical type by use of threaded holes.

[Features]
- A powerful permanent magnet used generates a strong magnetic force.
- The workpiece mounting and demounting time can be reduced significantly.
- Iron and nonmagnetic workpieces can be held by a magnet and mechanical clamping.
- These blocks can be connected to allow relatively large workpieces to be set.
- The blocks can be mounted vertically by using threaded holes on three faces (both faces and bottom face) other than the attractive face.

### Table: Holding Power

<table>
<thead>
<tr>
<th>Model</th>
<th>Holding Power</th>
<th>Holding Face</th>
<th>Mounting Face</th>
<th>Side Face</th>
<th>Others</th>
<th>Height</th>
<th>Mass</th>
</tr>
</thead>
<tbody>
<tr>
<td>JMC-75</td>
<td>7.5kN (750kgf)</td>
<td>136</td>
<td>180</td>
<td>59</td>
<td>77</td>
<td>134</td>
<td>80</td>
</tr>
<tr>
<td>JMC-120</td>
<td>12kN (1200kgf)</td>
<td>180</td>
<td>199</td>
<td>78</td>
<td>87</td>
<td>178</td>
<td>100</td>
</tr>
</tbody>
</table>

1. The holding power is based on a test piece of 55400, 50 mm thick, ground surface held on the whole face.
2. An operating handle is included. The connecting parts are optional.
3. When several blocks are connected and the same faces are used, ground them together after connecting blocks to obtain a required flatness.

**Model EPB** PERMANENT ELECTROMAGNETIC BLOCK

[Application]
Designed for holding workpieces on such machines as machining centers and NC machine tools. Most suitable for machining workpieces by 5-face machining centers, etc.

[Features]
- By securing a workpiece overhanging, the setup time on the 5-face machining center can be shortened.
- These blocks can be used in wet operations and therefore can be used like normal magnetic chucks.
- Since these blocks are of permanent electromagnetic type, the holding power is not affected by power failure or cable breakage. Also since very little heat is generated, thermal influence on workpiece is minimal.
- The metal connector design facilitates disconnection of the power cable. (Pallet change and external setup facilitated.)

### Table: Dimensions

<table>
<thead>
<tr>
<th>Model</th>
<th>Dimensions</th>
<th>Pole Size</th>
<th>No. of Poles</th>
<th>Holding Power</th>
<th>Mass</th>
</tr>
</thead>
<tbody>
<tr>
<td>EPB-1F1625A</td>
<td>160 (6.29)</td>
<td>250</td>
<td>150</td>
<td>70 (2.75)</td>
<td>2</td>
</tr>
<tr>
<td>EPB-1F2525A</td>
<td>255 (9.96)</td>
<td>150</td>
<td>70</td>
<td>23.5kN</td>
<td>4</td>
</tr>
<tr>
<td>EPB-1F3333A</td>
<td>330 (12.9)</td>
<td>330</td>
<td>9</td>
<td>53kN</td>
<td>9</td>
</tr>
</tbody>
</table>

1. The chuck controller is not included.
2. Turning the permanent electromagnetic blocks on and off must be limited to once per several minutes. If on/off operations are repeated frequently, the blocks may be damaged by overheating.
3. The holding power is based on a test piece of SS400, 50 mm thick, ground surface held on the whole face.
**Model EPB-2F**

**DOUBLE-FACE HOLDING PERMANENT ELECTROMAGNETIC BLOCK**

![EPB-2F2525]

**[Application]**

Suitable for various cutting applications such as by the MC.

**[Features]**

- As a workpiece is held on both faces, no mechanical clamping is necessary. It can be set on the machine table easily.
- By securing a workpiece overhanging, five faces can be machined in one chucking to improve the machining efficiency and accuracy.
- Since these blocks are of permanent electromagnetic type, the holding power is not affected by power failure or cable breakage. Also since very little heat is generated, thermal influence on workpiece is minimal.
- The power cable is of metal connector type that can be disconnected easily to make it suitable for pallet change and external setup.
- Several blocks can be used at the same time according to workpiece sizes and machining conditions.

<table>
<thead>
<tr>
<th>Model</th>
<th>Dimensions</th>
<th>Pole Size</th>
<th>No. of Poles (per Face)</th>
<th>Holding Power</th>
<th>Mass</th>
<th>Electro Chuck Master</th>
</tr>
</thead>
<tbody>
<tr>
<td>EPB-2F2525</td>
<td>250 (9.84)</td>
<td>250 (9.84)</td>
<td>100 (3.94)</td>
<td>4</td>
<td>23.6kN</td>
<td>70kg/ 80 lb</td>
</tr>
<tr>
<td>EPB-2F3333</td>
<td>120 (4.72)</td>
<td>120 (4.72)</td>
<td>50 (1.97)</td>
<td>9</td>
<td>53.0kN</td>
<td>70kg/154 lb</td>
</tr>
</tbody>
</table>

*The chuck controller is not included.
*The holding power is based on a test piece of SS400, 50 mm thick, ground surface held on the whole face.

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**Model RMA-2F**

**POWERFUL DOUBLE-FACE HOLDING PERMANENT MAGNETIC BLOCK**

![RMA-2F1530]

**[Application]**

Suitable for various cutting applications such as by the MC.

**[Features]**

- Since no mechanical clamping is required, setting on the machine table can be done easily to shorten the setup time.
- By securing a workpiece overhanging, five faces can be machined in one chucking.
- These blocks can be used in wet operations.
- These blocks are of permanent magnetic type that requires no power source. No troublesome work such as electrical connection is required and there is no fear of electrical troubles such as power failure and cable breakage.

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**Graphs and Diagrams**

- Single stopper
- Radial handle
- Tolerance

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**Table**

<table>
<thead>
<tr>
<th>Model</th>
<th>Dimensions</th>
<th>Holding Power</th>
<th>Mass</th>
</tr>
</thead>
<tbody>
<tr>
<td>RMA-2F125</td>
<td>125 (4.92)</td>
<td>184 (7.24)</td>
<td>10kN</td>
</tr>
<tr>
<td>RMA-2F150</td>
<td>150 (5.91)</td>
<td>229 (9.01)</td>
<td>15kN</td>
</tr>
<tr>
<td>RMA-2F200</td>
<td>200 (7.87)</td>
<td>334 (13.11)</td>
<td>30kN</td>
</tr>
</tbody>
</table>

*The holding power is based on a test piece of SS400, 50 mm thick, ground surface held on the whole face.*