Electromagnetic chuck for removing distortion ACSHIM* Series

This is an epoch-making chuck that supports a distorted/warped workpiece with sticks to hold it in its natural state.

- Model KEZF-WS and KEZF-G:
  - Sticks on the work face support a distorted (warped) workpiece and hold it in a natural state. Since no measures are necessary to support such workpieces using shims, etc., the work efficiency can be improved.
  - A series of operation from supporting a workpiece (raising the sticks) up to holding and securing the workpiece can be done quickly.
  - Each stick unit (workpiece support) can be removed easily for easy maintenance.

**Model KEZF-WS ACSHIM* FOR PRECISION CUTTING**

[Application]
The sticks arranged at certain pitches enable precise setting of workpieces quickly in the machining sector including mold bases in dry milling operations.

[Features]
- The precision flatness machining time can be reduced by 50%.
- The turn-over process in machining is reduced from 3 - 4 steps to 2 steps.
- The use of sticks requires no skills to machine workpieces precisely.
- Workpieces of 3 mm distortion max. can be supported.
- Most suitable for milling plates that are 20 mm or thicker.

**Normal electromagnetic chuck**

Prior to holding

Holding → machining

Magnetic force released

Absorbed warping of workpiece returns to original state.

**ACSHIM**

Prior to holding

Holding → machining

Magnetic force released

Sticks support concave parts of workpiece.

**Accuracy improvement by ACSHIM (Flatness)**

Workpiece size 300 × 700 mm (Material SS400)

<table>
<thead>
<tr>
<th>Material</th>
<th>0.00</th>
<th>0.20</th>
<th>0.40</th>
<th>0.60</th>
<th>0.80</th>
</tr>
</thead>
<tbody>
<tr>
<td>Note: Not guaranteed values.</td>
<td></td>
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</tbody>
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**Model KEZF-WS Specifications**

<table>
<thead>
<tr>
<th>Model</th>
<th>Nominal Size</th>
<th>Work Face</th>
<th>Mounting Face</th>
<th>Height</th>
<th>Number of Sticks</th>
<th>Mass</th>
</tr>
</thead>
<tbody>
<tr>
<td>KEZF-WS 3060</td>
<td>300 (11.8) × 600 (23.6)</td>
<td>300 (11.8)</td>
<td>600 (23.6)</td>
<td>310 (12.2)</td>
<td>620 (24.4)</td>
<td>105 (4.13)</td>
</tr>
<tr>
<td>KEZF-WS 4080</td>
<td>400 (15.7) × 800 (31.5)</td>
<td>400 (15.7)</td>
<td>800 (31.5)</td>
<td>410 (16.1)</td>
<td>620 (24.4)</td>
<td>105 (4.13)</td>
</tr>
<tr>
<td>KEZF-WS60100</td>
<td>500 (19.6) × 1000 (39.4)</td>
<td>500 (19.6)</td>
<td>1000 (39.4)</td>
<td>510 (20.0)</td>
<td>620 (24.4)</td>
<td>105 (4.13)</td>
</tr>
<tr>
<td>KEZF-WS80100</td>
<td>600 (23.6) × 1000 (39.4)</td>
<td>600 (23.6)</td>
<td>1000 (39.4)</td>
<td>610 (24.0)</td>
<td>620 (24.4)</td>
<td>105 (4.13)</td>
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