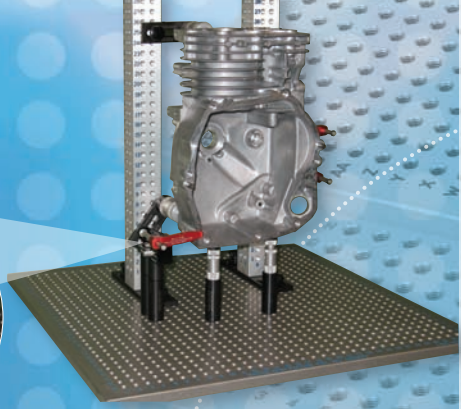


RAYCO CMM FIXTURE KITS



clamping kits

1/4-20 kit shown



1/4-20 clamping kit

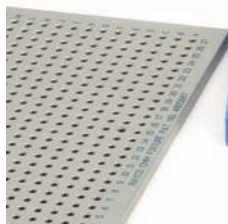
QTY	PART #	DESCRIPTION
4	R20-ST5-1	small tension spring (1.0" post)
10	R20-LTS-3	large tension spring (3.0" post)
2	R20-50-JS	small jackstand
1	R20-1-JS	large jackstand
2	R20-SLD	slide base
1	R20-MSLD	mini slide base
4	R20-NC	nylon cone
4	R20-SRP	steel resting pin
1	R20-LB	locating block
2	R20-501-PSO	.50" dia. x 1.0" pin standoff
3	R20-37550-SO	.375" x .50" standoff
6	R20-5075-SO	.50" dia. x .75" standoff
6	R20-501-SO	.50" dia. x 1.0" standoff
6	R20-502-SO	.50" dia. x 2.0" standoff
3	R20-7550-SO	.75" dia. x .50" standoff
6	R20-7575-SO	.75" dia. x .75" standoff
6	R20-751-SO	.75" dia. x 1.0" standoff
6	R20-752-SO	.75" dia. x 2.0" standoff
3	R20-753-SO	.75" dia. x 3.0" standoff
6	R20-175-SO	1.0" dia. x .75" standoff
6	R20-11-SO	1.0" dia. x 1.0" standoff
6	R20-12-SO	1.0" dia. x 2.0" standoff
3	R20-14-SO	1.0" dia. x 4.0" standoff
1	R20-SCT	small component tray

M8 clamping kit

QTY	PART #	DESCRIPTION
4	R8-ST5-25	small tension spring (25mm post)
10	R8-LTS-75	large tension spring (75mm post)
2	R8-19-JS	small jackstand
1	R8-25-JS	large jackstand
2	R8-SLD	slide base
4	R8-NC	nylon cone
4	R8-SC	steel cone
1	R8-LB	locating block
2	R8-1325-PSO	13mm dia. x 25mm pin standoff
6	R8-1320-SO	13mm dia. x 20mm standoff
6	R8-1325-SO	13mm dia. x 25mm standoff
6	R8-1350-SO	13mm dia. x 50mm standoff
3	R8-1915-SO	19mm dia. x 15mm standoff
6	R8-1920-SO	19mm dia. x 20mm standoff
6	R8-1925-SO	19mm dia. x 25mm standoff
6	R8-1950-SO	19mm dia. x 50mm standoff
3	R8-1975-SO	19mm dia. x 75mm standoff
6	R8-2520-SO	25mm dia. x 20mm standoff
6	R8-2525-SO	25mm dia. x 25mm standoff
6	R8-2550-SO	25mm dia. x 50mm standoff
3	R8-25100-SO	25mm dia. x 100mm standoff
1	R8-SCT	small component tray

magnetic & clamping kits

1/4-20 kit shown



1/4-20 magnetic & clamping kit

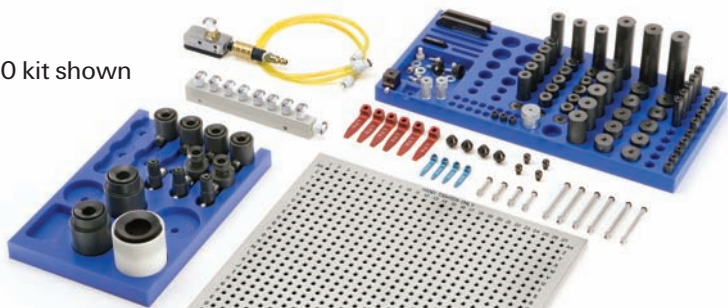
QTY	PART #	DESCRIPTION
3	R20-ST5-1	small tension spring (1.0" post)
6	R20-LTS-3	large tension spring (3.0" post)
2	R20-50-JS	small jackstand
1	R20-1-JS	large jackstand
2	R20-SLD	slide base
1	R20-MSLD	mini slide base
4	R20-NC	nylon cone
4	R20-SRP	steel resting pin
1	R20-LB	locating block
2	R20-50-PM	.50" dia. x 1.0" pin magnet
4	R20-50-M	.50" dia. x 1.0" magnet
4	R20-75-M	.75" dia. x 1.0" magnet
4	R20-1-M	1.0" dia. x 1.0" magnet
3	R20-37550-SO	.375" dia. x .50" standoff
5	R20-5075-SO	.50" dia. x .75" standoff
5	R20-501-SO	.50" dia. x 1.0" standoff
5	R20-502-SO	.50" dia. x 2.0" standoff
3	R20-7550-SO	.75" dia. x .50" standoff
5	R20-7575-SO	.75" dia. x .75" standoff
5	R20-751-SO	.75" dia. x 1.0" standoff
5	R20-752-SO	.75" dia. x 2.0" standoff
3	R20-753-SO	.75" dia. x 3.0" standoff
5	R20-175-SO	1.0" dia. x .75" standoff
5	R20-11-SO	1.0" dia. x 1.0" standoff
5	R20-12-SO	1.0" dia. x 2.0" standoff
3	R20-14-SO	1.0" dia. x 4.0" standoff
1	R20-SCT	small component tray

M8 magnetic & clamping kit

QTY	PART #	DESCRIPTION
3	R8-ST5-25	small tension spring (25mm post)
6	R8-LTS-75	large tension spring (75mm post)
2	R8-19-JS	small jackstand
1	R8-25-JS	large jackstand
2	R8-SLD	slide base
4	R8-NC	nylon cone
4	R8-SC	steel cone
1	R8-LB	locating block
2	R8-13-PM	13mm dia. x 25mm pin standoff
4	R8-13-M	13mm dia. x 25mm magnet
4	R8-19-M	19mm dia. x 25mm magnet
4	R8-25-M	25mm dia. x 25mm magnet
5	R8-1320-SO	13mm dia. x 20mm standoff
5	R8-1325-SO	13mm dia. x 25mm standoff
5	R8-1350-SO	13mm dia. x 50mm standoff
3	R8-1915-SO	19mm dia. x 15mm standoff
5	R8-1920-SO	19mm dia. x 20mm standoff
5	R8-1925-SO	19mm dia. x 25mm standoff
5	R8-1950-SO	19mm dia. x 50mm standoff
3	R8-1975-SO	19mm dia. x 75mm standoff
5	R8-2520-SO	25mm dia. x 20mm standoff
5	R8-2525-SO	25mm dia. x 25mm standoff
5	R8-2550-SO	25mm dia. x 50mm standoff
3	R8-25100-SO	25mm dia. x 100mm standoff
1	R8-SCT	small component tray

vacuum & clamping kits

1/4-20 kit shown



1/4-20 vacuum & clamping kit

QTY	PART #	DESCRIPTION
4	R20-ST5-1	small tension spring (1.0" post)
6	R20-LTS-3	large tension spring (3.0" post)
2	R20-50-JS	small jackstand
1	R20-1-JS	large jackstand
2	R20-SLD	slide base
1	R20-MSLD	mini slide base
4	R20-NC	nylon cone
4	R20-SRP	steel resting pin
1	R20-LB	locating block
3	R20-10-SC	10mm suction cup
4	R20-20-SC	20mm suction cup
2	R20-30-SC	30mm suction cup
1	R20-50-SC	50mm suction cup
2	R20-20-EXSC	20mm exposed suction cup
1	R-VK	pump, manifold, & hoses
3	R20-37550-SO	.375" dia. x .50" standoff
5	R20-5075-SO	.50" dia. x .75" standoff
5	R20-501-SO	.50" dia. x 1.0" standoff
5	R20-502-SO	.50" dia. x 2.0" standoff
3	R20-7550-SO	.75" dia. x .50" standoff
5	R20-7575-SO	.75" dia. x .75" standoff
5	R20-751-SO	.75" dia. x 1.0" standoff
5	R20-752-SO	.75" dia. x 2.0" standoff
3	R20-753-SO	.75" dia. x 3.0" standoff
5	R20-175-SO	1.0" dia. x .75" standoff
5	R20-11-SO	1.0" dia. x 1.0" standoff
5	R20-12-SO	1.0" dia. x 2.0" standoff
3	R20-14-SO	1.0" dia. x 4.0" standoff
1	R20-SCT	small component tray
1	R-VCT	vacuum component tray

M8 vacuum & clamping kit

QTY	PART #	DESCRIPTION
4	R8-ST5-25	small tension spring (25mm post)
6	R8-LTS-75	large tension spring (75mm post)
2	R8-19-JS	small jackstand
1	R8-25-JS	large jackstand
2	R8-SLD	slide base
4	R8-NC	nylon cone
4	R8-SC	steel cone
1	R8-LB	locating block
3	R8-10-SC	10mm suction cup
4	R8-20-SC	20mm suction cup
2	R8-30-SC	30mm suction cup
1	R8-50-SC	50mm suction cup
2	R8-20-EXSC	20mm exposed suction cup
1	R-VK	pump, manifold, & hoses
5	R8-1320-SO	13mm dia. x 20mm standoff
5	R8-1325-SO	13mm dia. x 25mm standoff
5	R8-1350-SO	13mm dia. x 50mm standoff
3	R8-1915-SO	19mm dia. x 15mm standoff
5	R8-1920-SO	19mm dia. x 20mm standoff
5	R8-1925-SO	19mm dia. x 25mm standoff
5	R8-1950-SO	19mm dia. x 50mm standoff
3	R8-1975-SO	19mm dia. x 75mm standoff
5	R8-2520-SO	25mm dia. x 20mm standoff
5	R8-2525-SO	25mm dia. x 25mm standoff
5	R8-2550-SO	25mm dia. x 50mm standoff
3	R8-25100-SO	25mm dia. x 100mm standoff
1	R8-SCT	small component tray
1	R-VCT	vacuum component tray

CMM fixture kits

A kit includes one base plate (sizes shown below) and the components listed on the following pages for the corresponding kit. To determine the part number for the desired kit, select the size of the base plate below. (Ex: A 1/4-20 clamping kit with a 12" x 12" x .50" plate is part # R20-CK1)

	clamping kit	magnetic & clamping kit	vacuum & clamping kit
1/4-20 kits Rayco aluminum base plate with 1/4-20 threaded holes .50" on center			
BASE PLATE SIZE	PART #	PART #	PART #
12" x 12" x .50"	R20-CK1	R20-MCK1	R20-VCK1
18" x 18" x .50"	R20-CK2	R20-MCK2	R20-VCK2
24" x 24" x .75"	R20-CK3	R20-MCK3	R20-VCK3
30" x 30" x .75"	R20-CK4	R20-MCK4	R20-VCK4
28" x 40" x .75"	R20-CK5	R20-MCK5	R20-VCK5
36" x 48" x .75"	R20-CK6	R20-MCK6	R20-VCK6

M8 kits Rayco aluminum base plate with M8 threaded holes 15mm on center

BASE PLATE SIZE	PART #	PART #	PART #
300mm x 300mm x 13mm	R8-CK1	R8-MCK1	R8-VCK1
450mm x 450mm x 13mm	R8-CK2	R8-MCK2	R8-VCK2
600mm x 600mm x 19mm	R8-CK3	R8-MCK3	R8-VCK3
750mm x 750mm x 19mm	R8-CK4	R8-MCK4	R8-VCK4
750mm x 1020mm x 19mm	R8-CK5	R8-MCK5	R8-VCK5
900mm x 1200mm x 19mm	R8-CK6	R8-MCK6	R8-VCK6

- Custom fixtures and components are also available.
- Plates 24" x 24" (600mm x 600mm) and larger can be ordered with either a 1/2" (15mm) or 1" (30mm) hole pattern.
- Other plate sizes available upon request up to a maximum of 50" x 84" (1260mm x 2100mm).
- Visit www.raycofixture.com for a listing of common plate sizes.
- Fixture kits can be tailored to fit your application.
- Mounting holes used to attach the Rayco base plate to your specific CMM are available at no additional charge.

Note: Rayco CMM fixtures and components are guaranteed against manufacturer defects for one year.

Note: The Rayco CMM Fixture System is covered by U.S. Patent No. 4,805,887 and 5,135,120.