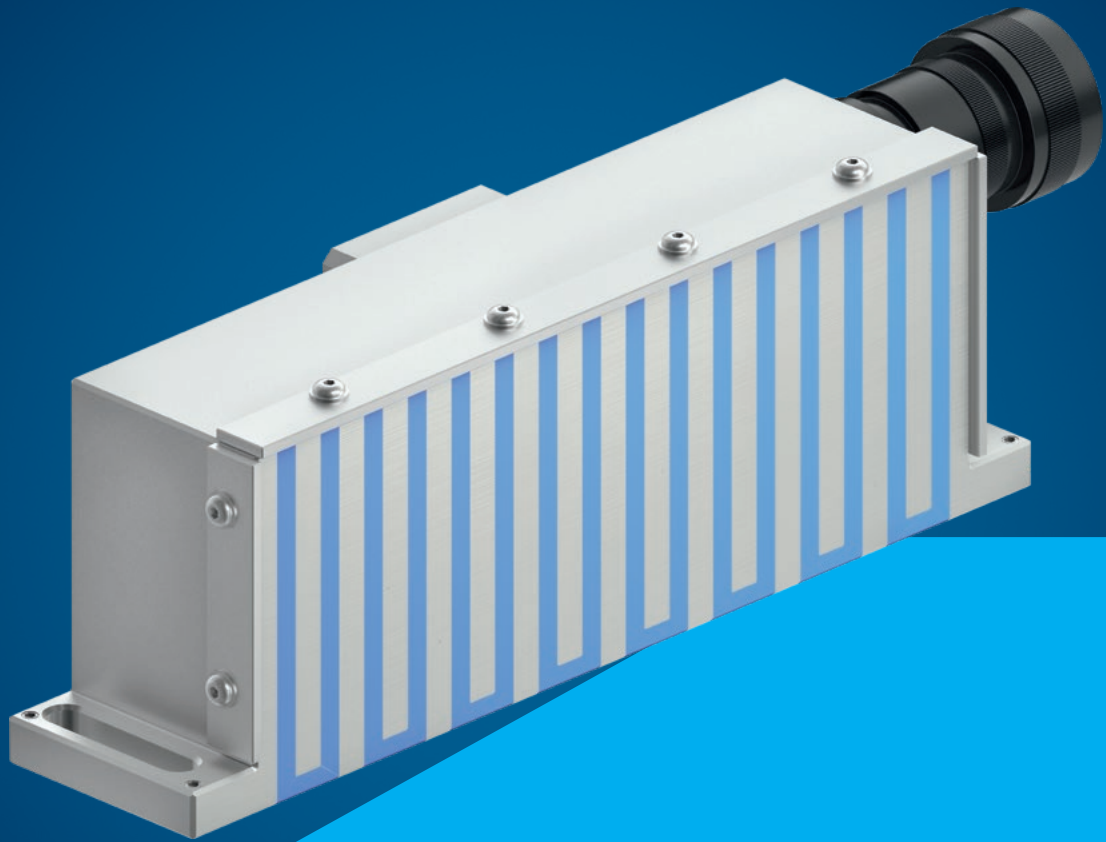


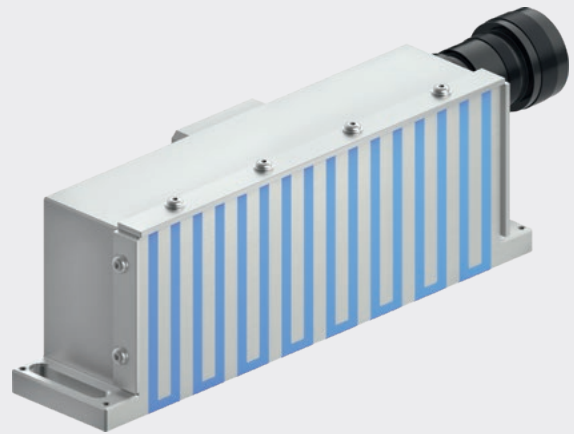


MAGNOS MEF

**Electropermanent magnetic
modules for wire EDM**

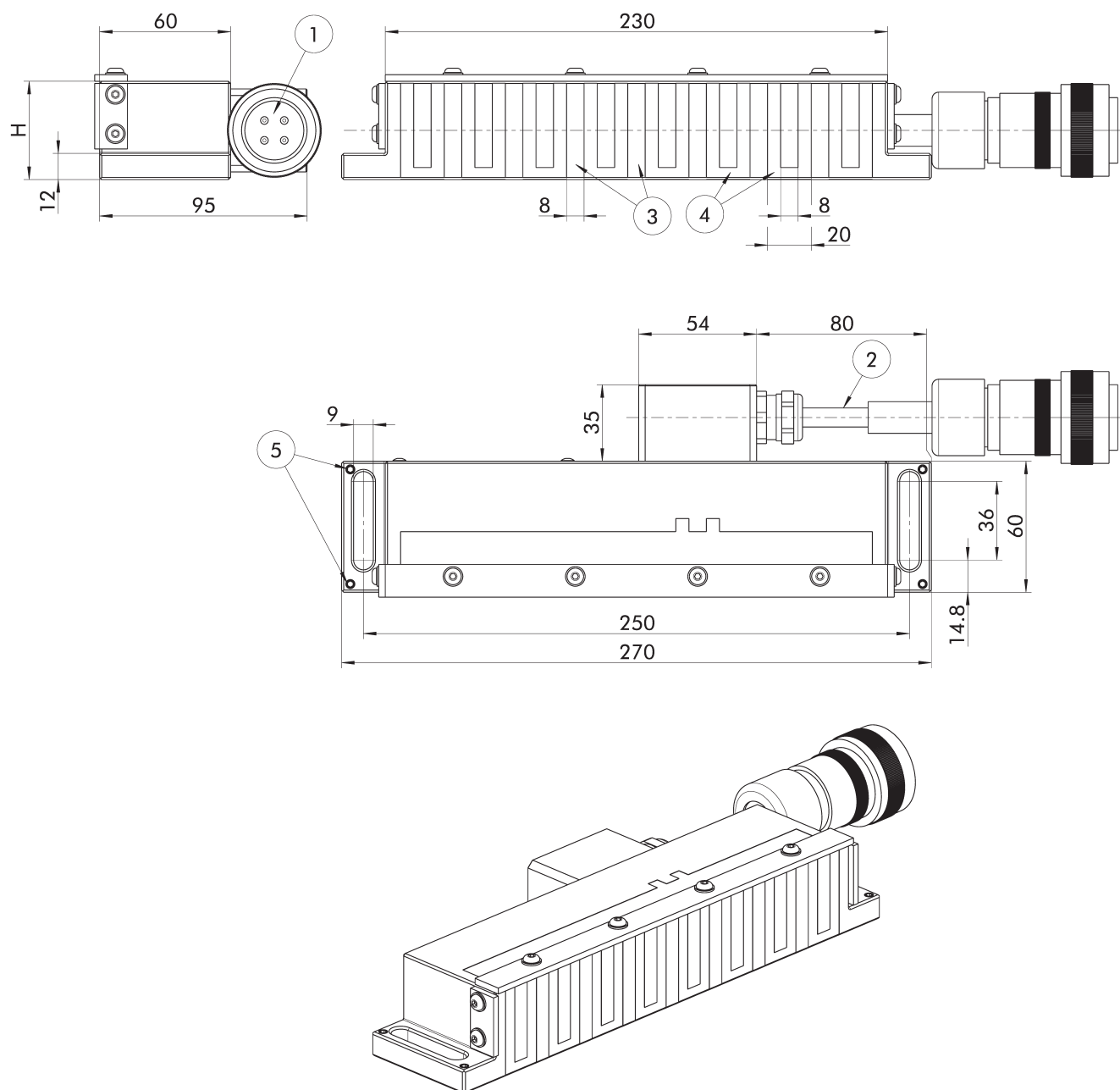
Electropermanent magnetic modules with high holding forces specifically for EDM applications

MAGNOS MEF magnetic modules are specially designed for EDM applications. An innovative "fine" and "active" pole pitch allows very small workpieces to be clamped while maintaining the holding force required for machining. Due to the unfavorable influences during eroding – caused by the chemical liquids and contact with air – the magnetic modules are made of special stainless steel. This prevents oxidation as well as expensive cleaning work on the modules. The MEF magnetic modules are self-sufficient and require only a short pulse for the MAG/DEMAG processes due to innovative electro-permanent technology. Specially prepared positioning holes allow quick and easy mounting on EDM machines without the need to drill separate holes beforehand.



Advantages – Your benefits

- + Innovative "fine" and "active" pole pitch**
Provision of the required clamping force for clamping of very small workpieces (up to 20 x 20 mm)
- + Stainless steel frame**
Avoidance of oxidation and expensive cleaning due to contact with air and chemical liquids
- + Even permanent magnetic clamping force across the entire workpiece**
Low deformation and vibration clamping of the workpieces
- + Low vibration clamping**
Improved surfaces and significantly increased precision
- + Deformation-free clamping**
No deformation and internal forces in the workpiece due to the clamping force
- + State-of-the-art electropermanent technology for one-time energy supply for MAG/DEMAG process**
Energy-efficient and reliable clamping of the workpieces
- + Clamping within a few seconds**
Shortest possible setup times and a resulting increase in productivity
- + Control unit compatible with machine control system**
Can also be used in automated applications
- + Mounting bores especially for EDM machines**
The magnetic modules can be mounted directly on the machine table.



Subject to technical changes.

- ① 4-PIN connector for connecting with the control unit
- ② Connection cable length 5 m
- ③ Steel pole

- ④ Synthetic resin filling
- ⑤ Fine alignment of the angular position

Technical data

Description	ID	Length L [mm]	Width B [mm]	Height H [mm]	Connection	Number of channels	Weight [kg]
MEF-F-A1-100 270x45	1393252	270	60	45	4-PIN	1	6
MEF-F-A1-100 270x90	1393250	270	60	90	4-PIN	1	10

Scope of delivery

Magnetic chuck, operating manual, CE declaration of conformity

Notes

Field of application

For very small workpieces on EDM machines.

Stainless steel housing.

Resistant to the influence of air and chemical fluids from the erosion process.

Cable connection

The magnetic modules are equipped with a fixed cable connection and a 5 m cable.

Further technical data

Max. clamping force [N/cm ²]	Mains voltage [V]	Min. workpiece size [mm]	Cable length fixed connection [m]	Max. working temperature [°C]	IP protection class of fixed connection
75	200/220	20 x 20	5	80	68

Accessories

Manual gaussmeter

For determining the residual magnetism in the workpiece after machining.



Suitable for	Description	ID
MEF-F-A1-100	MG10	0422950

Hand remote control

Hand remote control for max. one magnetic chuck

With holding force regulation (HKR).



Suitable for	Description	Length m	HKR	ID
KEH plus 01 220V/50Hz	HABE KEH plus 01-HKR	5	●	0420665

Connection cable

Connection cable 1x 4-PIN for max. one magnetic chuck

Connections:

Control unit = 1 x 4-PIN.

Magnetic chuck = 1 x 4-PIN/1CH.



Suitable for	Description	Length m	ID
MEF-F-A1-100	VBK2-MEF-5 1x4PK-1x4P 1CH	5	1611128

Control units

Control unit 220V/50Hz

For magnetizing or demagnetizing magnetic chucks.



Suitable for	Description	Channels	ID
MEF-F-A1-100	KEH plus 01 220V/50Hz	1	0420655



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