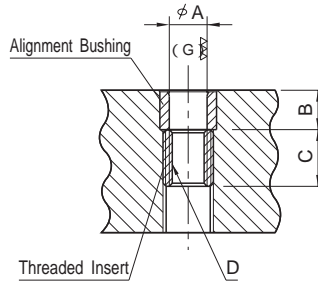


TECHNICAL INFORMATION

Multipurpose(MTP) Holes

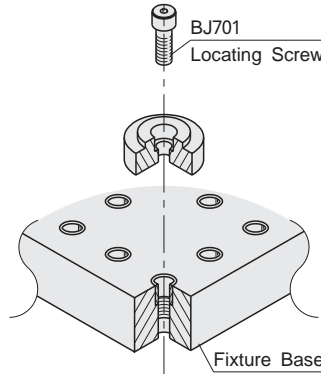
- Double construction for locating and fastening in one operation: alignment bushing on top and threaded insert below it .



Thread	A (F7)	B	C	D
M12	12	12.5	15	M12 x 1.75
M16	16	16.5	18	M16 x 2

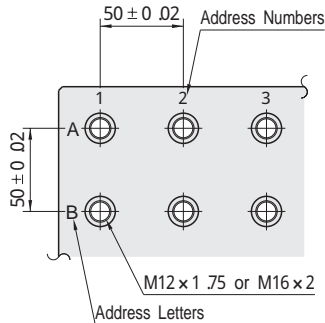
Locating a Component

- Use BJ700 or BJ701 Locating Screws that allow locating and fastening simultaneously .



Hole Spacing & Grid Address System

- MTP holes are spaced every $50\text{mm} \pm 0.02$ on every grid tooling plate and block face .
- On every grid tooling plate and block face , numbers are provided in one direction and letters in the perpendicular direction to assign a grid address to every MTP hole , for easy recording of component mounting hole locations as part of fixturing documentation .

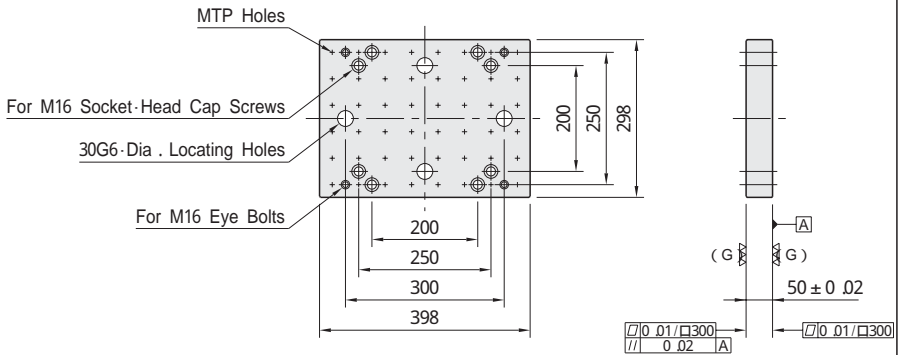


BJ010(Standard&Heavy) RECTANGULAR GRID PLATES

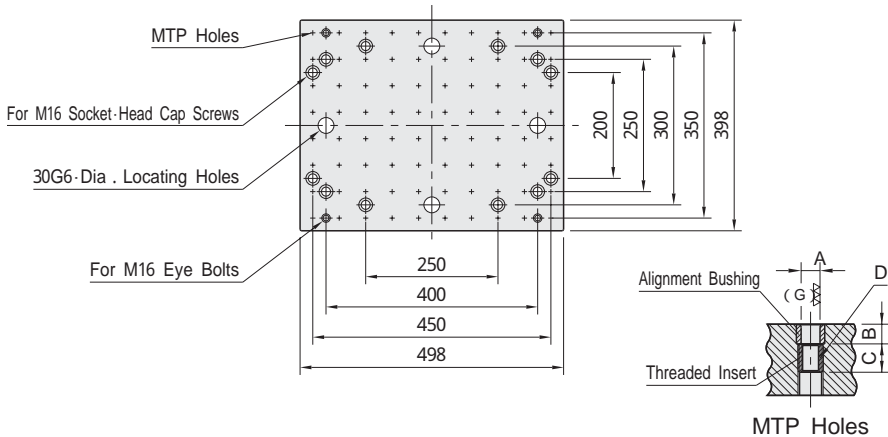


- [Body]
Material:FC250 cast iron
Annealed
Precision ground
- [Alignment Bushing]
Material:SUJ2 steel
Heat treated
- [Threaded Insert]
Material:S45C steel
Heat treated

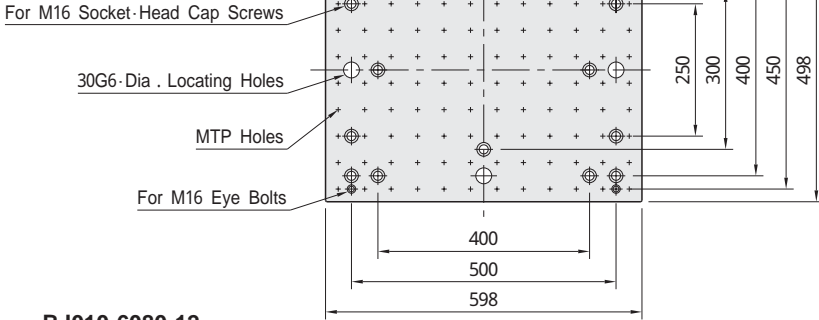
BJ010-3040-12



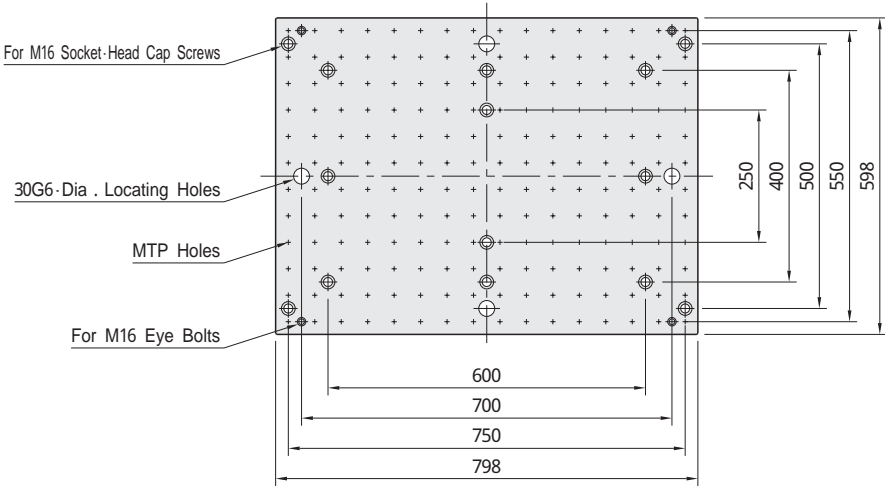
BJ010-4050-12 BJ010-4050-16



BJ010-5060-12
BJ010-5060-16



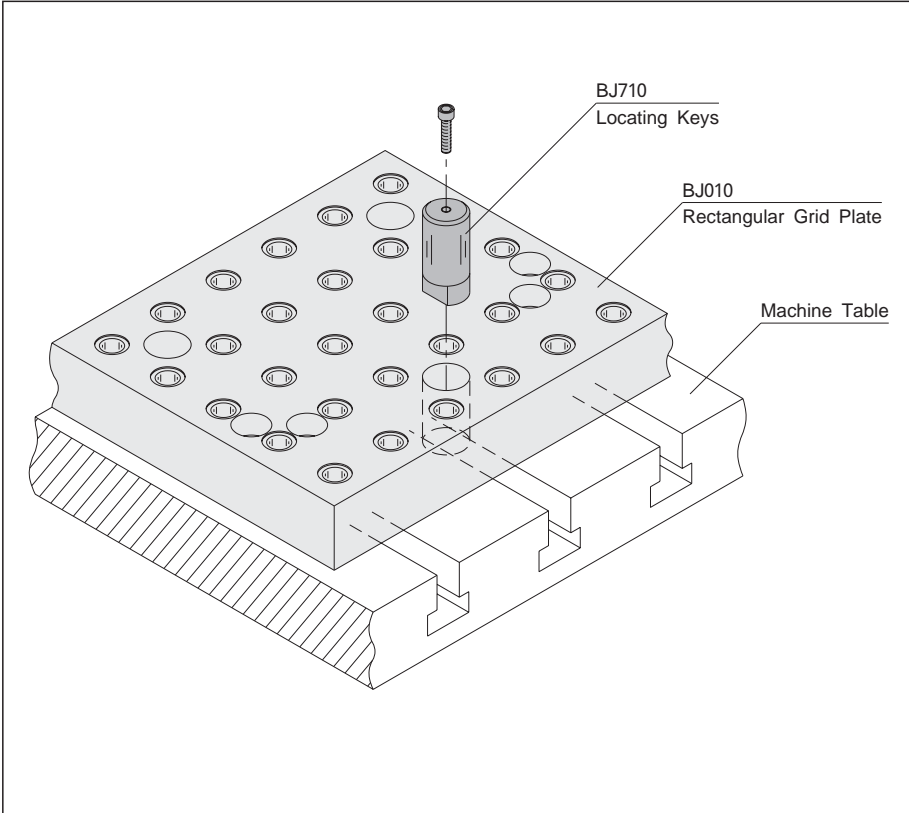
BJ010-6080-12
BJ010-6080-16



Part Number	A (F7)	B	C	D	No. of MTP Holes	No. of Mounting Holes	Weight (kg)
BJ010-3040-12	12	12.5	15	M12 x 1.75	48	8	40
BJ010-4050-12	12	12.5	15	M12 x 1.75	80	12	67
BJ010-4050-16	16	16.5	18	M16 x 2			64
BJ010-5060-12	12	12.5	15	M12 x 1.75	120	16	101
BJ010-5060-16	16	16.5	18	M16 x 2			98
BJ010-6080-12	12	12.5	15	M12 x 1.75	192	14	164
BJ010-6080-16	16	16.5	18	M16 x 2			157

- MTP-hole protection plugs and eye bolts are included.
- Every MTP hole is marked with an address number and letter.
- MTP holes spacing : 50±0.02mm

How To Locate On Machine Table



Locate on the machine table using BJ710 Locating Keys .

BJ040(Standard&Heavy) SQUARE GRID PLATES



[Body]

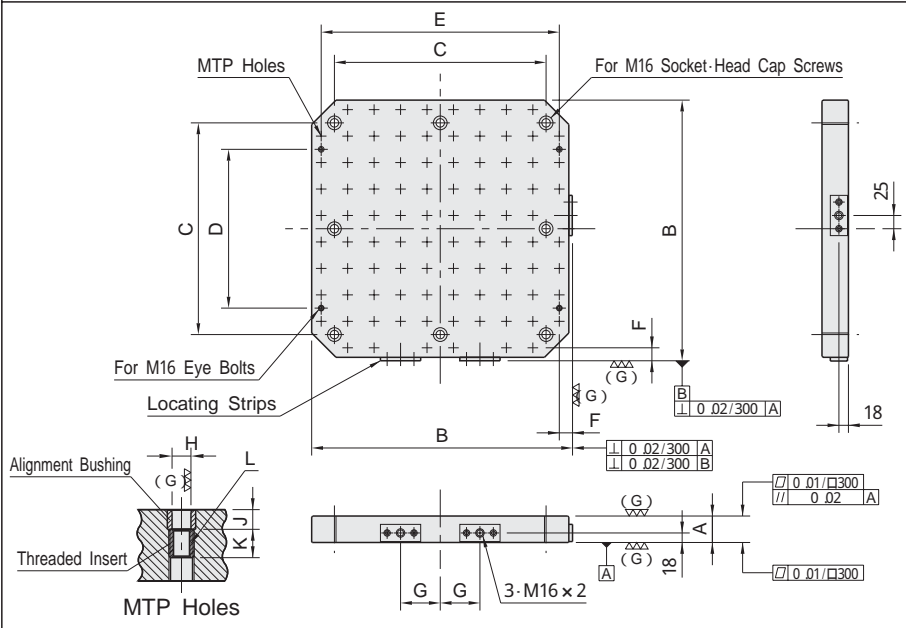
Material:FC250 cast iron
Annealed
Precision ground

[Alignment Bushing]

Material:SUJ2 steel
Heat treated

[Threaded Insert]

Material:S45C steel
Heat treated



Part Number	Pallet Size	A (± 0.02)	B	C	D	E	F (± 0.04)	G	H (F7)	J	K	L	No. of MTP Holes	No. of Mounting Holes	Weight (kg)
BJ040-4040-12	400	50	393	320	200	350	25	55	12	12.5	15	M12 x 1.75	59	4	53
BJ040-4040-16									16	16.5	18	M16 x 2			51
BJ040-5050-12	500	50	493	400	300	450	25	75	12	12.5	15	M12 x 1.75	93	8	82
BJ040-5050-16									16	16.5	18	M16 x 2			79
BJ040-6363-12	630	50	623	500	400	550	40	100	12	12.5	15	M12 x 1.75	139	8	132
BJ040-6363-16									16	16.5	18	M16 x 2			128
BJ040-8080-12	800	60	793	640	500	750	25	135	12	12.5	15	M12 x 1.75	237	8	253
BJ040-8080-16									16	16.5	18	M16 x 2			244

- MTP-hole protection plugs and eye bolts are included.
- Every MTP hole is marked with an address number and letter.
- MTP holes spacing : $50 \pm 0.02\text{mm}$

Modular
Fixture Bases

Blank
Fixture Bases

Quick-Change
Fixture Bases

Standard
Fixture Parts

Modular
Fixture Parts

One-Touch
Clamps

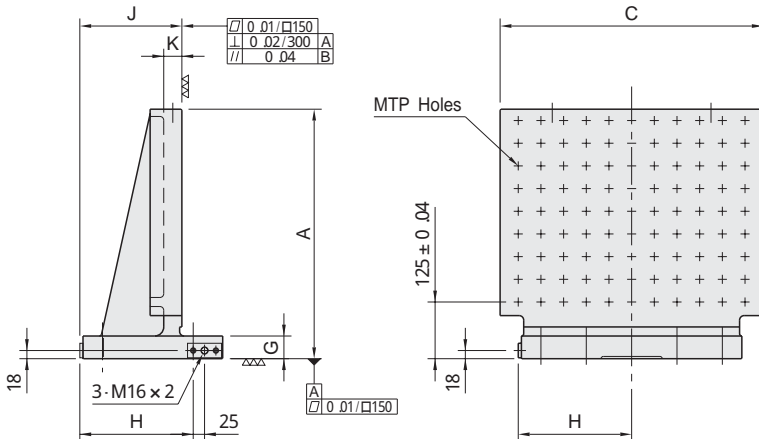
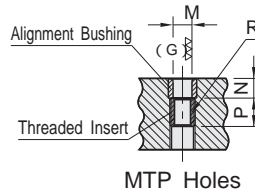
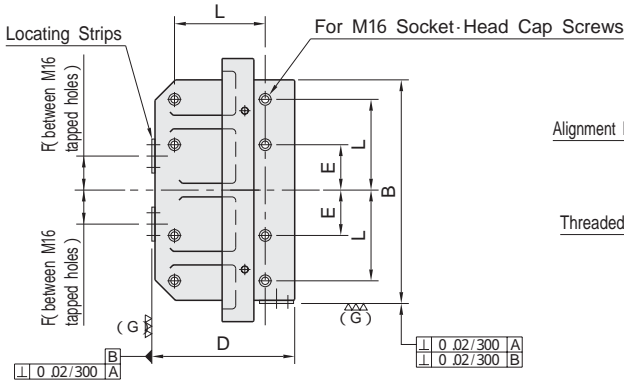
BJ050(Standard&Heavy) ANGLE GRID PLATES



[Body]
Material:FC300 cast iron
Annealed
Precision machined

[Alignment Bushing]
Material:SUJ2 steel
Heat treated

[Threaded Insert]
Material:S45C steel
Heat treated



Part Number	Pallet Size	A	B	C	D	E	F	G	H (± 0.04)	J (± 0.04)	K	L
BJ050-4101-12	400	450	393	470	265	-	55	45	200	175	40	160
BJ050-4101-16												
BJ050-5101-12	500	550	493	580	315	100	75	50	250	225	40	200
BJ050-5101-16												
BJ050-6101-12	630	700	623	760	380	125	100	55	315	265	50	250
BJ050-6101-16												
BJ050-8101-12	800	800	793	900	465	160	135	60	400	350	50	320
BJ050-8101-16												

Part Number	M (F7)	N	P	R	No. of MTP Holes	No. of Mounting Holes	Weight (kg)
BJ050-4101-12	12	12.5	15	M12 x 1.75	63	4	95
BJ050-4101-16	16	16.5	18	M16 x 2			94
BJ050-5101-12	12	12.5	15	M12 x 1.75	99	8	157
BJ050-5101-16	16	16.5	18	M16 x 2			154
BJ050-6101-12	12	12.5	15	M12 x 1.75	180	8	303
BJ050-6101-16	16	16.5	18	M16 x 2			298
BJ050-8101-12	12	12.5	15	M12 x 1.75	238	8	457
BJ050-8101-16	16	16.5	18	M16 x 2			450

- MTP-hole protection plugs and eye bolts are included.
- Every MTP hole is marked with an address number and letter.
- MTP holes spacing : $50 \pm 0.02\text{mm}$

BJ060/BJ061 (Standard & Heavy) TWO-SIDED GRID BLOCKS



[Body]

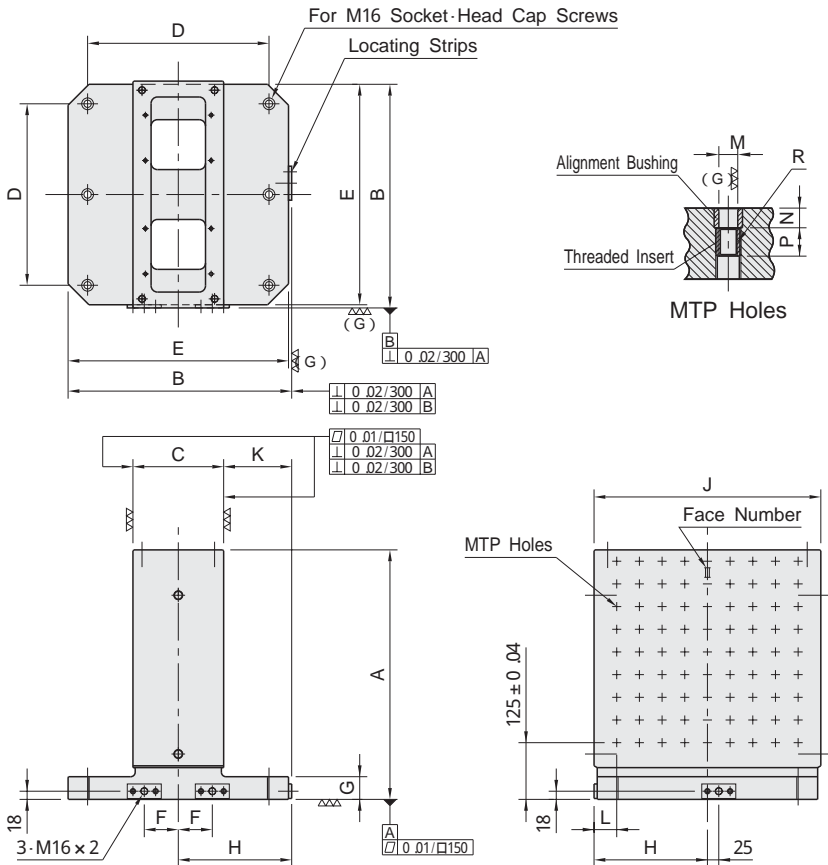
Material: FC300 cast iron
Annealed
Precision machined

[Alignment Bushing]

Material: SUJ2 steel
Heat treated

[Threaded Insert]

Material: S45C steel
Heat treated



Part Number	Pallet Size	A	B	C (± 0.04)	D	E	F	G	H	J	K (± 0.04)	L (± 0.04)
BJ060-4015-12	400	450	393	150	320	386	55	50	200	400	125	50
BJ060-4015-16												
BJ060-5020-12	500	550	493	200	400	486	75	50	250	500	150	50
BJ060-5020-16												
BJ060-6325-12	630	700	623	250	500	616	100	55	315	630	190	65
BJ060-6325-16												
BJ060-8030-12	800	800	793	300	640	786	135	60	400	800	250	50
BJ060-8030-16												
BJ061-4015-12	400	550	393	150	320	386	55	50	200	400	125	50
BJ061-4015-16												
BJ061-5020-12	500	650	493	200	400	486	75	50	250	500	150	50
BJ061-5020-16												
BJ061-6325-12	630	800	623	250	500	616	100	55	315	630	190	65
BJ061-6325-16												

Part Number	M (F7)	N	P	R	No. of MTP Holes	No. of Mounting Holes	Weight (kg)
BJ060-4015-12	12	12.5	15	M12 x 1.75	98	4	153
BJ060-4015-16	16	16.5	18	M16 x 2			150
BJ060-5020-12	12	12.5	15	M12 x 1.75	162	6	253
BJ060-5020-16	16	16.5	18	M16 x 2			251
BJ060-6325-12	12	12.5	15	M12 x 1.75	264	6	473
BJ060-6325-16	16	16.5	18	M16 x 2			465
BJ060-8030-12	12	12.5	15	M12 x 1.75	420	6	684
BJ060-8030-16	16	16.5	18	M16 x 2			672
BJ061-4015-12	12	12.5	15	M12 x 1.75	126	4	179
BJ061-4015-16	16	16.5	18	M16 x 2			176
BJ061-5020-12	12	12.5	15	M12 x 1.75	198	6	287
BJ061-5020-16	16	16.5	18	M16 x 2			285
BJ061-6325-12	12	12.5	15	M12 x 1.75	308	6	528
BJ061-6325-16	16	16.5	18	M16 x 2			513

- MTP-hole protection plugs and eye bolts are included.
- Every MTP hole is marked with an address number and letter.
- MTP holes spacing : $50 \pm 0.02\text{mm}$

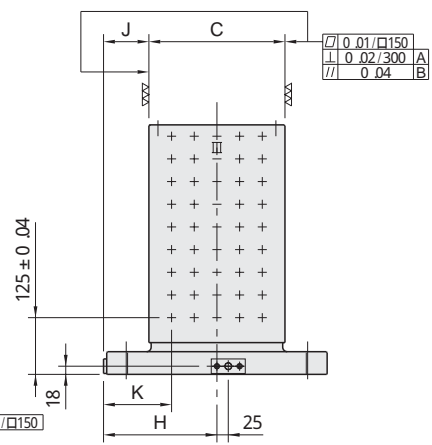
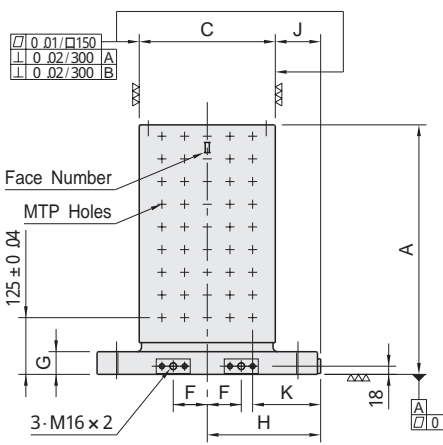
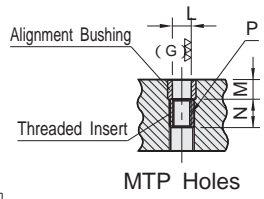
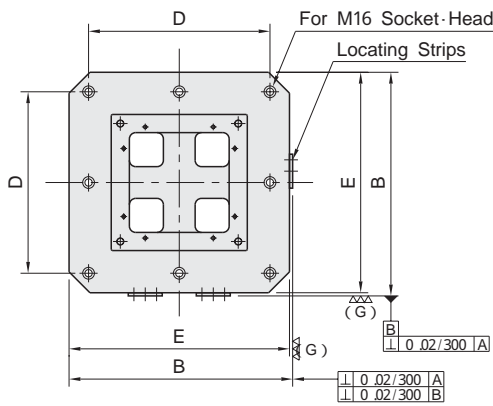
BJ070/BJ071(Standard&Heavy) FOUR-SIDED GRID BLOCKS



[Body]
Material:FC300 cast iron
Annealed
Precision machined

[Alignment Bushing]
Material:S45C steel
Heat treated

[Threaded Insert]
Material:S45C steel
Heat treated



Part Number	Pallet Size	A	B	C (± 0.04)	D	E	F	G	H	J (± 0.04)	K (± 0.04)
BJ070-4025-12	400	450	393	250	320	386	55	50	200	75	125
BJ070-4025-16											
BJ070-5030-12	500	550	493	300	400	486	75	50	250	100	150
BJ070-5030-16											
BJ070-6335-12	630	700	623	350	500	616	100	55	315	140	190
BJ070-6335-16											
BJ070-8050-12	800	800	793	500	640	786	135	60	400	150	200
BJ070-8050-16											
BJ071-4025-12	400	550	393	250	320	386	55	50	200	75	125
BJ071-4025-16											
BJ071-5030-12	500	650	493	300	400	486	75	50	250	100	150
BJ071-5030-16											
BJ071-6335-12	630	800	623	350	500	616	100	55	315	140	190
BJ071-6335-16											

Part Number	L (F7)	M	N	P	No. of MTP Holes	No. of Mounting Holes	Weight (kg)
BJ070-4025-12	12	12.5	15	M12 x 1.75	112	4	149
BJ070-4025-16	16	16.5	18	M16 x 2			148
BJ070-5030-12	12	12.5	15	M12 x 1.75	180	8	232
BJ070-5030-16	16	16.5	18	M16 x 2			229
BJ070-6335-12	12	12.5	15	M12 x 1.75	288	8	381
BJ070-6335-16	16	16.5	18	M16 x 2			377
BJ070-8050-12	12	12.5	15	M12 x 1.75	504	8	627
BJ070-8050-16	16	16.5	18	M16 x 2			613
BJ071-4025-12	12	12.5	15	M12 x 1.75	144	4	172
BJ071-4025-16	16	16.5	18	M16 x 2			170
BJ071-5030-12	12	12.5	15	M12 x 1.75	220	8	262
BJ071-5030-16	16	16.5	18	M16 x 2			258
BJ071-6335-12	12	12.5	15	M12 x 1.75	336	8	418
BJ071-6335-16	16	16.5	18	M16 x 2			411

- MTP-hole protection plugs and eye bolts are included.
- Every MTP hole is marked with an address number and letter.
- MTP holes spacing : $50 \pm 0.02\text{mm}$

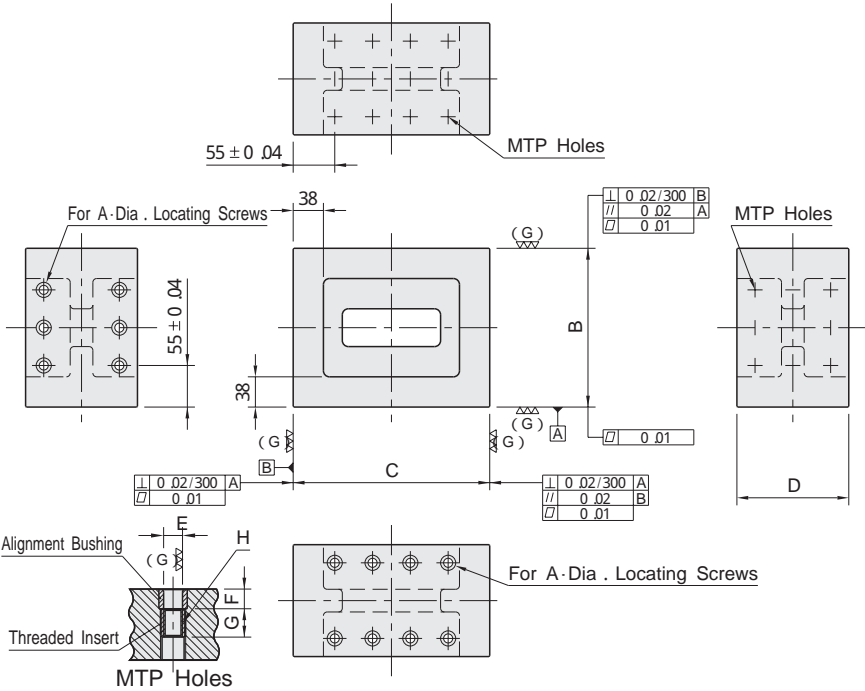
BJ090(Standard&Heavy) RISER BLOCKS



[Body]
 Material:FC300 cast iron
 Annealed
 Precision ground

[Alignment Bushing]
 Material:SUJ2 steel
 Heat treated

[Threaded Insert]
 Material:S45C steel
 Heat treated



Part Number	A (F7)	B ± 0.02	C ± 0.02	D	E (F7)	F	G	H	No. of MTP Holes	No. of Mounting Holes	Proper Locating Screws	Weight (kg)
BJ090-1621-12	12	160	210	148	12	12.5	15	M12x1.75	15	10	BJ700-12065	26
BJ090-2126-12		210	260						21	14		37
BJ090-1621-16	16	160	210	148	16	16.5	18	M16x2	15	10	BJ700-16075	25
BJ090-2126-16		210	260						21	14		36

- MTP-hole protection plugs and eye bolts are included.
- Locate on a tooling plate or block using BJ700 Locating Screws.
- MTP holes spacing : $50 \pm 0.02\text{mm}$

Modular
Fixture Bases

Blank
Fixture Bases

Quick-Change
Fixture Bases

Standard
Fixture Parts

Modular
Fixture Parts

One-Touch
Clamps

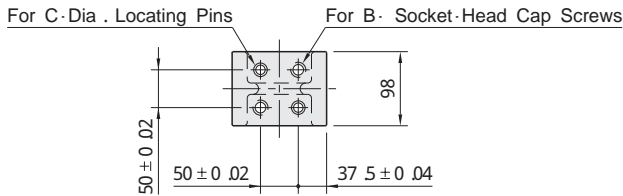
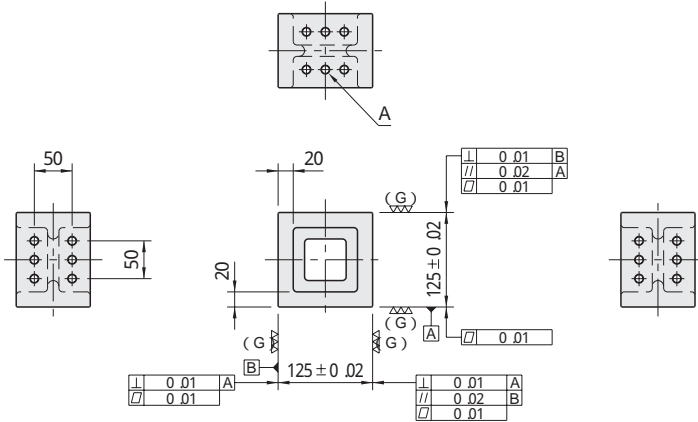
BJ091(Standard&Heavy) COMPACT RISER BLOCKS



[Body]
 Material:FC300 cast iron
 Annealed
 Precision ground

[Alignment Bushing]
 Material:SUJ2 steel
 Heat treated

[Threaded Insert]
 Material:S45C steel
 Heat treated



Part Number	A	B	C (F7)	Weight (kg)
BJ091-12125	M12 x 1.75	M12	12	6.3
BJ091-16125	M16 x 2	M16	16	6.2

•Locate on a tooling plate or block using a round pin and a diamond pin.

Modular
Fixture Bases

Blank
Fixture Bases

Quick-Change
Fixture Bases

Standard
Fixture Parts

Modular
Fixture Parts

One-Touch
Clamps

BJ092

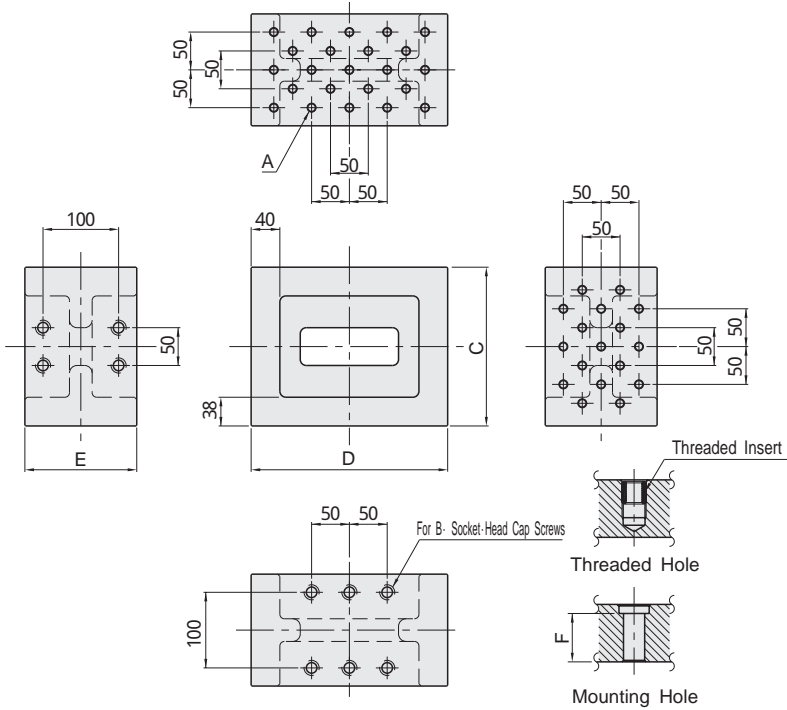
RISER BLOCKS (Rough-finish Machined)

NEW

[Body]

Material:FC300 cast iron
Annealed

[Thread Insert]

Material:S45C steel
Heat Treated

Part Number	A	B	C ($+0.5$ $+0.2$)	D ($+0.5$ $+0.2$)	E	F	No. of Threaded Holes	No. of Mounting Holes	Weight (kg)
BJ092-1621-12	M12 x 1.75	M12	160	210	148	32	30	8	26
BJ092-2126-12			210	260			40	10	37
BJ092-1621-16	M16 x 2	M16	160	210		35	30	8	25
BJ092-2126-16			210	260			40	10	36

- Use to raise a workpiece or a fixture component part.
- The work-clamping surfaces have some machining allowance left for grinding finish.