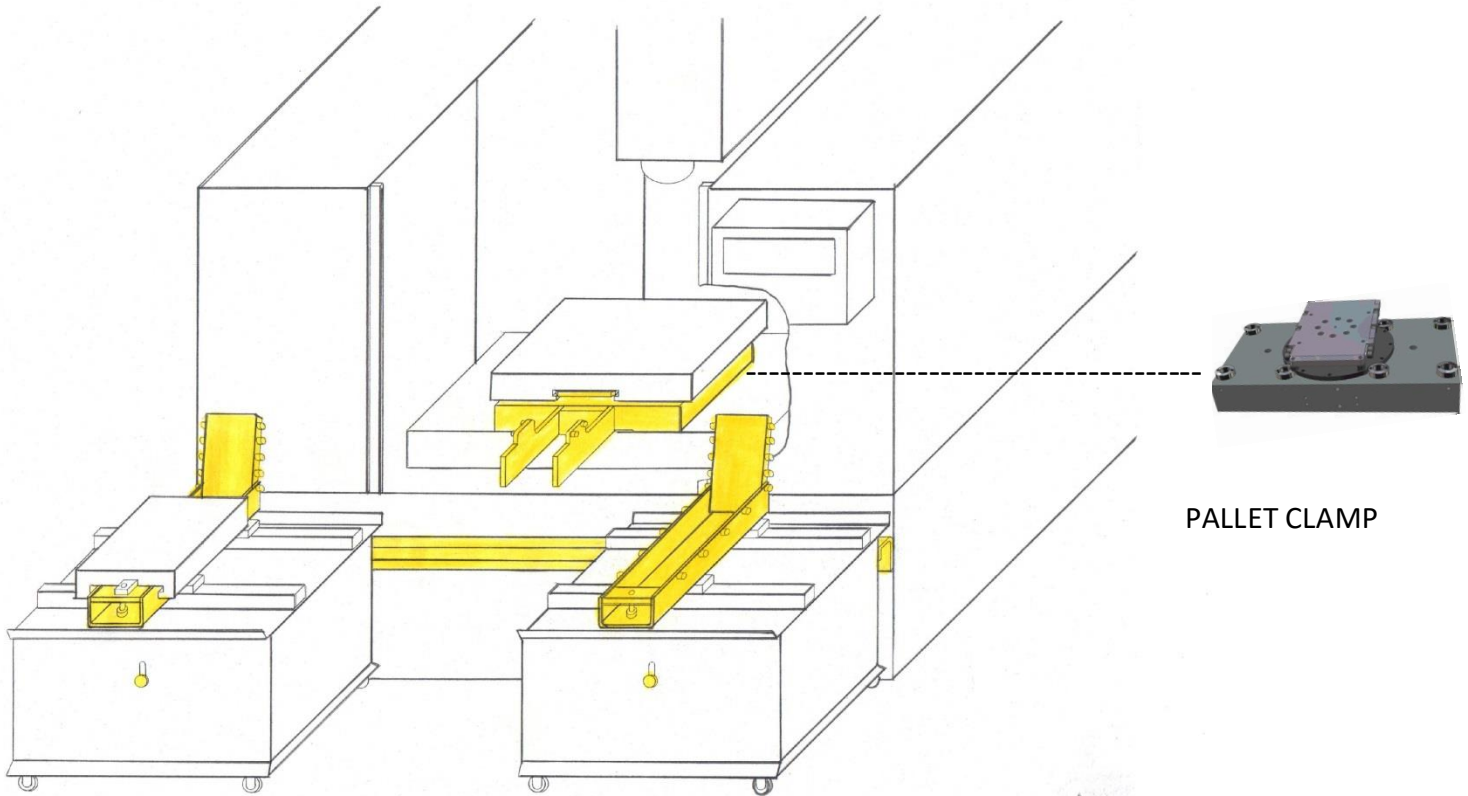


BAYER FLAT PALLET SYSTEM

Setup and work handling can be conducted off machine to save operator and machine time.

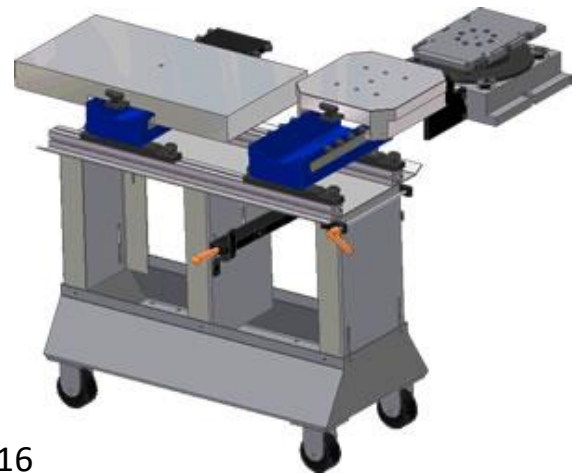
Setups, rotary tables, indexers chucks and angle plates can be stored and transferred to available machines with the greatest of ease.



Pallets are light and mobile.

Multiple parts located on pallets and pallet switching saves tool change and work handling time and increases cycle time to enable the operator to do other things.

GOOD FOR BATCH PRODUCTION



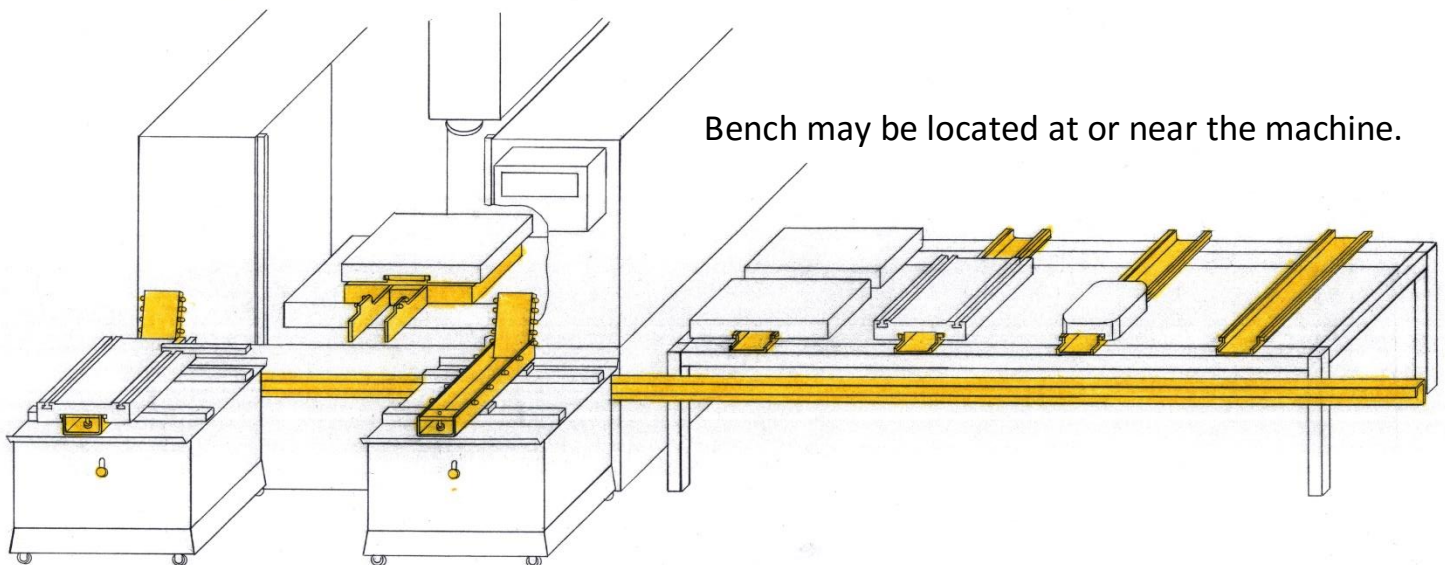
Bayer Systems 5150 N 24TH ST Phoenix, Arizona 85016
www.bayersystems.com

Tel 602-448-9409

STORAGE BENCH

Any number of pallets and setups can be stored on benches and/or carts and transferred to any number of machines.

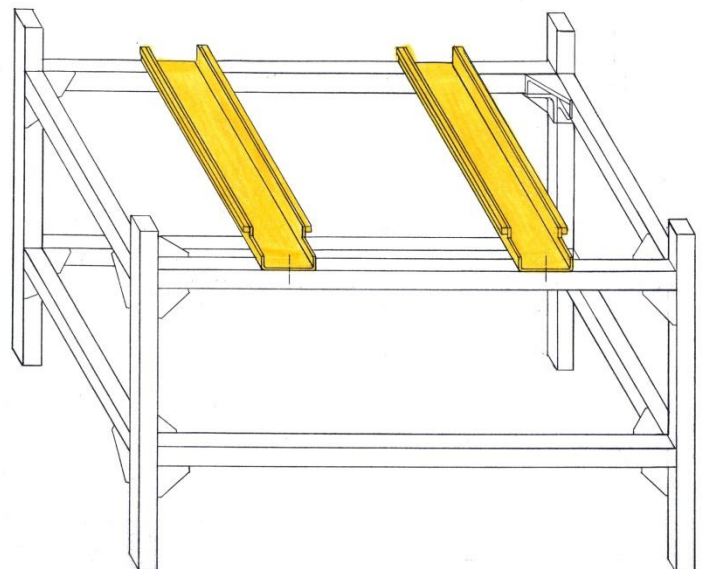
1. This enables setup storage to facilitate batch production.
2. It enables the use of the optimum pallet for the setup.
3. It enables emergency jobs to be machined during production cycles.



The storage bench is made from aluminum profile with T slots on four sides. This enables the height and pallet space to be adjusted. Two pallets that do not exceed 12.6 inch width can be stored on each station.

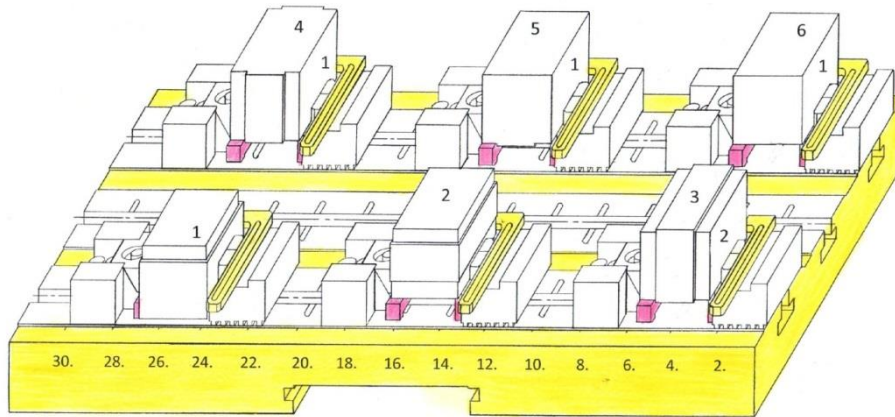
The customer must specify:

1. The number of stations required.
2. The length of the pallets.
3. The guide rail length required if attached to the machining center.



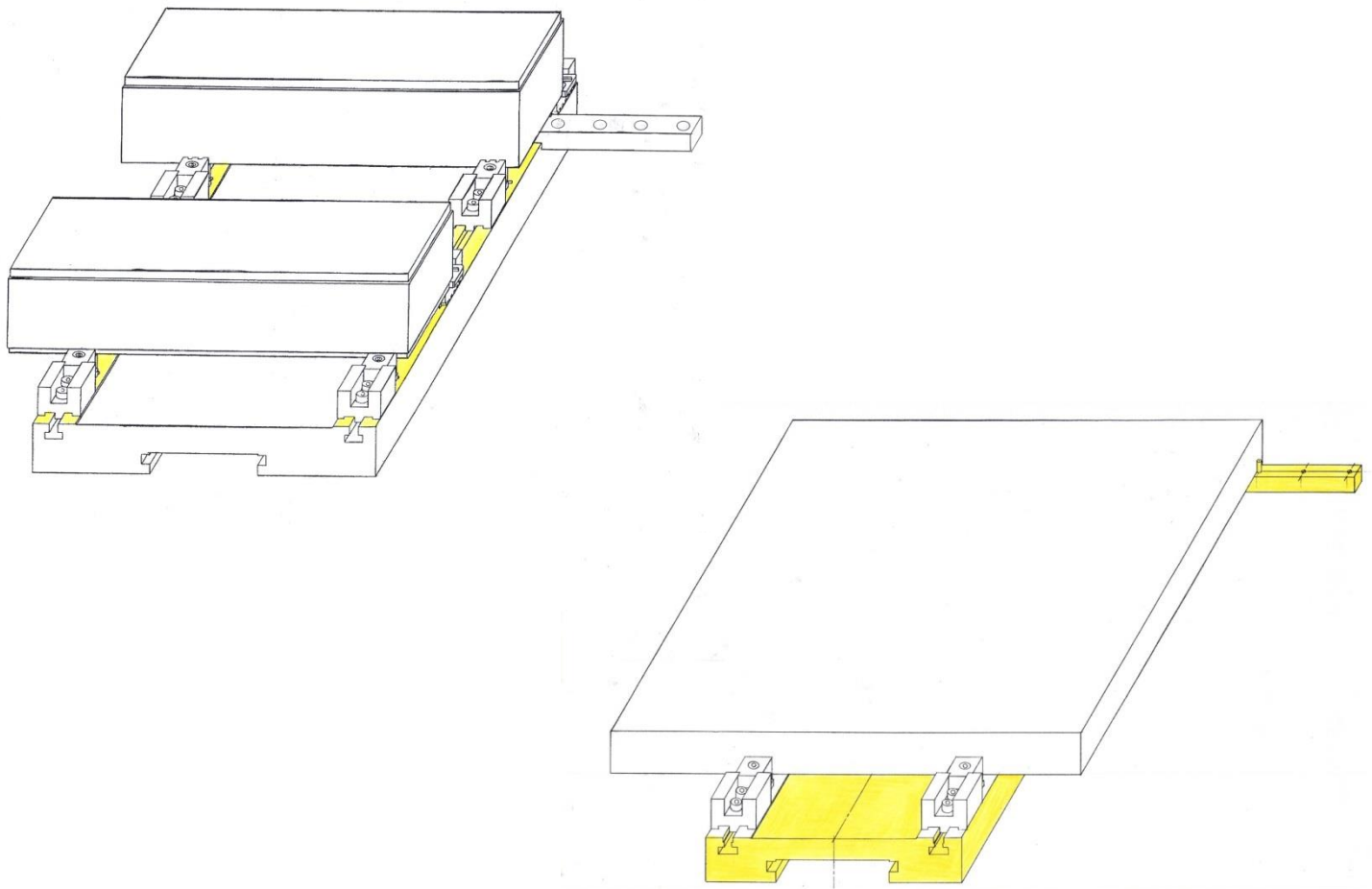
Price on request

This pallet was used to machine six sides of a part.



The Bayer flat pallet system enables any number of such pallets to be stored on carts and transferred to the machine ready for use in seconds.

That is why setup can take seconds, not hours.



PALLET CLAMPS

The eight seat pallet clamp provides end support that is located in the pallet clamp housing.

A four seat pallet can be used on the eight seat pallet clamp.

A long eight seat pallet can be used on a four seat pallet clamp but the rigidity will be less unless end supports are used.

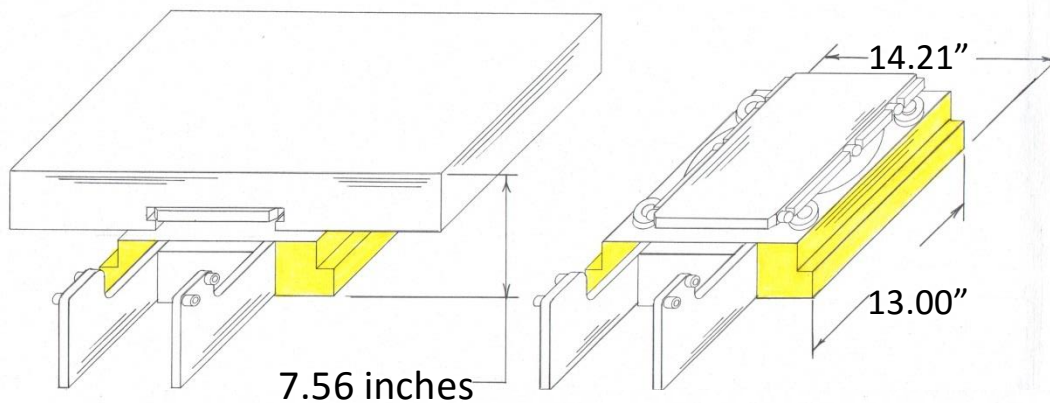
Pallets are clamped by a combination of air and spring pressure.

High velocity air cleans the pallet locating surfaces.

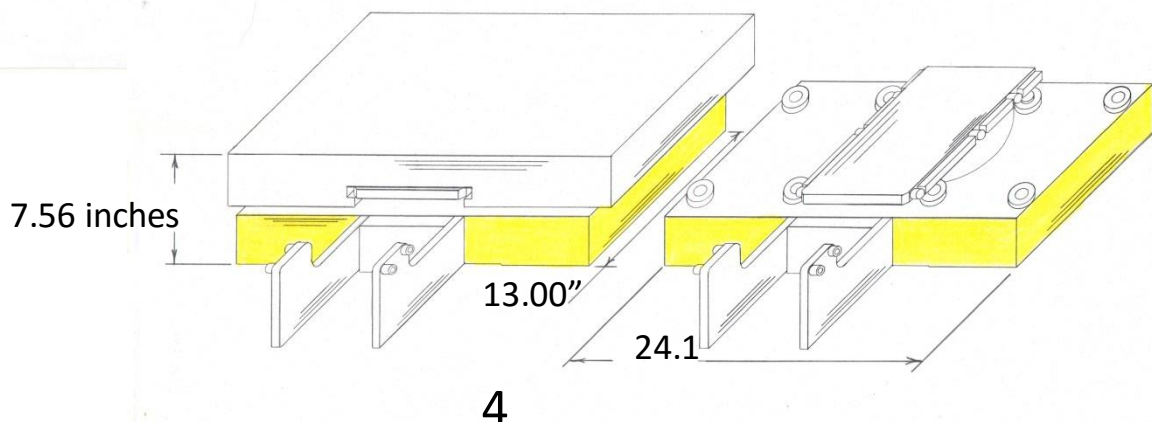
Pallets remain clamped if the air pressure is lost.

The pallet height above the machining center table using a 3.4" inch thick pallet is 7.56 inches.

FOUR SEAT PALLET CLAMP

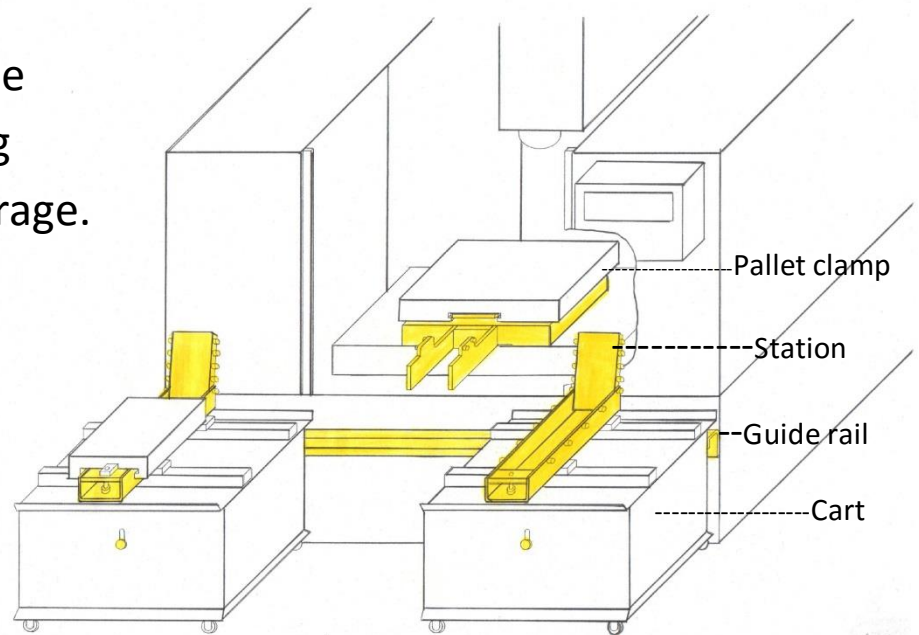


EIGHT SEAT PALLET CLAMP



PALLETS ARE LIGHT AND MOBILE!

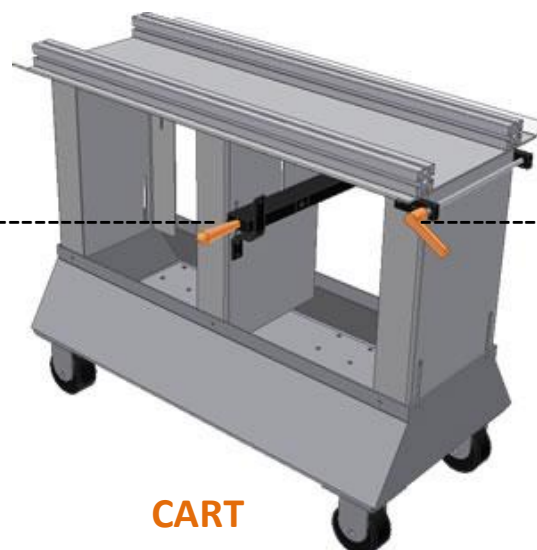
Carts enable off machine setup and work handling and unlimited pallet storage.



A guide rail mounted to the front of the machine is used to locate the carts.

1. Carts are easily attached and detached from this guide rail.
2. Pallets are transferred to and from the pallet clamp and stations located on the cart. One or more stations may be used on the cart.

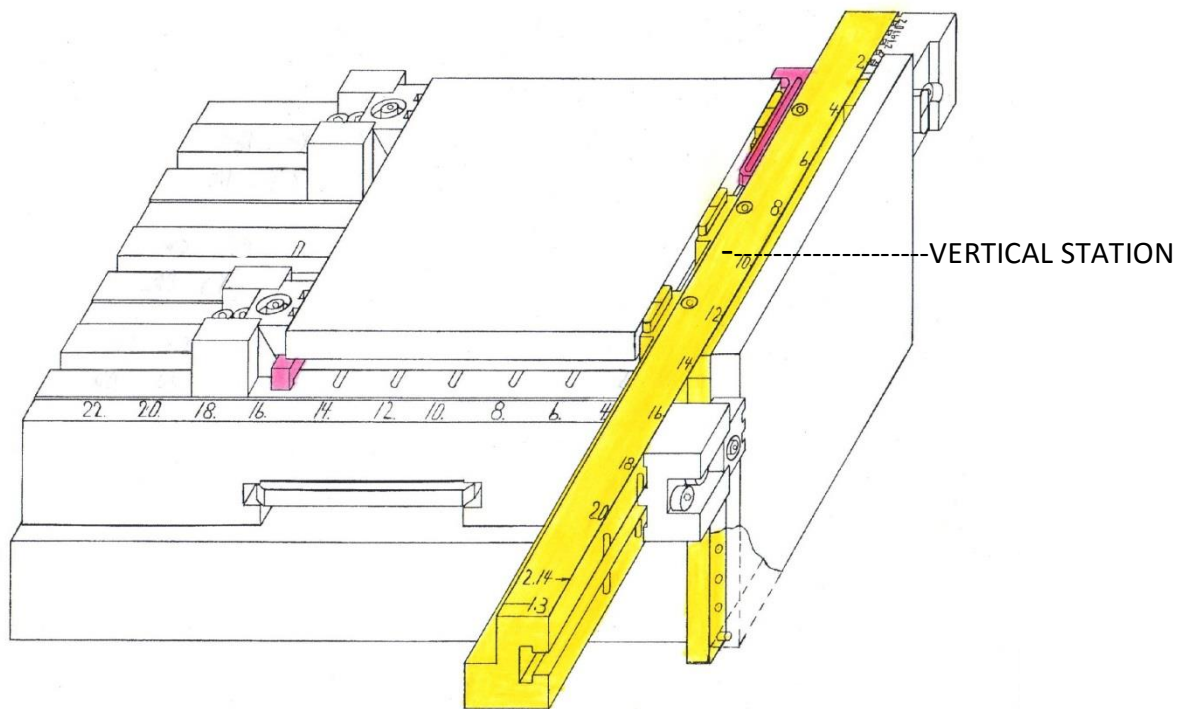
Handle used to attach to the guide rail.



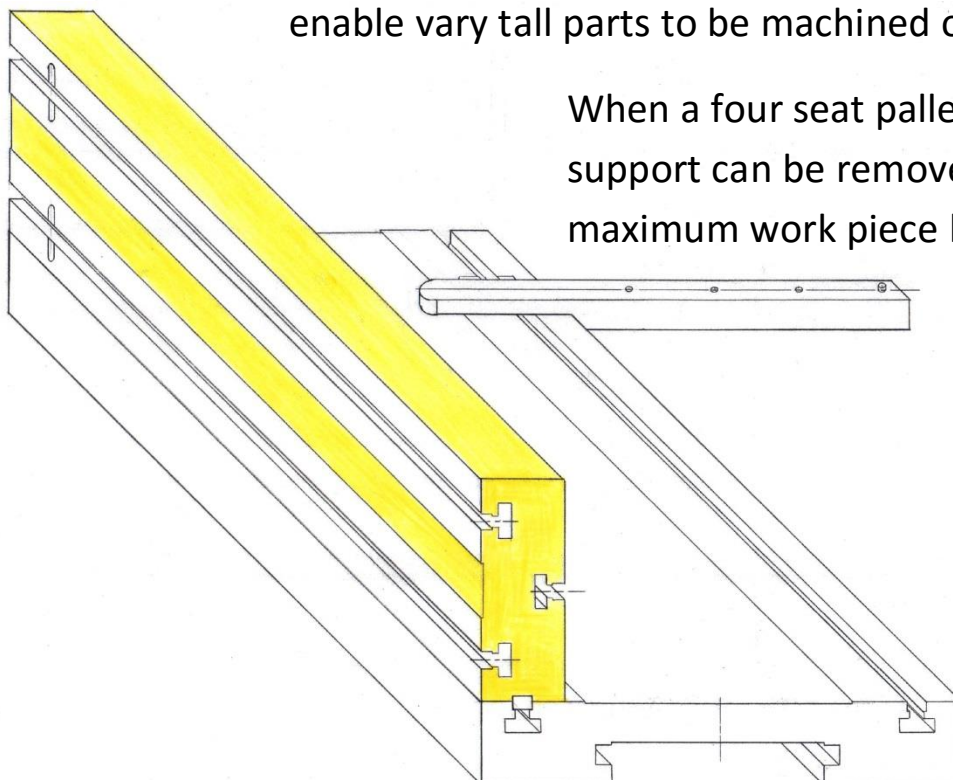
Handle used to locate along the guide rail.

CART

The X flat pallet with a vertical station provides much capability to the mobile pallet system, including the ability to machine the ends of tall parts.



Special vertical stations can be mounted to a Y pallet to enable vary tall parts to be machined on the end.



When a four seat pallet clamp is used, an end support can be removed to provide the maximum work piece height.

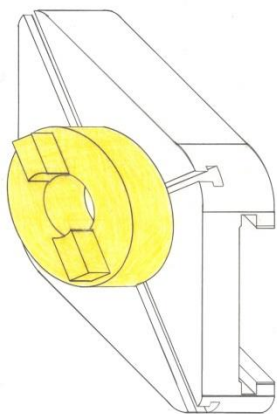
As much as 80% of machining center time is lost during small lot production and 20 % during high production.

Locating fixtures and work holding devices on the machining center contributes much to the set up cost for small lot production.

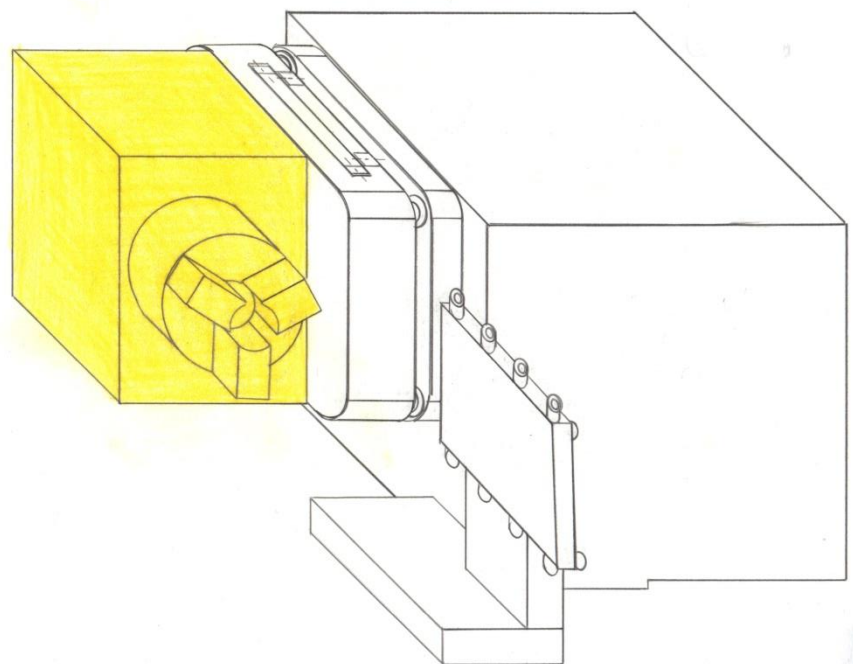
Often a work holding device is only used for a few seconds but locating it on the machine may take much longer.

Fixtures and clamping devices can be located on mobile pallets and stored and ready for use in seconds.

Chucks, rotary tables, indexers, collet clamps and other clamping devices can be mounted to square pallets.



They may be used on either flat pallet clamps or pallet rotary tables.



Good for compound machining.

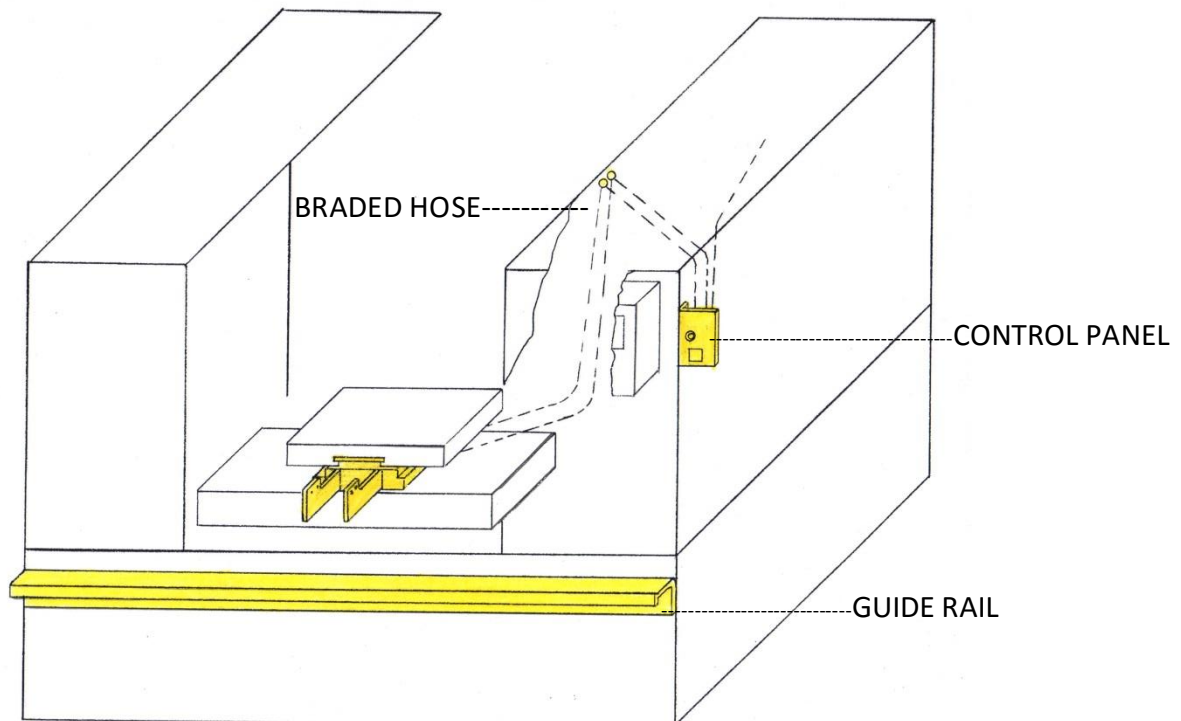
INFORMATION REQUIRED TO ORDER THE FLAT PALLET SYSTEM

1. Specify the distance from the machining center table top to the floor.
2. Specify the distance from the machining center, central tee slot to the inside and outside of the machining center front when the table is positioned full out.
3. Specify the machining center tee slot size.

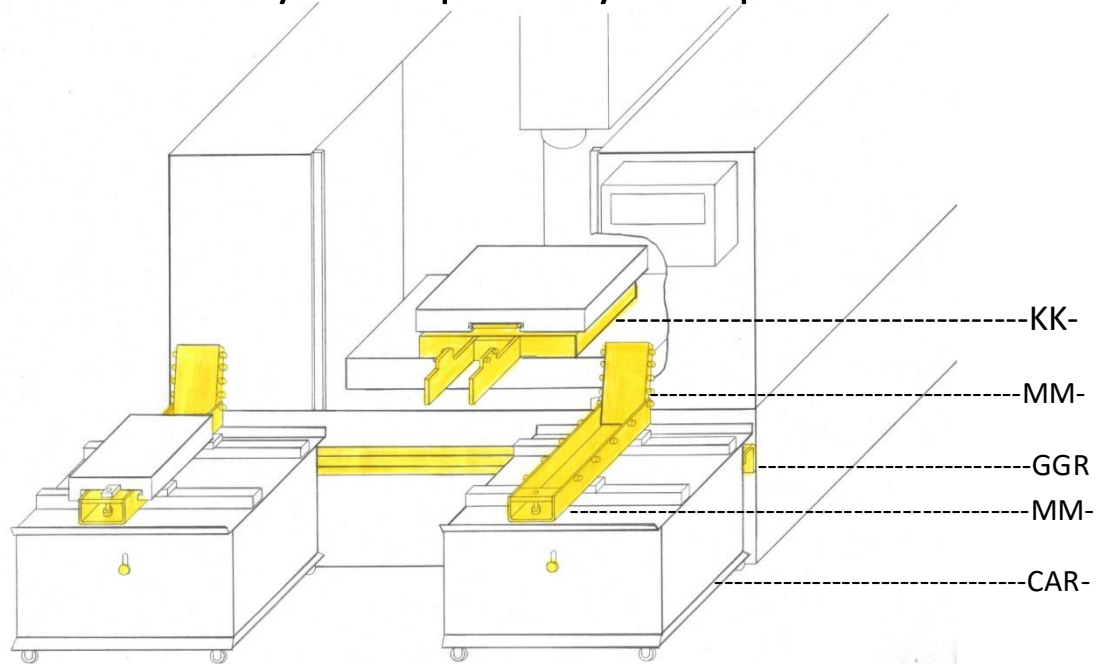
INSTALLATION

THE INSTALLATION CONSISTS OF:

1. Mounting the flat pallet clamp on the machining center table.
2. Mounting the guide rail to the front of the machining center.
3. Mounting the pneumatic control panel to the machine.
4. Routing the air hoses to the various components.



Bayer flat pallet system part numbers.



P/N

NAME

KK4H	FOUR SEAT PALLET CLAMP
ESH	END SUPPORT FOR HIGH FOUR SEAT PALLET CLAMP
KK-8H	EIGHT SEAT PALLET CLAMP
MM-16"	STATION
MM-20"	STATION
MM-24	STATION
GGR	GUIDE RAIL
CCL	CART LOCATER USED ON GUIDE RAIL
CAR-18 X 32	CART
CAR-24 X 32	CART