Glide-Line

Custom Pallet Machining Request Process

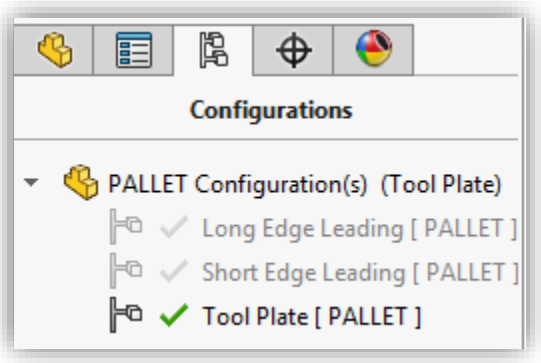
Overview

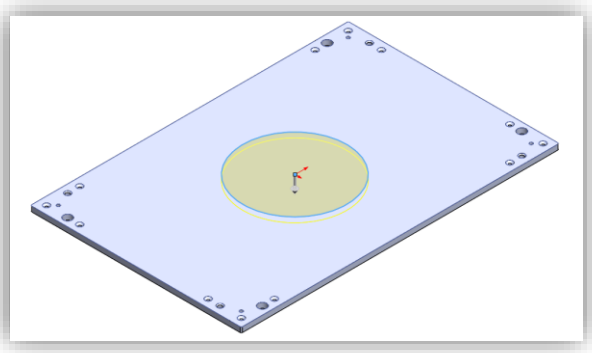
This document is intended to provide customers with a process for submitting custom pallet machining requests.

Process

1. Obtain a SolidWorks part file (*.SLDPRT) of a Glide-Line Workpiece Pallet – this can be done one of two ways:
    a. Using the Glide-Line IMPACT configurator, create and import a pallet model into SolidWorks
    b. Contact a Glide-Line Application Engineer to obtain a pallet model of your desired size
2. Isolate the pallet tool plate by navigating to the Configuration Tree in SolidWorks and selecting Tool Plate configuration. This will remove the additional pallet features (bumpers, hardware, etc) that interfere with our programming. See below for reference:

3. Proceed to modify the Tool Plate configuration of the pallet using SolidWorks' sketch/features tools





4. Save the Tool Plate configuration as a Parasolid (*.X_T) file, and send the file to Glide-Line Applications Engineer
5. In addition to the Parasolid file of the Tool Plate, Glide-Line requires a 2D drawing that specifies all tolerances and special callouts.

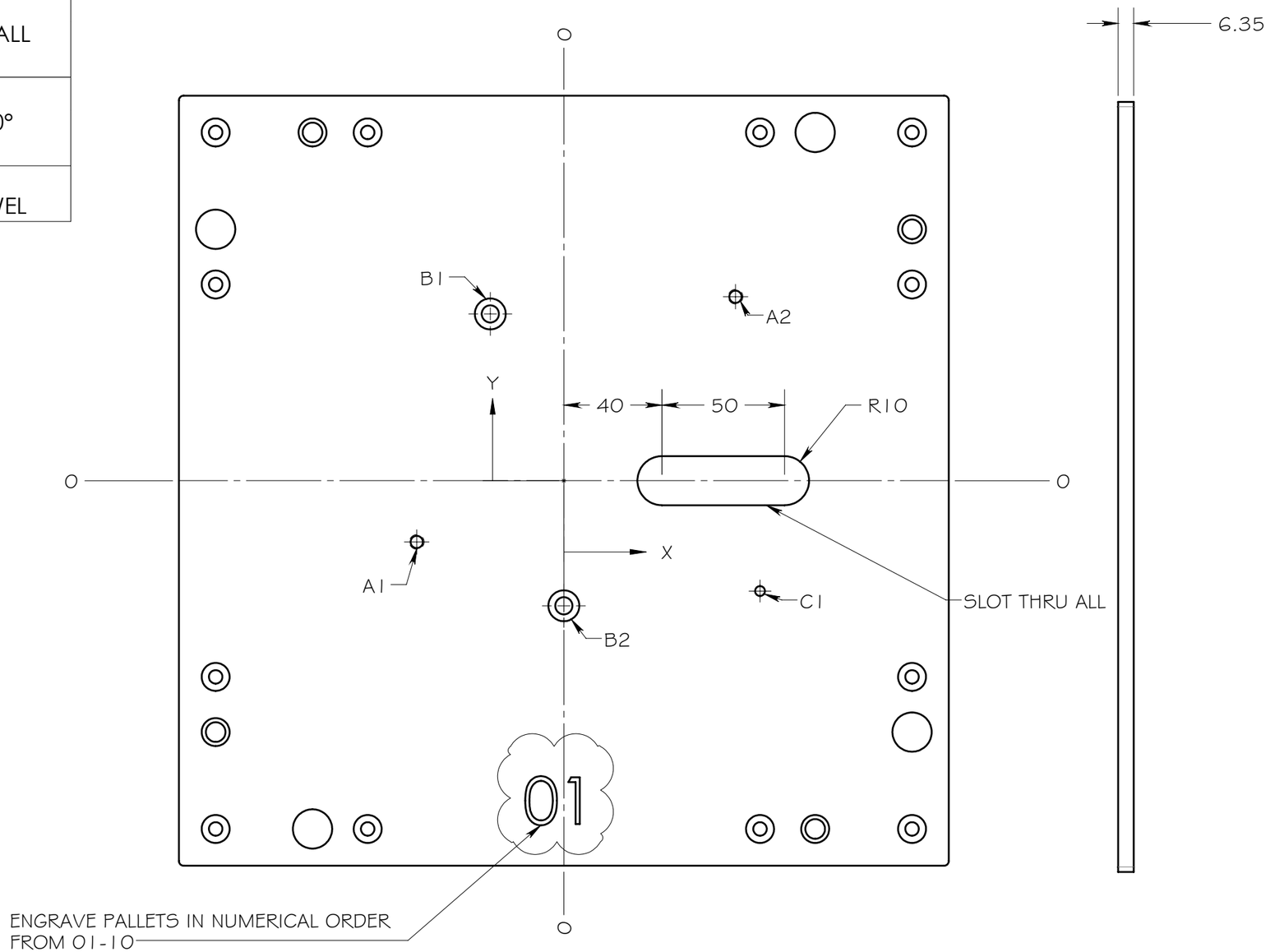
IMPORTANT REMINDERS:

- ✓ Please be sure your datum reference is based on **the exact center of the pallet** to ensure accurate references.
- ✓ Please be sure to specify the number of decimal places in your drawing to prevent any rounding issues.
- ✓ Please be sure any pallet engraving is provided with sequence info and clearly defined.

TAG	X LOC	Y LOC	SIZE
A1	-60	-25	∅ 5 THRU ALL M6X1.0 - 6H THRU ALL
A2	70	75	
B1	-30	68	∅ 7 THRU ALL ⌵ ∅ 12.60 X 90° FOR M6 FHCS
B2	0	-51	
C1	80	-45	∅ 4 THRU ALL PF FOR 4MM DOWEL

PLEASE USE THIS DRAWING AS A GUIDE TO ENSURE CLARITY AND EFFICIENCY FOR BOTH ENGINEERING AND FABRICATION

PLEASE NOTE THAT THE TOLERANCES AND UNITS OF MEASUREMENT USED HERE ARE FOR EXAMPLE PURPOSES. IT IS EXPECTED THAT THE CUSTOMER WILL PROVIDE THE REQUIRED TOLERANCES FOR ANY CUSTOM FEATURES



NOTES:

1. ORIGIN IS LOCATED AT THE CENTER OF THE PALLET TOOL PLATE
2. FEATURES IN CLOUDS ARE TO BE ENGRAVED
3. DIMENSIONS ARE IN MM (OR IN)
4. PLEASE NOTE IF THE PALLET NEEDS FINISHING SUCH AS BUT NOT LIMITED TO CLEAR/BLACK ANODIZING, HEAT TREATMENT, ETC

THIRD ANGLE PROJECTION

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UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IMPERIAL AND TOLERANCES ARE AS FOLLOWS:
FRACTIONAL ± 1/64" OR .4mm
ANG. ± .5°
TWO PLACE ± .01" OR .25mm
THREE PLACE ± .005" OR .125mm
FOUR PLACE ± .0005" OR .0125mm
SURFACE: 64 RMS OR BETTER
DEBURR ALL SHARP EDGES
MAX RADIUS .01" OR .25mm
DO NOT SCALE DRAWING

MANUFACTURING INFORMATION

FABRICATION TYPE: NONE
REQD. MACHINING CAPABILITY: CNC
FORMING REQUIRED: NO
REQUIRES WELDING: NO
USED IN A WELDMENT: NO

[MATERIAL] [FINISH] [HEAT TREAT]

ALUMINUM TOOL AND JIG PLATE

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DESCRIPTION

CUSTOM PALLET EXAMPLE

SIZE	PART NUMBER	REV
B	22P-02952	0

SCALE: 1:2 | WEIGHT: lbs. | SHEET 1 OF 1