

PLT:

The Workpiece Pallet

The Pallet:

Glide-Line™ pallets work as a carrier for work pieces as they move around a conveyor system. Pallets can be tooled with custom fixturing components to secure work pieces as they are handled. Each pallet contains a set of four precision bushings for exact pallet location at each workstation by means of our Lift and Locate Units.

Pallets also include a set of zinc exciter plates on the side and on the bottom of each corner. These plates can be used for pallet detection when used with a proximity sensor.

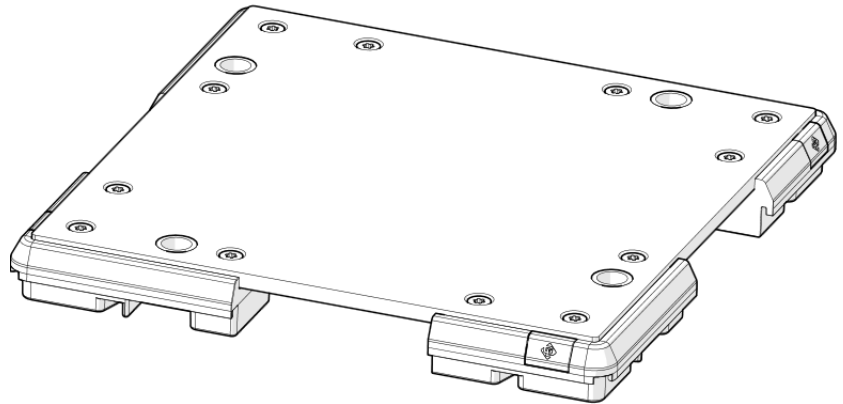
Pallet Bumpers are manufactured from abrasion and impact resistant plastic. Bumpers offer mild chemical resistance, but if custom machining is completed on the pallets, it is recommended bumpers are removed prior to machining.

Current standard pallets offered are:

- 1/4" (6.4mm) thick Tool and Jig Aluminum
- 3/8" (9.5mm) thick Tool and Jig Aluminum
- 1/2" (12.7mm) thick Tool and Jig Aluminum
- 3/4" (19mm) thick Tool and Jig Aluminum

Pallets are provided with no anodize or finish, as it is assumed that secondary processes will be completed by user.

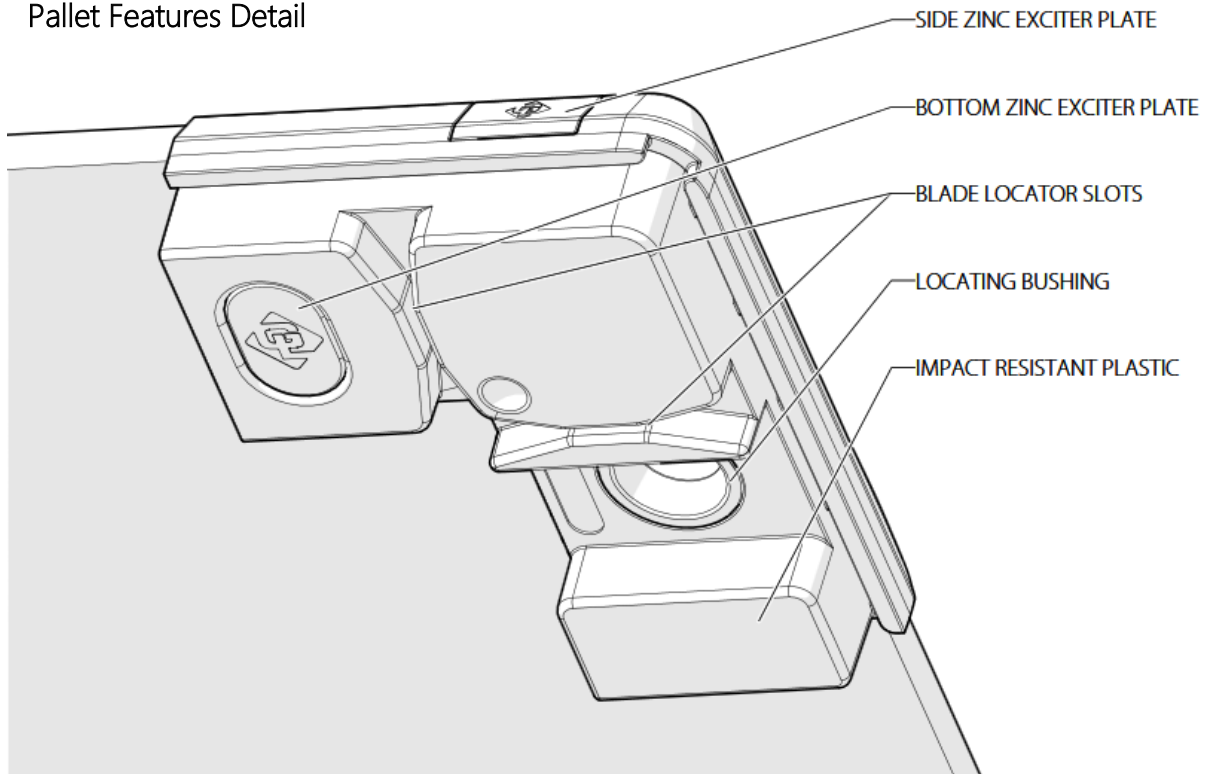
Glide-Line™ is proud to offer custom machining and finishing services for our range of pallets. For our applications department to quote, we will require a preliminary drawing of the requested features, as well as any special finishing specified. Custom features may add to lead times.



Part Number: PLT-(A)-(B)-(C)-(D)-(E)-(F)

- A** = Width as conveyed from 160mm to 1040mm in 1mm increments
- B** = Length as conveyed from 160mm to 1040mm in 1mm increments
- C** = Pallet Thickness in mm
- D** = TJ for Tool and Jig Aluminum Plate; 2B stainless steel plates available upon special request
- E** = SR for Slide Rails between bumpers, NR for no rails
- F** = A fully assembled, -Kit for unassembled kit (no tool plate), -blank for unassembled pallet

Pallet Features Detail

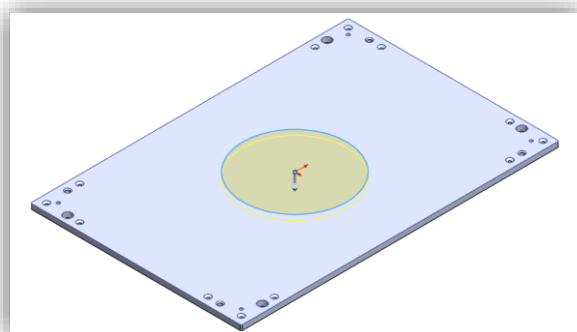
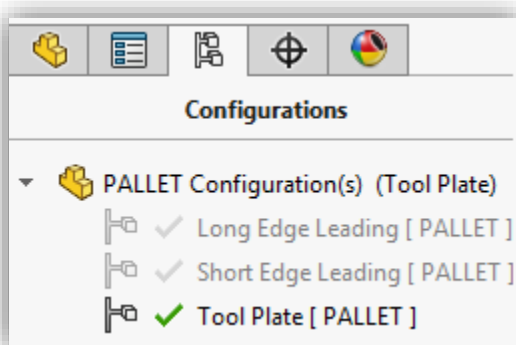


Width (mm)	Length (mm)	Flatness Tolerance (mm)
160	160	0.3
160	240	0.3
160	320	0.3
160	400	0.3
160	480	0.3
240	240	0.3
240	320	0.5
240	400	0.5
240	480	0.5
320	320	0.5
320	400	0.6
320	480	0.6
400	400	0.6
400	480	0.6
480	480	0.8

**Additional pallet sizes and tighter flatness tolerances available upon request*

Custom Pallet Machining Request Process

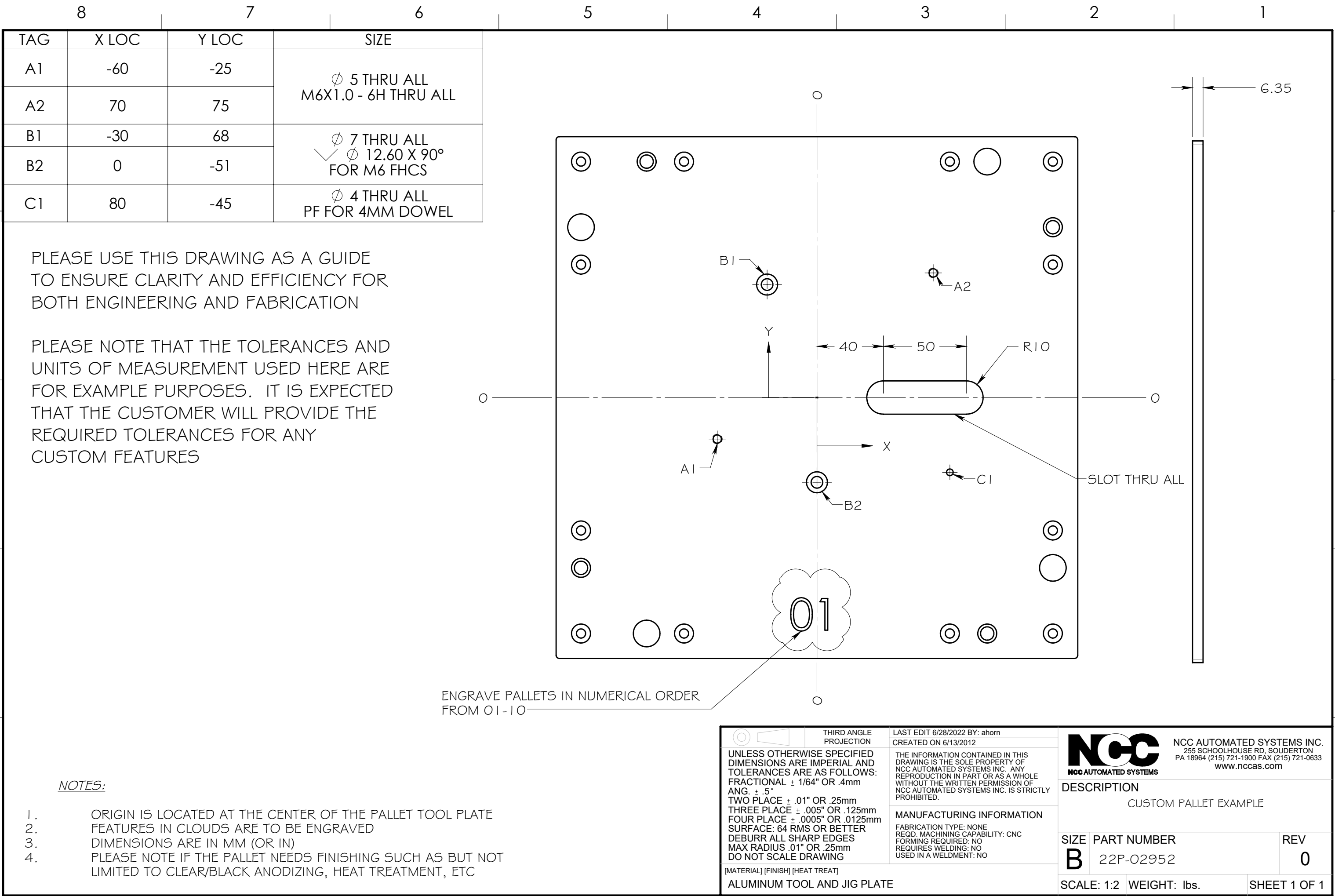
1. Obtain a SolidWorks part file (*.SLDPRT) of a Glide-Line Workpiece Pallet – this can be done one of two ways:
 - a. Using [Glide-Line IMPACT configurator](#), create & import a pallet model into SolidWorks
 - b. Contact a Glide-Line Application Engineer to obtain a pallet model of your desired size
2. Isolate the pallet tool plate by navigating to the Configuration Tree in SolidWorks and selecting Tool Plate configuration:
 - a. 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 callouts
 - a. *Please include a Hole Table for patterns with multiple hole types and quantities
 - b. *Please be sure the datum reference is based on the exact center of the tool plate
 - c. Please be sure to specify the number of decimal places in your drawing to prevent rounding issues
 - d. Please be sure any pallet engraving is provided with clearly defined sequence info

*In the event Glide-Line receives pallet drawings without a Hole Table or an incorrectly placed datum center, additional engineering time will be required to proceed with fabrication.

See below for example drawing with hole location callouts in table as well as all tolerances and special featured labeled.



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

ENGRAVE PALLETS IN NUMERICAL ORDER
FROM 01-10

NOTES:

- ORIGIN IS LOCATED AT THE CENTER OF THE PALLET TOOL PLATE
- FEATURES IN CLOUDS ARE TO BE ENGRAVED
- DIMENSIONS ARE IN MM (OR IN)
- 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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CREATED ON 6/13/2012

THE INFORMATION CONTAINED IN THIS
DRAWING IS THE SOLE PROPERTY OF
NCC AUTOMATED SYSTEMS INC. ANY
REPRODUCTION IN PART OR AS A WHOLE
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MANUFACTURING INFORMATION
FABRICATION TYPE: NONE
REQD. MACHINING CAPABILITY: CNC
FORMING REQUIRED: NO
REQUIRES WELDING: NO
USED IN A WELDMENT: NO

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

[MATERIAL] [FINISH] [HEAT TREAT]
ALUMINUM TOOL AND JIG PLATE

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DESCRIPTION
CUSTOM PALLET EXAMPLE

SIZE
B

PART NUMBER
22P-02952

REV
0

SCALE: 1:2

WEIGHT: lbs.

SHEET 1 OF 1