



FLIP-POD™ Vacuum System

Alu FLIP-POD FLIP-POD

This technology is ideal for

- Milling
- Grinding
- Drilling
- Cutting threads

Mainly for large workpieces made out of

- Wood
- Plastic
- Glass
- Cast metals

Suitable for

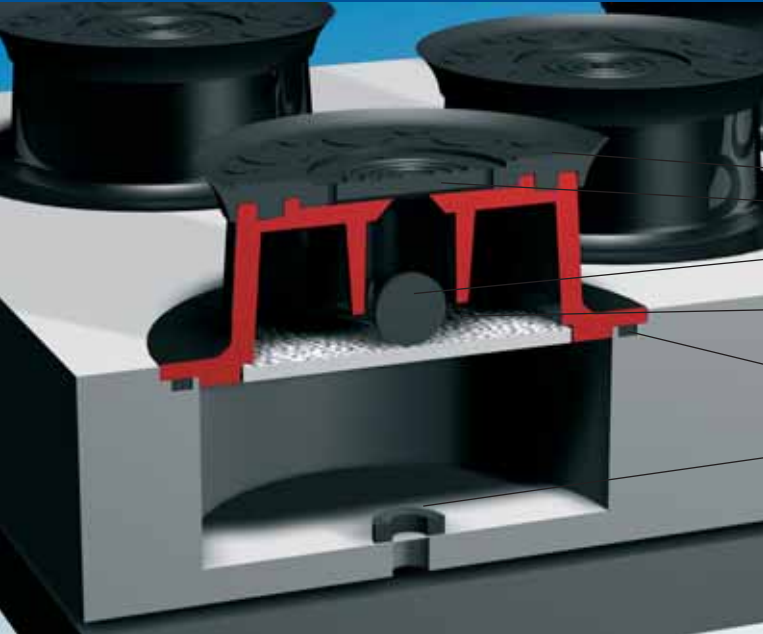
- Milled or rough surfaces.

Advantages

- Strong hold down forces enable the use of large machines.
- Bevels, contours and radii can be performed on the upper and lower workpiece surfaces.
- Clamping dimensions can be changed within seconds to conform to new workpiece sizes
- Can be used on most machine tables.

Handling

- Pods are the contact surfaces for the workpiece
- Simply activate or deactivate the pods by turning them around.
- To clamp a workpiece effectively 6-8 pods are required.
- This modular system can be extended for larger clamping surfaces.



The crosssection shows

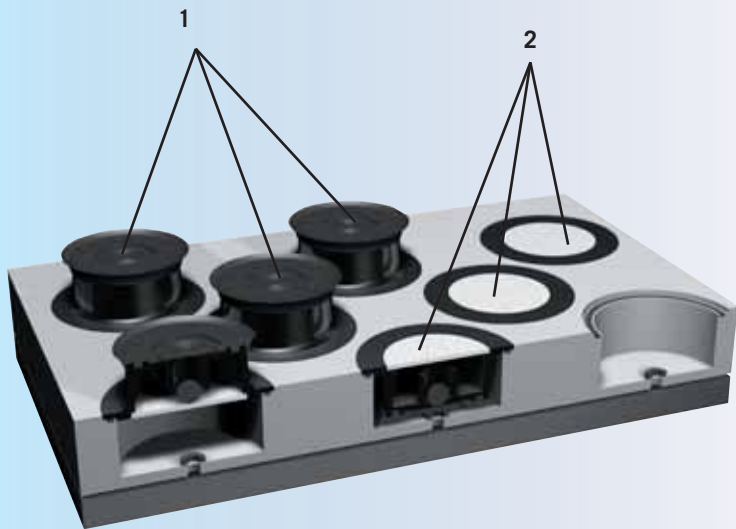
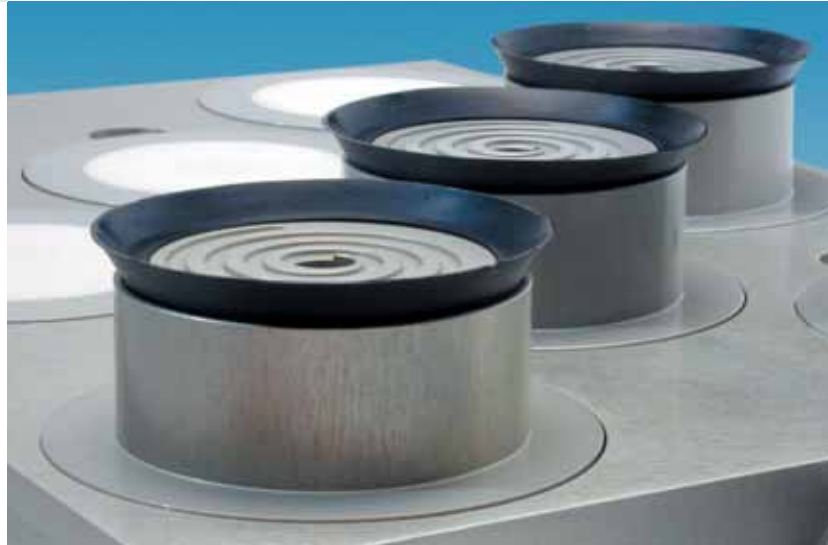
- FP Sucker
- FP Unit
- FP Polymer ball
- and
- FP Filter

In the pod plate you will find

- FP Large gasket
- FP Center hole gasket

Alu FLIP-POD™

has an accurate, defined workpiece surface. Height tolerance is only 50µ. They are suitable for face machining on both surfaces, especially of metallic workpieces.



Function

The round polymer pods (1) protrude out of the pod plate when in use.

The pods not required lie in a recess cavity (2) of the pod plate.

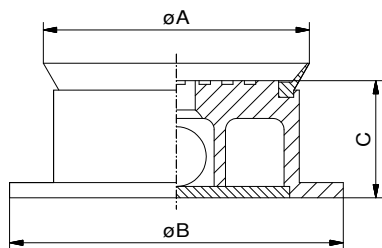
Simply flipping them over activates or deactivates the pods.

The valve ball which stops the vacuum supply when the pod is resting, opens the valve and the vacuum system is activated.

All active pods stand 27mm above the pod plate surface, allowing contour milling and recess cutting on the outer contours.

FP Basic unit

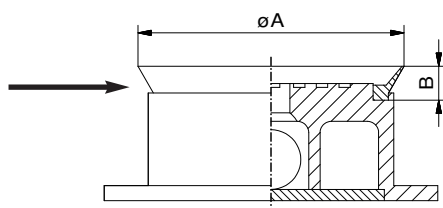
complete



Supply includes:

- FP Seal
- FP Ball
- FP Filter

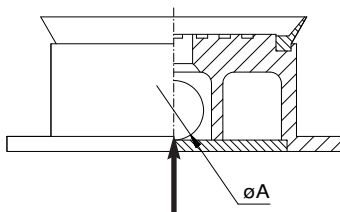
Nr.	A	B	C	Mat	g
84408	70	88	31	Aluminium	170
14384	70	88	31	Polymer	100



FP Seal

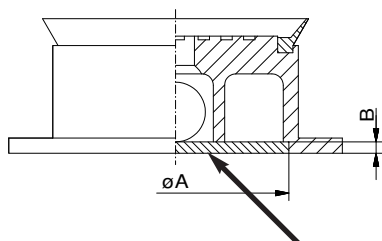
for Alu-Pod

Nr.	A	B	g	g
30584	70	9		6



FP Polymer Ball

Nr.	A			g
12124	15,8			10



FP Filter

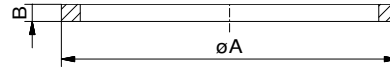
Nr.	A	B		g
12125	61	3		14



FP Large seal

for Pod Plate

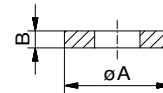
Nr.	A	B		
11395	88	4,5		65



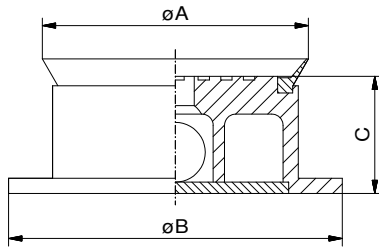
FP Center hole gasket

for pod cavity

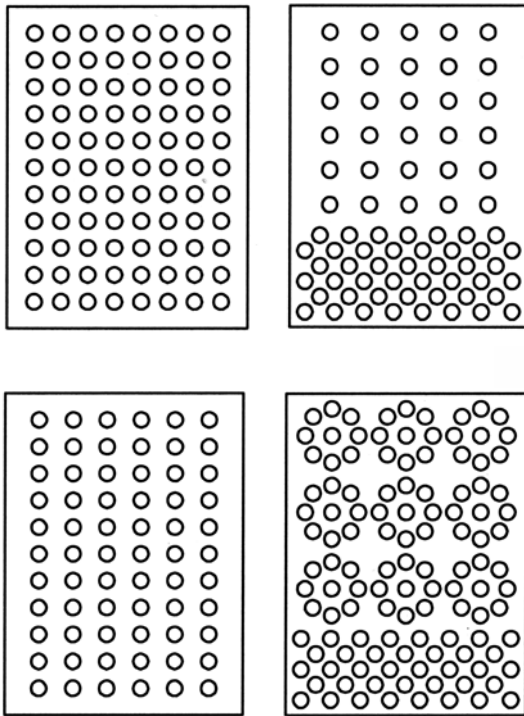
Nr.	A	B		
11394	28	6		1



Pod -Plate, ready for use,
with ALU FLIP-POD™s



The sketches show a range of possible pod panel designs.



The user can choose a panel design that best suits the parts being machined. The pod panel can be laid out in almost any design and combination.

FLIP-POD™ Sets

polymer version

Nr.	Description	Area/Grid	Pods (N)	kg
83100	FLIP-POD™ Set 100	1m ² /100mm	100	10,2
83200	FLIP-POD™ Set 200	2m ² /100mm	200	20,2
83300	FLIP-POD™ Set 300	3m ² /100mm	300	30,2
83400	FLIP-POD™ Set 400	4m ² /100mm	400	40,2

Supply includes:

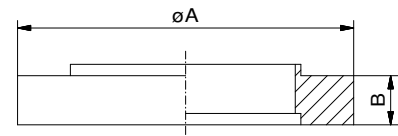
- Basic unit with lip seal
- FP Center hole gasket
- FP Large seal
- 3 Retractable locator pod
- 2 Fixed locator pods



FP Lift ring

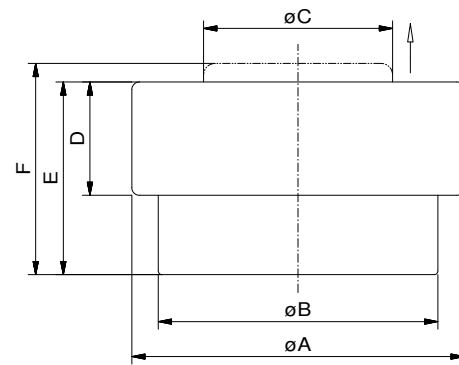
1/2"

Nr.	A	B		
11396	88,5	12,7		65



FP Transfer Pod

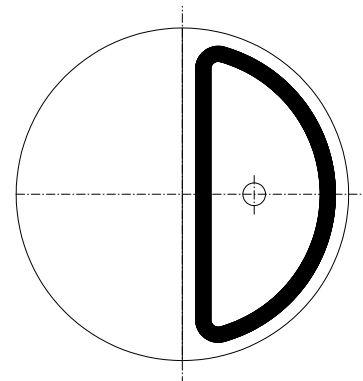
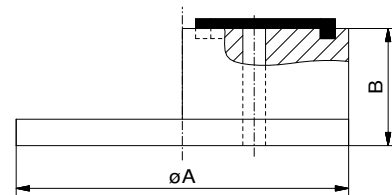
Nr.	A	B	C	Dg	E	F	
85662	88,9	87,4	50,8	30	51	55,9	230

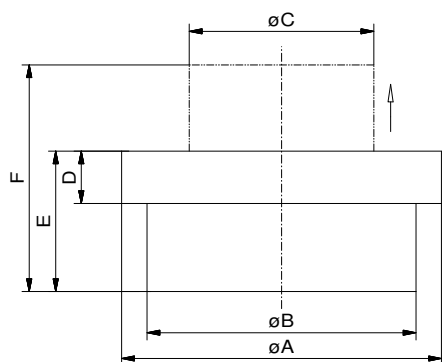


Acts as spacer when positioning large workpieces, raised ring retracts when vacuum is applied

FP Half Pod (1/2)

Nr.	A	B	Mat	
85328	88	30,9	Aluminium	150
82138	88	30,9	Polymer	95





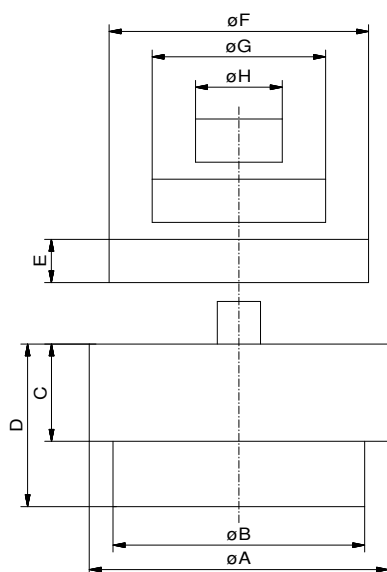
FP Retractable locator pod

automatically retract when vacuum is applied

Nr.	A	B	C	D	E	F	
82136	88,9	74	50,8	14,4	38,6	62,3	252



Retract function of upper section when vacuum switched on



FP Fixed locator pod

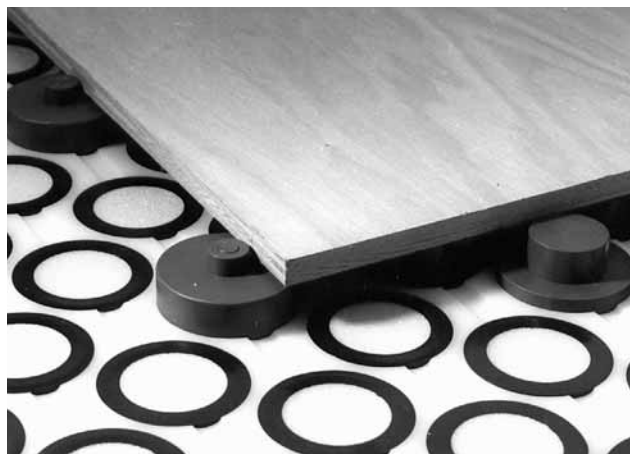
incl. unit, pins and spacer disks

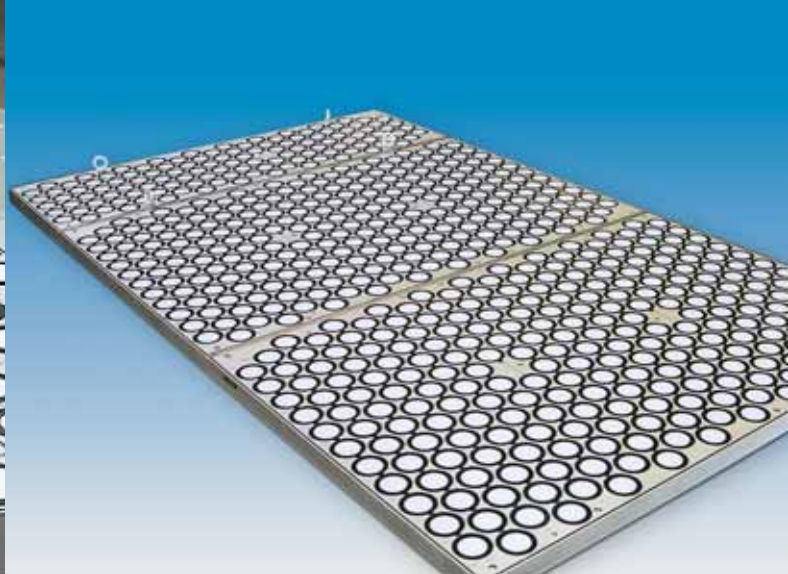
Nr.	A	B	C	D	E	F	G	H	
82137	88,9	74	28,6	47,8	12,7	76,3	15	25,5	476



Fixed and retractable locator pods

ensure high accuracy. Locator pods are available in both fixed and retractable versions, either of which fit in any pod cavity. After positioning the workpiece the retractable pods are drawn back into the pod plate as soon as vacuum is switched on, allowing a free path for the cutting tool.





Various Flip-Pod™ applications in different industries i.e. aircraft and carriage building