![magswitch integrated solutions logo]

Magswitch AR30 Laser Fixture Tool
P/N: 81401134

Designed specifically for use as a fixturing tool for use on welding and cutting applications, the MagSwitch Laser Fixture Tool increases process efficiency and by decreasing set up time. The fixture tool clamps inside the part perimeter, allowing for optimized laser path. The "AR" series allows complete customization of pole shapes to provide the best hold on your hard to grip parts. The copper shield will protect the unit from any welding slag.

Note: You may have to design and fabricate custom pole shoes depending on your application for optimal performance.
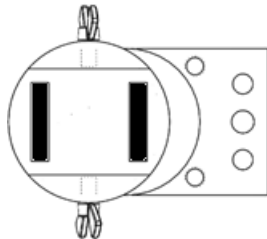
WORKING SURFACE
BLACK = BEST
GRAY=MODERATE

WARNING!
Do Not Operate Unless In
**Contact With Ferrous Target**

SPECIFICATIONS	
P/N: 81401134 - MAGSWITCH AR30 Laser Fixture Tool	
Max Breakaway*	134 lbs/60.9 kg
Working Load 4:1*	33.5 lbs/15.2 kg
Full Saturation Thickness	10 ga/3.5 mm
Max Shear 2:1*	15 lbs/6.8 kg
Minimum Thickness for De-Stack	10 ga/3.5 mm
Min Actuation Pressure	21 psi/1.45×10^5 pa
Max Actuation Pressure	100 psi/6.9×10^5 pa
Off Target Actuation Pressure	48 psi/3.3×10^5 pa
Net Weight	2.42 lbs/1.1 kg
Air Port Thread	M5x0.8
Mounting Thread	2-8mm Dowel / 1-M8 Clearance Hole
Overall Height	145 mm
Magnetic Pole Footprint	36x31.2 mm

* Max Breakaway determined in laboratory environment on 2" thick SAE1018 Steel with surface roughness 63 micro inches. Many factors contribute to the actual breakaway force in each application. Always test the magswitch in each application before deployment. Refer to the magswitch information booklet for more information.

![magswitch logo]

Part Number 1101257
Revision Date: April 13, 2017

Magswitch AR30 Working Load

Actuation Pressure Vs. Material Thickness
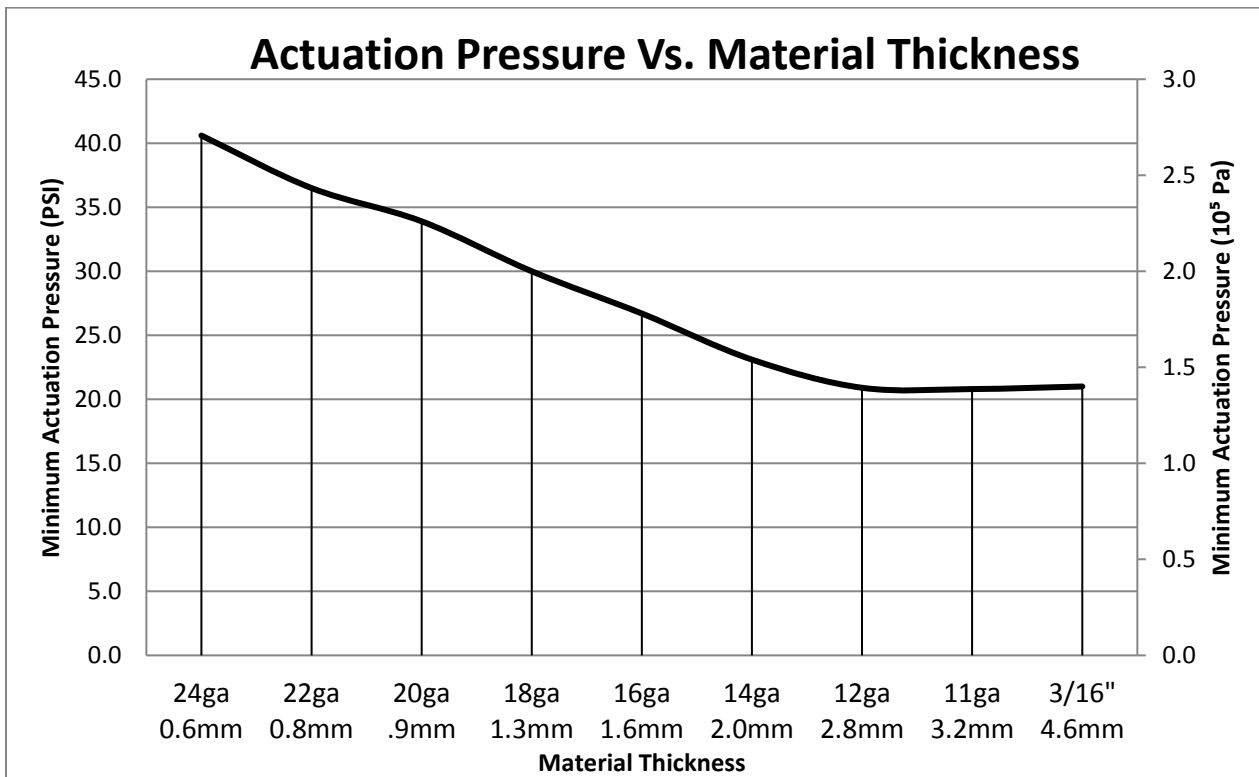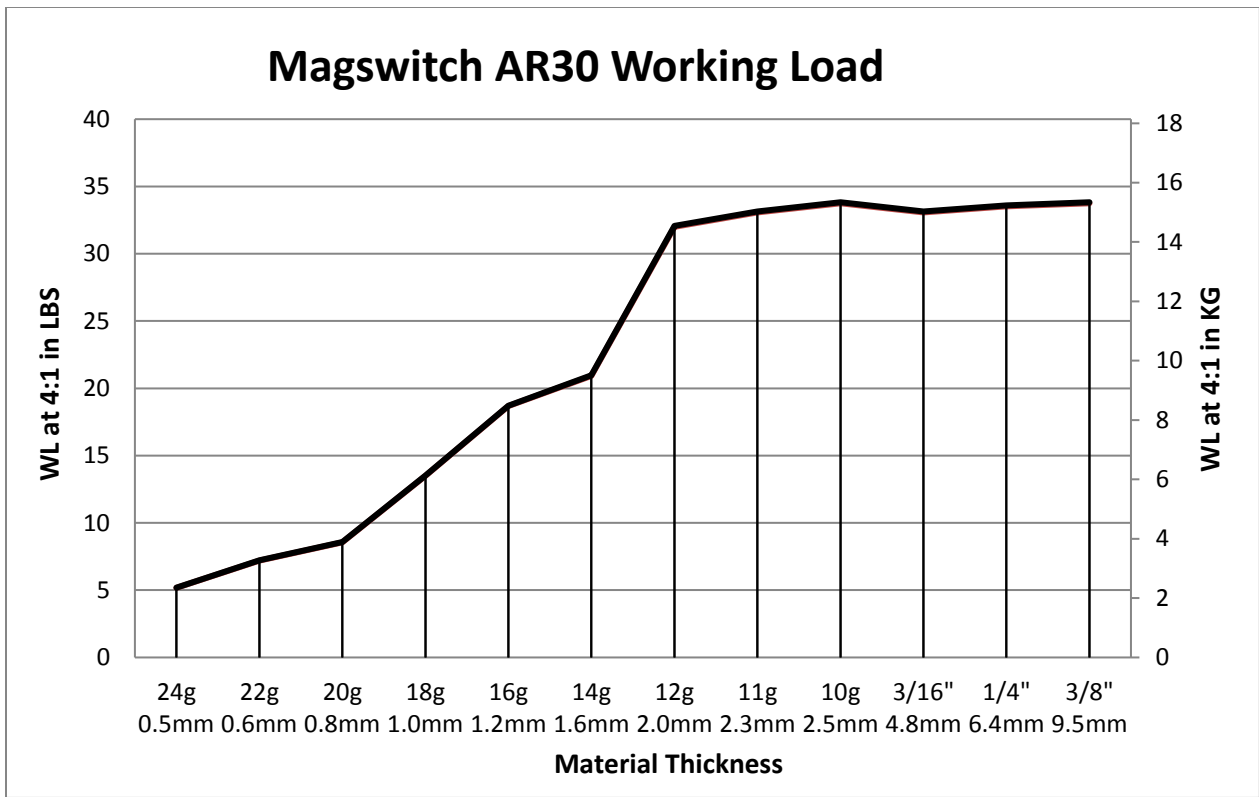
Part Number 1101257
Revision Date: April 13, 2017

* Max Breakaway determined in laboratory environment on 2" thick SAE1018 Steel with surface roughness 63 micro inches. Many factors contribute to the actual breakaway force in each application. Always test the magswitch in each application before deployment. Refer to the magswitch information booklet for more information.
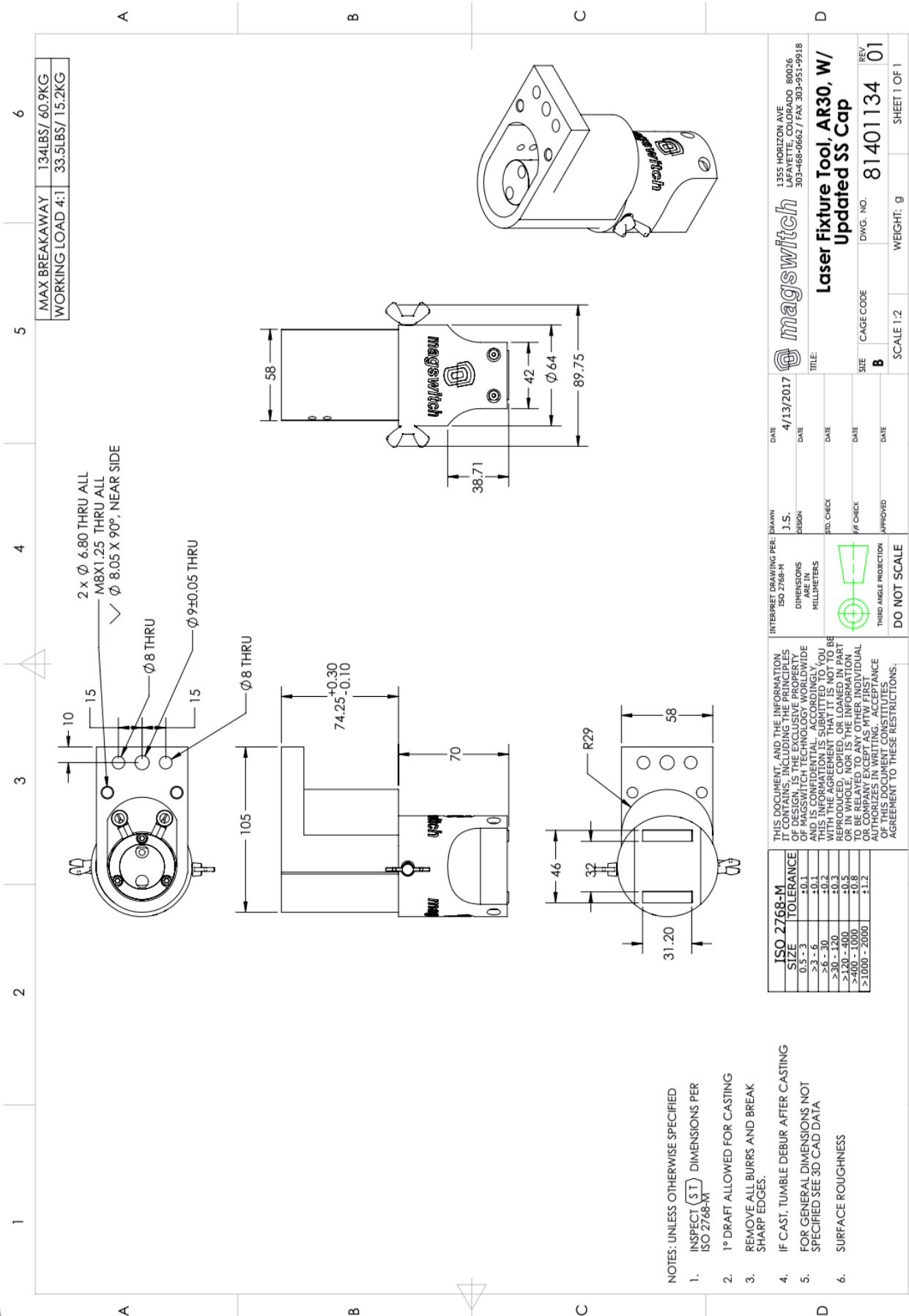
MAX BREAKAWAY	134LBS/ 60.9KG
WORKING LOAD 4:1	33.5LBS/ 15.2KG

2 x Ø 6.80 THRU ALL
M8X1.25 THRU ALL
⌵ Ø 8.05 X 90°, NEAR SIDE

Ø 8 THRU

Ø 9±0.05 THRU

Ø 8 THRU

15
10
15

58

Ø 64
42
89.75
38.71

74.25 +0.30 −0.10
70
105

R29
58
46
32
31.20

NOTES: UNLESS OTHERWISE SPECIFIED

1. INSPECT (ST) DIMENSIONS PER ISO 2768-M
2. 1° DRAFT ALLOWED FOR CASTING
3. REMOVE ALL BURRS AND BREAK SHARP EDGES.
4. IF CAST, TUMBLE DEBUR AFTER CASTING
5. FOR GENERAL DIMENSIONS NOT SPECIFIED SEE 3D CAD DATA
6. SURFACE ROUGHNESS

ISO 2768-M	
SIZE	TOLERANCE
0.5 - 3	±0.1
>3 - 6	±0.1
>6 - 30	±0.2
>30 - 120	±0.3
>120 - 400	±0.5
>400 - 1000	±0.8
>1000 - 2000	±1.2

INTERPRET DRAWING PER: ISO 2768-M	DRAWN	J.S.	DATE 4/13/2017
DIMENSIONS ARE IN MILLIMETERS	DESIGN		DATE
	STD. CHECK		DATE
	F/F CHECK		DATE
	APPROVED		DATE

THIRD ANGLE PROJECTION

DO NOT SCALE

magswitch
1355 HORIZON AVE
LAFAYETTE, COLORADO 80026
303-468-0662 / FAX 303-951-9918

TITLE: Laser Fixture Tool, AR30, W/ Updated SS Cap

CAGE CODE

DWG. NO. 81401134

REV 01

SIZE B

SCALE 1:2

WEIGHT: g

SHEET 1 OF 1

Part Number 1101257
Revision Date: April 13, 2017