

# LAPPING SYSTEMS

## POLISHING STATIONS & ACCESSORIES



**/// BECOTECHNIC**

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# LAPPING SYSTEMS

The discs presented in this chapter, thanks to the numerous possible configurations and options, provide an efficient way of undertaking lapping operations.



The discs presented have standard diameters of 240 and 300 millimetres. Discs 300 millimetres in diameter must be fitted with a riser base (see specific chapter). Shapes specific to your application may be created on request.

In addition, a vulcanisation thickness of 10 mm on the face of the disc is available, with a choice of hardness of between 30 and 80 Shores.





- 1 Rod protector
- 2 Clamping rod
- 3 Disc protector
- 4 Disc

## Disc protectors

ITEM	DESCRIPTION	ITEM NO.
	Ø 240 mm disc protector	C501-PRDI-01 1000356
	Ø 300 mm disc protector	C501-PRDI-02 1000273

## Flat discs

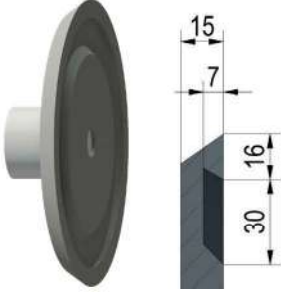
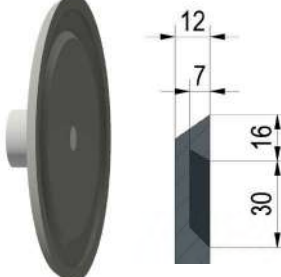
ITEM	Ø [mm]	DESCRIPTION	ITEM NO.
	240	Ø 240 flat cast iron disc, clamped by M8 rod	C501-DI-10-M8 1000315
	300	Ø 300 flat cast iron disc, clamped by M8 rod	C501-DI-20-M8 1015449

► The old discs with M12 screw mounting are still available on request.

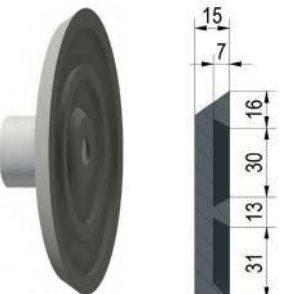
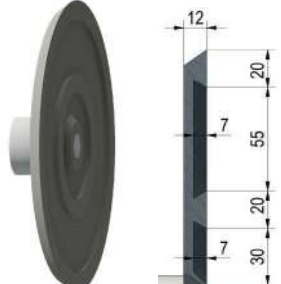
# LAPPING SYSTEMS

## Discs

### Dovetail discs

ITEM	Ø [mm]	DESCRIPTION	ITEM NO.
	240	Ø 240 dovetail cast iron disc, clamped by M8 rod	C501-DI-30-M8 1015450
	300	Ø 300 dovetail cast iron disc, clamped by M8 rod	C501-DI-60-M8 1015452

### Double dovetail discs

ITEM	Ø [mm]	DESCRIPTION	ITEM NO.
	240	Ø 240 double dovetail cast iron disc, clamped by M8 rod	C501-DI-40-M8 1015399
	300	Ø 300 double dovetail cast iron disc, clamped by M8 rod	C501-DI-110-M8 1015455

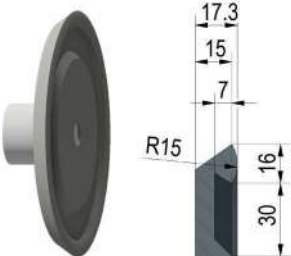
► The old discs with M12 screw mounting are still available on request.

► For specific applications, the dimensions and shape may vary on request.


# LAPPING SYSTEMS

## Discs

### Dovetail discs with neck mould

ITEM	Ø [mm]	DESCRIPTION	ITEM NO.
	240	Ø 240 dovetail cast iron disc with neck mould, clamped by M8 rod	C501-DI-50-M8 1015451


### Twin discs for inter-horn area


ITEM	Ø [mm]	DESCRIPTION	ITEM NO.
	240	Ø240 twin cast iron disc for inter-horn area, clamped by M8 rod	C501-DI-70-M8 1015453

► For specific applications, the dimensions and shape may vary on request.

### Vulcanisation

Vulcanisation is used to diversify the disc hardness in line with your requirements. This is done only on the flat discs range. The thickness allowance is 10 mm.

ITEM	Ø [mm]	HARDNESS [SHORE]	DESCRIPTION	ITEM NO.
	240	30	Cast iron disc with vulcanisation	C501-DI-11.0_M8 1018823
		40	"	C501-DI-11.1_M8 1018822
		50	"	C501-DI-11.2_M8 1018821
		60	"	C501-DI-11.3_M8 1018820
		70	"	C501-DI-11.4_M8 1018819
		80	"	C501-DI-11.5_M8 1018818

ITEM	Ø [mm]	HARDNESS [SHORE]	DESCRIPTION	ITEM NO.
	300	30	Cast iron disc with vulcanisation	C501-DI-21.0_M8 1021312
		40	"	C501-DI-21.1_M8 1021314
		50	"	C501-DI-21.2_M8 1021316
		60	"	C501-DI-21.3_M8 1021318
		70	"	C501-DI-21.4_M8 1011653
		80	"	C501-DI-21.5_M8 1006183

► The old discs with M12 screw mounting are still available on request.






# LAPPING SYSTEMS

## Lapping bars and lapping carriages




The lapping bar enables a lapping carriage to be used. The lapping carriages are used for preparing shaped or round workpieces, according to their technical level, supported by the lapping bar.



### Lapping bars

ITEM	DESCRIPTION	ITEM NO.
	Long version lapping bar	C501-BAR-LAP.V2 1016518
	Angle-adjustable version lapping bar	C501-BAR-LAP.V3 1003304
	Stainless steel slotted stop (for Ø16 bar)	C501-BUT-LAP 1038564

### Full set

ITEM	DESCRIPTION	ITEM NO.
	M10x1 right-handed universal reel, with fine adjustment to 45° and universal chuck	C501-BOB-UNI_D.D 1038731
	M10x1 right-handed universal reel, with standard adjustment to 40° and universal chuck	C501-BOB-UNI_D.C 1038730
	Left-handed lapping carriage with universal carriage	C501-BOB-D-MAND 1027147

### Optional: valid for all universal chucks





Protective ring	C501-3060_SAV_9	1028747
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► All reels are supplied without a collet (see Quick-tightening clamps chapter) and without jaws (see Holders and chucks chapter).



# LAPPING SYSTEMS

## Lapping carriages and polishing reels

### Separate components

ITEM	DESCRIPTION	ITEM NO.	
	M16x1 left-handed universal reel, with fine adjustment to 45°	C501-BOB-UNI-45G	1002925
	M16x1 right-handed universal reel, with fine adjustment to 45°	C501-BOB-UNI-45D	1012481
	M16x1 left-handed universal reel, with standard adjustment to 40°	C501-BOB-UNI_G	1003377
	M16x1 right-handed universal reel, with standard adjustment to 40°	C501-BOB-UNI_D	1000229

### Accessories

ITEM	DESCRIPTION	ITEM NO.	
	Rod-clamping universal chuck, without jaws M10X1	C501-3070	1012629
	M10x1 SW holder for adapting universal chuck For adapting onto: C501-BOB-UNI_D/G and C501-BOB-UNI-45D/G	C501-3060_SAV_11	1038486
	SW M16 x 1 left-handed chuck for adapting onto C501-BOB-UNI	C501-BOB-UNI-SAV_1	1203010
	SW M16 x 1 right-handed chuck for adapting onto C501-BOB-UNI	C501-BOB-UNI-SAV_2	1203011

### Optional: valid for all universal chucks







Protective ring	C501-3060_SAV_9	1028747
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► All reels are supplied without a collet (see Quick-tightening clamps chapter) and without jaws (see Holders and chucks chapter).


# LAPPING SYSTEMS

## Lapping carriages and polishing reels



### Separate components by hand

ITEM	DESCRIPTION	ITEM NO.
	M16x1 left-handed lapping carriage	C501-BOB-G 1001792
	M16x1 right-handed lapping carriage	C501-BOB-D 1000188
	M16x1 left-handed polishing hand reel	C501-BOB-POL-G 1003093
	M16x1 right-handed polishing hand reel	C501-BOB-POL-D 1000765
	Reel adapter for internal clamping	C501-ADAPT-BOB-FRM 1025972
	Opening stem for hand reel	C501-ADAPT-BOB-OUV 1030536

### Système modulaire de lapidage et polissage

ITEM	DESCRIPTION	ITEM NO.
	Hand reel with universal chuck	C501-BOB-POL-D-MAND 1021532

### Modular lapping and polishing system

ITEM	DESCRIPTION	ITEM NO.
	CLIP system polishing handle without jaws	C501-BOB-CLIP_A 1030380
	CLIP system lapping carriage with handle, without jaws Usable in carriage mode or manual polishing reel mode	C501-BOB-CLIP_B 1030381

### Interchangeable hand accessory

ITEM	DESCRIPTION	ITEM NO.
	CLIP-ON universal chuck without jaws	C501-MAN-CLIP 1030382

► All reels are supplied without collet (see Quick-tightening clamps chapter) and without jaws (see next page).


# LAPPING SYSTEMS

## Quick-clamping chuck / jaws


### Quick-clamping chuck

ITEM	DESCRIPTION	ITEM NO.	
	Bocks® universal chuck with ring clamping, without jaws, with adapter for clamping via M8 rod	C501-3060_M8	1012625


### Jaws with quenched steel base

ITEM	DESCRIPTION	ITEM NO.	
	Set of 3 numbered and machined jaws, internal clamping	C501-3060_SAV_1i	1014715
	Set of 3 numbered and machined jaws, external clamping	C501-3060_SAV_1e	1028837

### Jaws with brass base

ITEM	DESCRIPTION	ITEM NO.	
	Set of 3 numbered and machined jaws, internal clamping	C501-3060_SAV_4i	1014718
	Set of 3 numbered and machined jaws, external clamping	C501-3060_SAV_4e	1028839
	Set of 3 numbered and blanked jaws	C501-3060_SAV_3	1012627

### Jaws with plastic base

ITEM	DESCRIPTION	ITEM NO.	
	Set of 3 numbered and machined jaws, internal clamping	C501-3060_SAV_6i	1014725
	Set of 3 numbered and machined jaws, external clamping	C501-3060_SAV_6e	1028841
	Set of 3 numbered and blanked jaws	C501-3060_SAV_5	1012628


► Other dimensions are available on request.




# LAPPING SYSTEMS

## Jaws

### Jaws without quenched steel base

ITEM	DESCRIPTION	ITEM NO.	
	Set of 3 numbered and machined jaws, internal clamping	C501-3060_SAV_2i	1014714
	Set of 3 numbered and machined jaws, external clamping	C501-3060_SAV_2e	1028838

### Jaws without plastic base

ITEM	DESCRIPTION	ITEM NO.	
	Set of 3 numbered and machined jaws, internal clamping	C501-3060_SAV_8i	1014727
	Set of 3 numbered and machined jaws, external clamping	C501-3060_SAV_8e	1028843
	Set of 3 numbered and blanked jaws	C501-3060_SAV_7	1014713

► Other dimensions are available on request.

# LAPPING SYSTEMS

## Double discs

The double angle transmission device enables two discs with Ø 240 mm to be mounted (blank and finishing). Since the height of the lapping bars is different, the strokes will be crossed to improve the preparation.

The double angle transmission device is supplied without the discs.



### Double discs

ITEM	DESCRIPTION	ITEM NO.
	Double disc system, without discs	C501-RENV-DBL 1201994
	Lapping bar	C501-BAR-LAP-DBL 1202226
	Tables and reels support plate	C501-ST-DBL-10 1012511
	Ø 240 flat cast iron disc, M12 clamp screw	C501-DI-10-M12 1013072

- ▶ A vulcanisation thickness of 10 mm is available, with a choice of hardness between 30 and 80 Shore (see chapter Lapping Systems).
- ▶ The reels are not delivered with the double discs (see chapter Lapping Systems).

# LAPPING SYSTEMS

## Examples of applications

**Disc with a carriage and a lapping bar**  
See the specific chapter for the accessories



**Disc with a 3D table fitted with a support ruler and a 0.01 mm slide calliper**  
See the specific chapter for the accessories



**Dovetail disc and a 3D table, with a support**  
See the specific chapter for the accessories



**Double disc system with lapping bars and a lapping carriage**  
See the specific chapter for the accessories



**Double disc system and two 3D tables, with 2 supports**  
See the specific chapter for the accessories

