

How to create fixture setups for X+

Load and prepare the part that should be used as a fixture

We are going to use the **CentroLite 68M** from **Allite**.

You can download the centric vice from their website at:

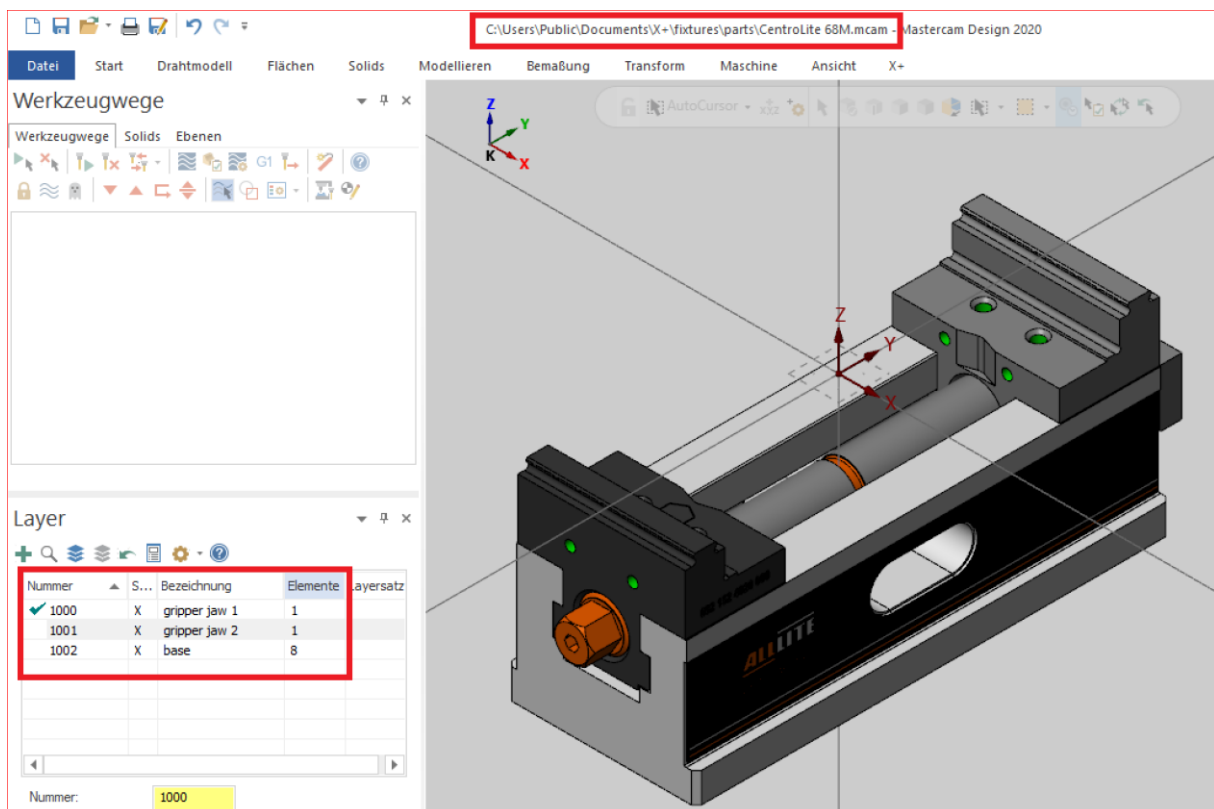
<https://www.allite.de/en/Products/CentroLite-68M>



After importing the part into Mastercam, we are going to delete unnecessary geometry (i.e. all wire geometry), transform the part to the TOP view and move the gripper jaws and the base to higher levels. It is very important that all components (jaw 1, jaw 2 and base) are on different levels.

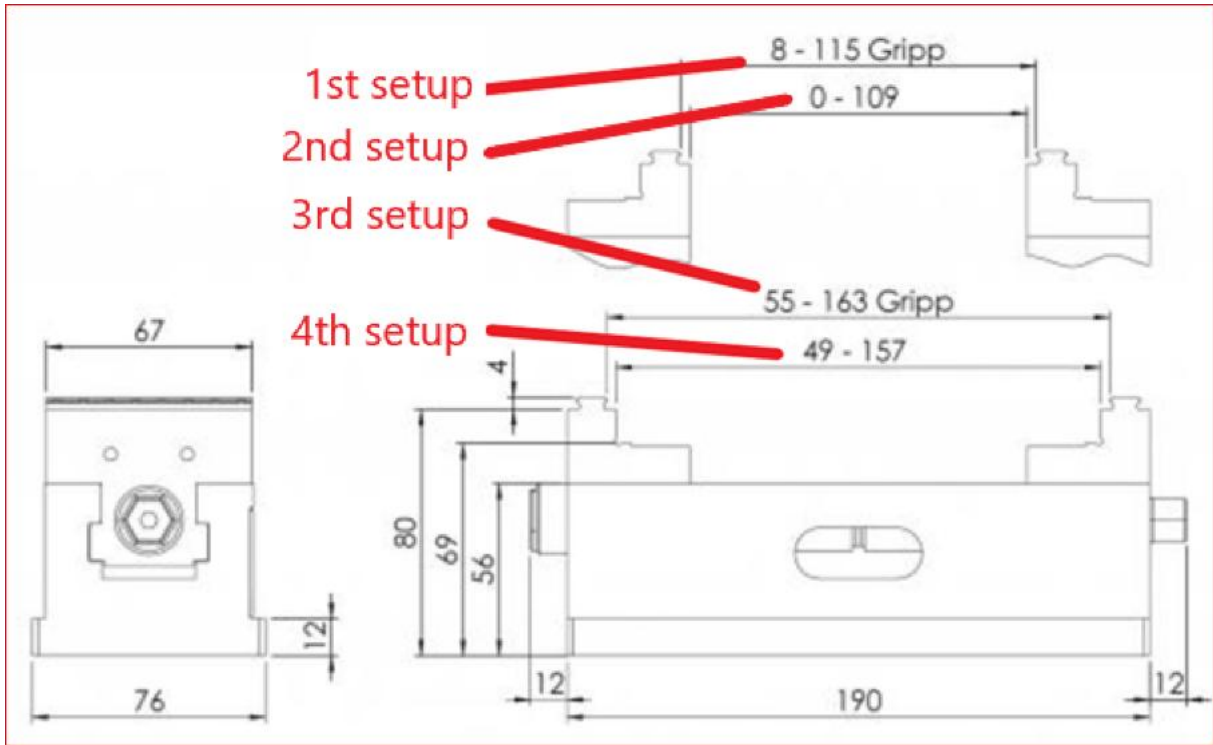
Then we save the part to our fixture folder: **C:\Users\Public\Documents\X+\fixtures\parts**

It should look something like this now:




Create setups with the X+ fixture setup tool

Looking to the specs of the centric vice, we can create 4 setups.

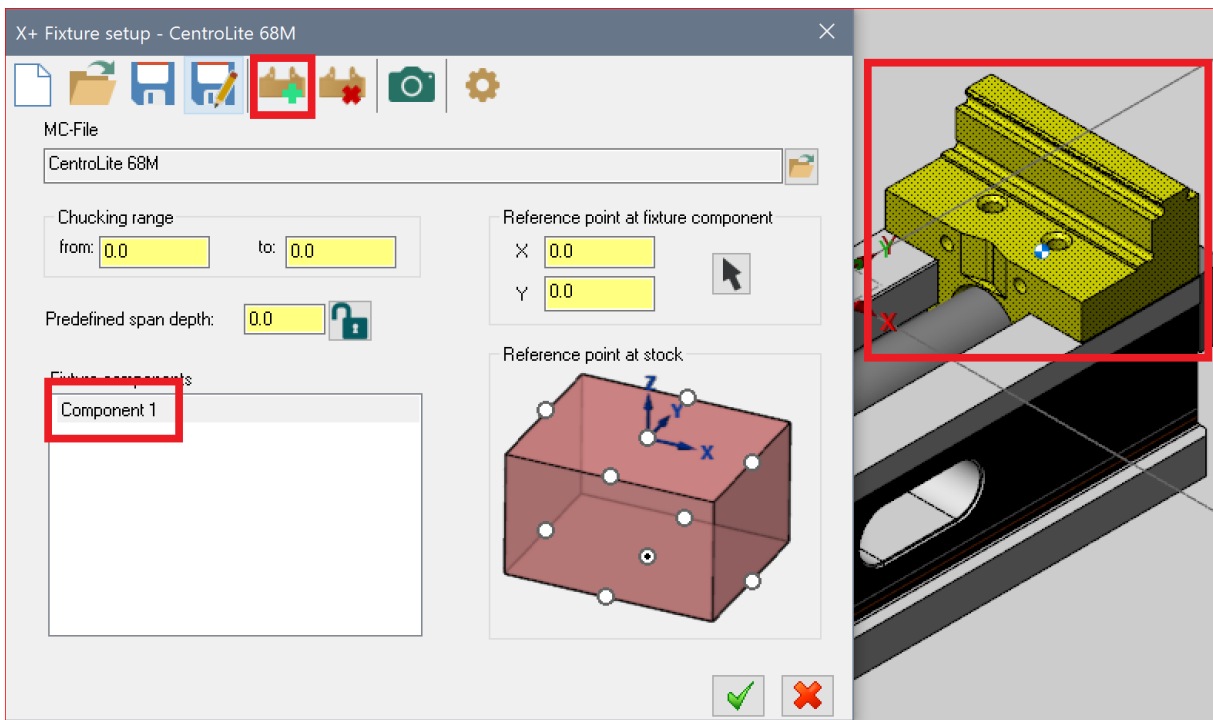


To create a setup, the centric vice needs to be loaded into Mastercam.


Launch the fixture setup chook .

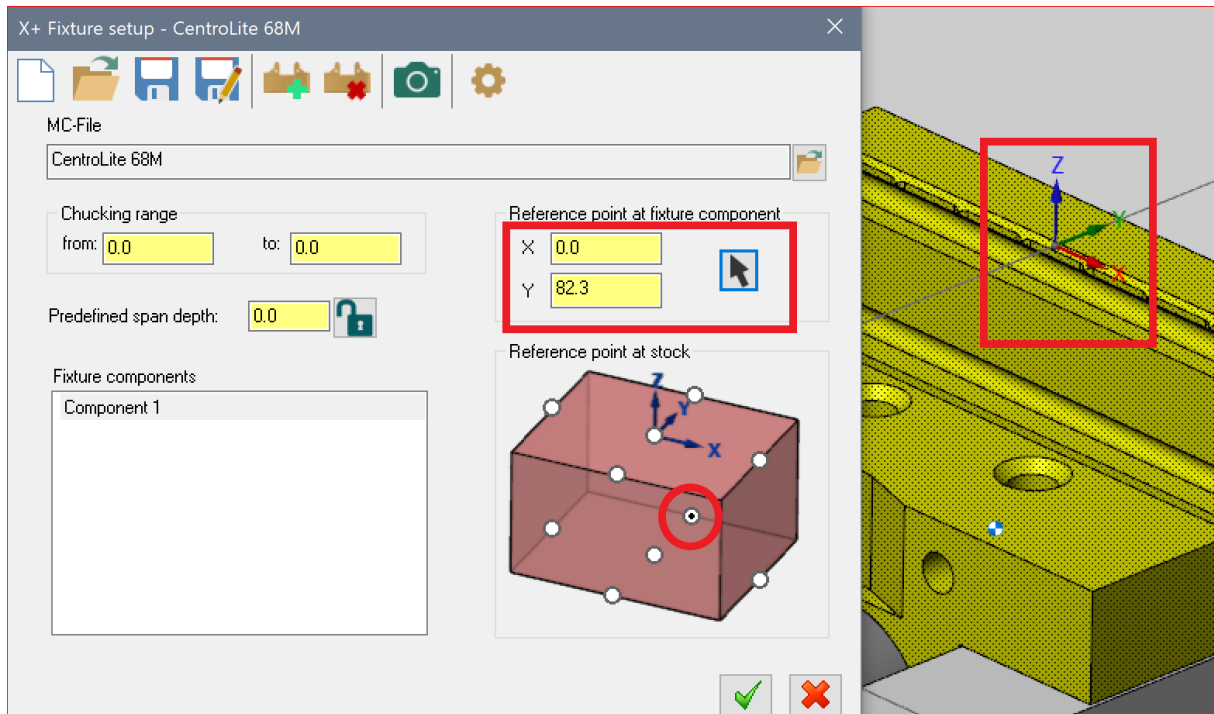
Click on the “add component to list” button .

Select the 1st gripper jaw and press enter. The 1st component will be added to the list.

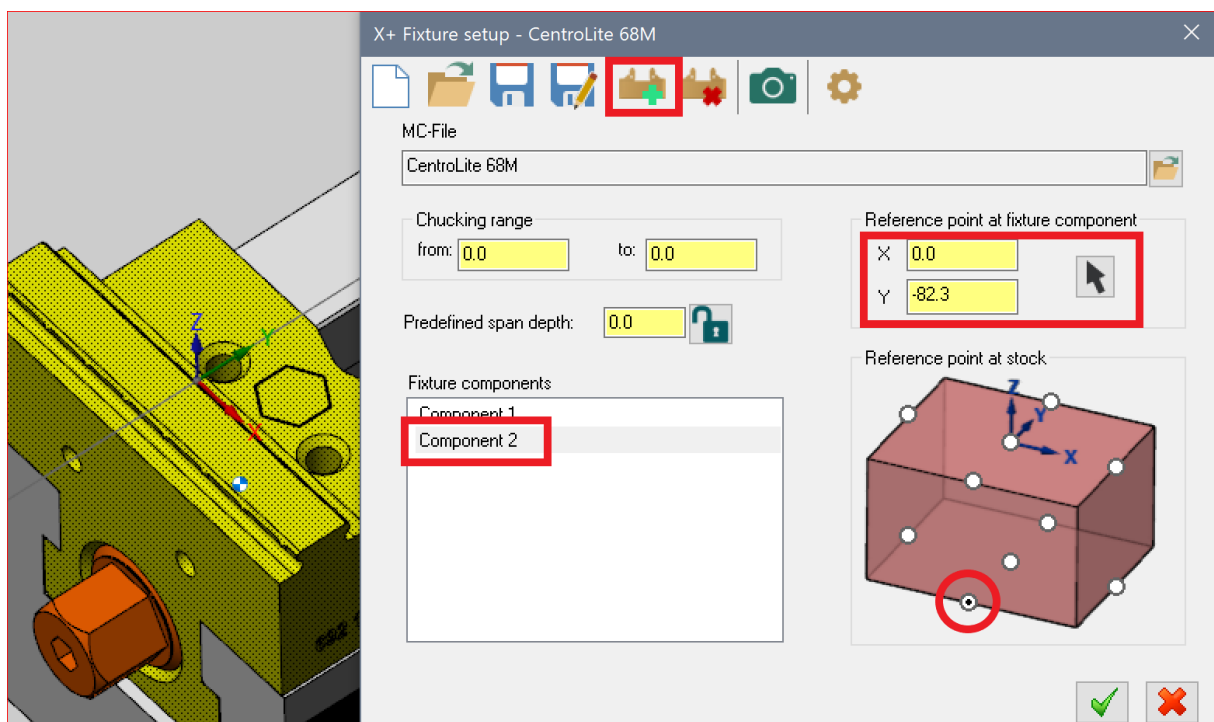


Now we need to define a reference point from the 1st component. The reference point will be used to move the component to a specified position at the stock.

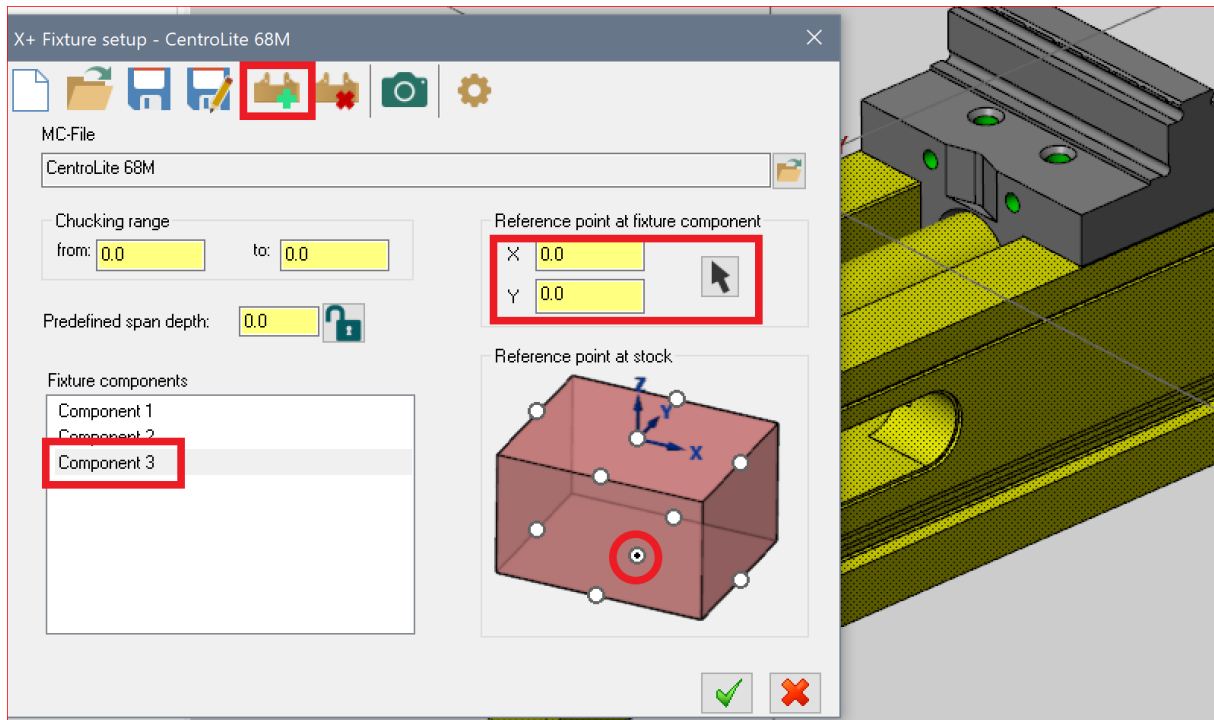
Select the *reference point at stock* as shown below then click on the black arrow  and select the point from the gripper jaw as shown below.



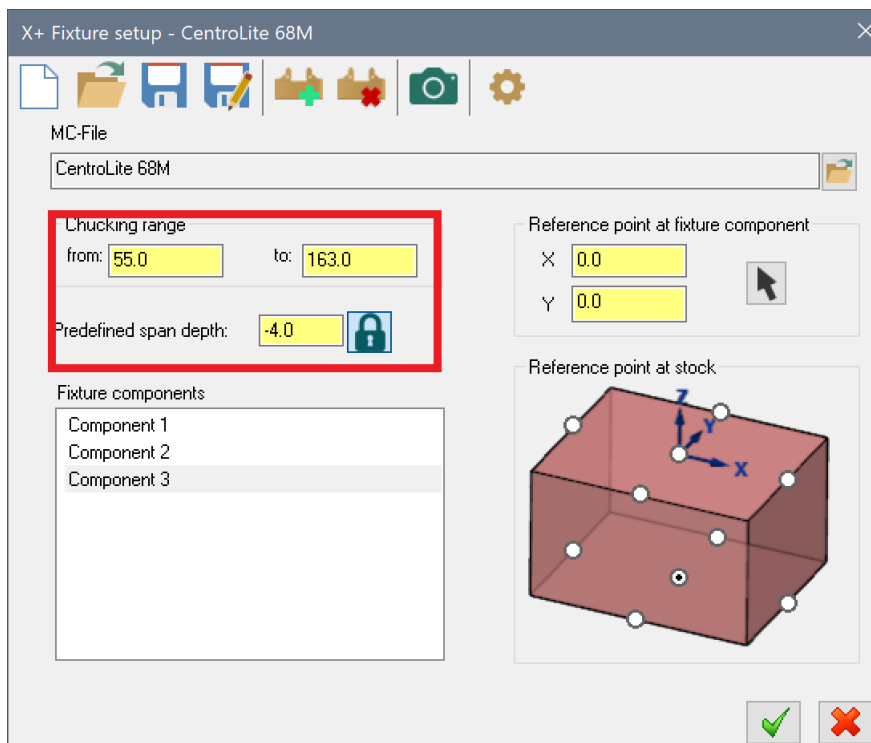
Add a new component and repeat the previous step with the 2nd gripper jaw.



Add a new component for the base and select one of the remaining elements. That's all you need to do for the base.




Set the span depth to **-4** and lock it. Set the range from **55** to **163** (According to the specs on page 2, 2nd setup).



Save the setup as "**CentroLite 68M_55_163.smk**" by clicking on the "**Save as...**" button .

Then click on the "**Create thumbnail**" button .

Done!

You could now create the other configurations for this centric vice by clicking on the "**New**" button  and then repeat the process.