

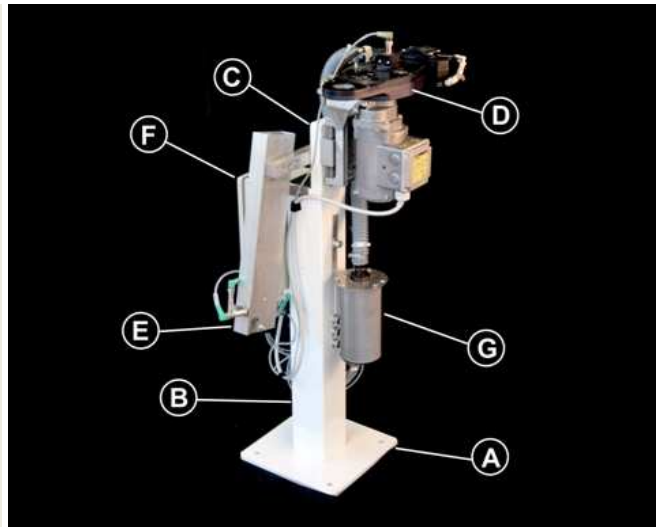


SCA SRE DELTA tip-dresser with automatic tip-changer consists of:

- A: base plate
- B: pillar welded to a base plate
- C: sliding bar that supports the tip-change and tip-dresser's head
- D: tip-dresser's head with a release device for the automatic change of the electrodes
- E: electrodes storage unit for the load of the tips on welding guns
- F: power and drive electric box
- G: cylindrical container for copper swarves

Thanks to its compact size, this model is extremely easy to fit into welding lines.

By using a single machine it is possible to perform both tip-dressing and the automatic change of worn electrodes on the welding gun, thus reducing line stops, installation and spare parts costs.



APPLICATION: ROBOT WELDING GUNS

In compliance with the Machinery Directive 89/392 EEC

OVERALL DIMENSIONS

X (length) = 600 mm
 Y (width) = 400 mm
 Z (adjustable height) = 1000 - 1200 mm
 Overall weight = 32 Kg.

ELECTRIC AND PNEUMATIC CONNECTIONS

Power= 1 kW
 Frequency= 50 or 60 Hz
 Voltage= 380/480 VAC + 24 VDC
 Duty cycle= S2-10 sec.
 Current = 2.7 A (50 Hz)
 5 A (60 Hz)
 Suitable air flow rate = 450 l/min at 6 bar
 Air supply pipe minimum inner diameter = Ø 6 mm
 Air supply = 5÷8 bar - ISO 8573 Class 3.4.3

STANDARD ELECTRODES STORAGE UNIT

Electrodes magazines= 2 + 2 x 10 electrodes each
 Electrodes = ISO 5821 type A-B-E-F-G Ø 20x22 mm
 Sensor detecting the presence of electrodes on welding gun = induction for non-ferrous materials.
 Sensor detecting the presence of electrodes in the magazines = induction for ferrous materials
Technical, economic and productive issues emerge when using electrodes not matching the above listed ones. In this case it is necessary to advise with Sinterleghe's technical dept., in order to agree on supply details.

STANDARD COLOUR SCHEME

Structural steelwork= RAL 9010 white
 Electric box= RAL 7035 grey

INTERFACE

Base plate/flange dimensions = 300x300 mm
 4x Ø 14 holes for M12 screws
 distance between holes 230x230 mm
 Fixing of the SCA SRE DELTA head to the pillar:
 4x M10 screws distance between holes 40x40 mm

TIP DRESSER'S AND TIP CHANGER'S FEATURES

Distance cutter center - carter edge= 42 mm
 Distance release device axis - carter edge= 42 mm
 Tip-dresser's head height H = 20 mm
 Quick release device height H= 20 mm
 Cutter rotation speed loadless= 200 rpm
 Cutter/quick release device rotating direction= clockwise
 Tip-dresser's head equalization height= +/- 10 mm
 Uncoupling of a single electrode = 300 msec
 Complete tip-change + tip-dressing cycle ≤ 50 sec.

The torque used to uncouple the electrodes is not supplied through a rotating movement of the welding gun. The uncoupling is performed through the RAVITEX® Tip Changer: Patent N° TO 2002 A 001032.

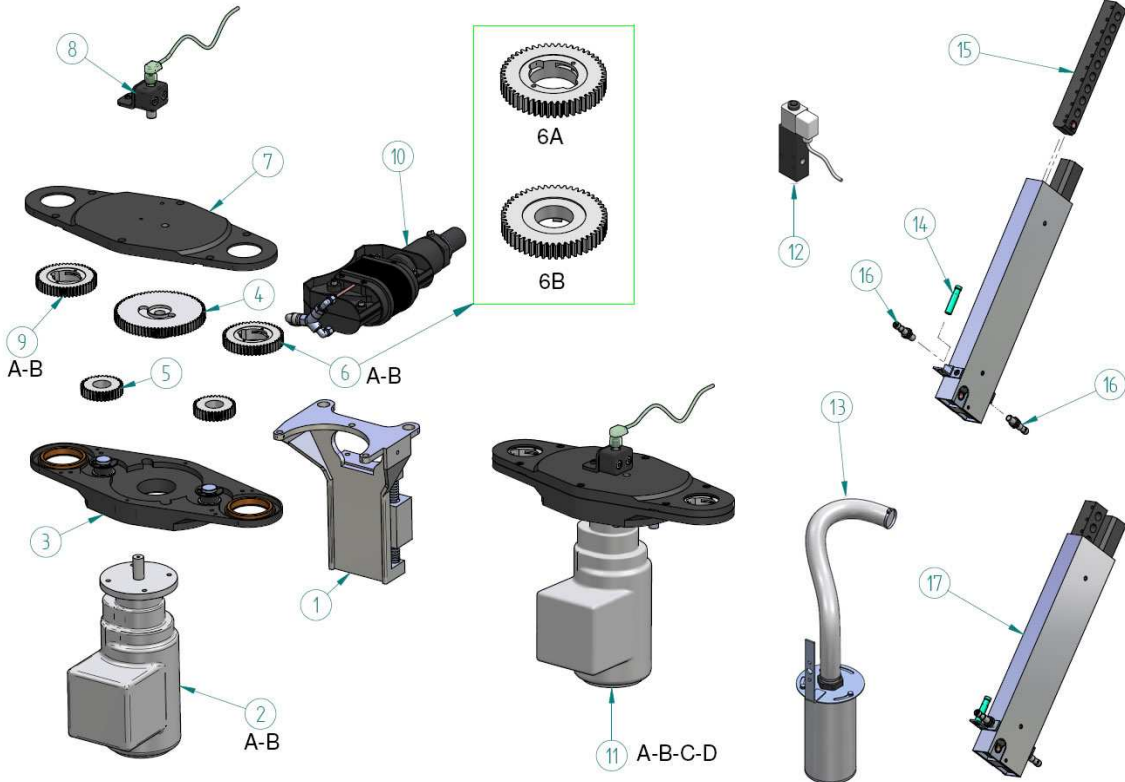
MAINTENANCE

Lubrication = permanent
 Tip-dresser/tip changer's head = multipurpose grease with PTFE
 Reduction unit= synthetic oil ISO VG 320
 Swarves tray = empty once every 15 days

RAVITEX® Pneumatic and electric tip-dressers, as well as the automatic tip changer are designed and assembled using interchangeable parts, thus reducing the number of pieces and spare parts costs.

WARRANTY

12 months, spare and wearable parts excluded.



Pos.	SPARE PARTS FOR TIP-DRESSER AND TIP-CHANGER'S HEAD SCA SRE DELTA*	Code	Q.ty
1	HEAD SUPPORT WITH EQUALIZATOR	28HM-03381	1
2a	AXIAL GEARMOTOR 380V 50Hz 1kW	14T0-10008	1
2b	AXIAL GEARMOTOR 380V 50Hz 1kW	14T0-10009	1
3	LOWER SRE DELTA TWIN CARTER WITH BUSHES AND PIVOTS	28RA-04629	1
4	SRE-DELTA MOTOR GEAR	06I4-01726	1
5	SRE-DELTA TWIN/SCA NEUTRAL GEAR	06I4-03224	2
6a	CUTTER HOLDER GEAR RFRW WITH PLUNGERS	34R0-10021	1
6b	CUTTER HOLDER GEAR SRE-DELTA FOR RFA BUSHES	06P4-02474	1
7	UPPER SCA SRE DELTA CARTER WITH BUSHES	16C0-10044	1
8	SENSOR GROUP WITH CABLE	29RI-04401	1
9	COMPLETE QUICK RELEASE DEVICE (Ø20) Patent PENDING N° TO 2002 A 001032	28RA-04239	1
10	PLASTIC SUCTION DEVICE WITH BRUSHES AND PNEUMATIC CONNECTION	29RI-04588	1
11a	SCA SRE Ø20 380V 50Hz HEAD WITH SENSOR WITHOUT RELEASE DEVICE RFRW	34R0-10006-AA	1
11b	SCA SRE Ø20 380V 50Hz HEAD WITH SENSOR WITHOUT RELEASE DEVICE RFA	34R0-10006-AB	1
11c	SCA SRE Ø20 380V 60Hz HEAD WITH SENSOR WITHOUT RELEASE DEVICE RFRW	34R0-10006-AJ	1
11d	SCA SRE Ø20 380V 60Hz HEAD WITH SENSOR WITHOUT RELEASE DEVICE RFA	34R0-10006-AK	1
12	SOLENOID VALVE WITH CABLE	29RI-04400	1
13	CYLINDRICAL SWARVES TRAY WITH PIPE	29RI-04826	1
Pos.	SPARE PARTS FOR THE COMPLETE STORAGE UNIT	Code	Q.ty
14	INDUCTION SENSOR M12X1X65/2/24V/PNP/NO COPPER	08S2-04078	1
15	ELECTRODES MAGAZINE Ø20	19RA-04846	4
16	INDUCTION SENSOR M12X1X60	08S2-04114	2
17	COMPLETE ELECTRODES STORAGE UNIT Ø20	19RA-04847	1

* **IMPORTANT:** THE TIP-CHANGER CAN BE CONSIDERED IN THE STANDARD VERSION WHEN THE ELECTRODES PAIRED ON THE WELDING GUN COMPLY WITH ISO 5821 NORM TYPE A, B, E, F, G. **Technical, economic and productive issues emerge when using electrodes not matching the above listed ones. In this case it is necessary to advise with Sinterleghe's technical dept., in order to agree on the correct spare parts.**

SINTERLEGHE s.r.l.