

PNEUMATIC SWIVELLING UNIT SPO A
 code 99BA-04085 = SPO A



RAVITEX®
 dressing quality

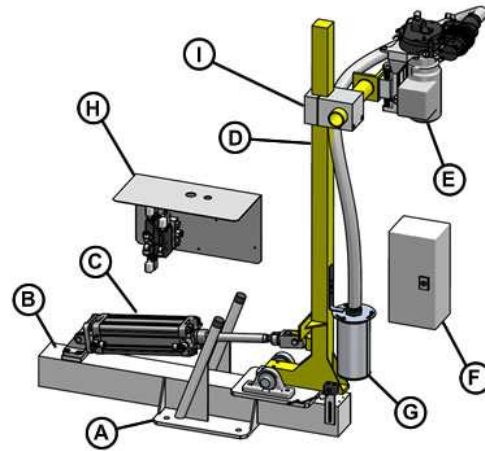
Code: **MD_C04**

Review date: 080529

TOTAL QUALITY MANAGEMENT

Swivelling unit SPO A consists of:

- A : base plate
- B : beam supporting a pneumatic cylinder
- C : swivelling arm motion system, including a pneumatic cylinder, joints and bearings
- D : swivelling arm supporting the tip-dresser's head
- E : equalized tip-dresser's head including an electric motor (380 /500 V), a gear train for the transmission of the motion to the cutter and the box of the suction device.
- F : electric box.
- G : cylindric box for the storage of copper swarves.
- H : pneumatic group.
- I : cross clamp allowing height and position adjustments of the tip-dresser's head.



APPLICATION: STATIONARY WELDING GUNS

In compliance with the Machinery Directive 89/392 EEC

OVERALL DIMENSIONS

Length X = 1300 mm
 Width Y = 600 mm
 Height Z = 1300 mm
 Maximum load @ L 1000 mm = 15 Kg.
 Overall weight = 60 Kg

INTERFACE

Base plate(A)=300x300 mm, 4x Ø 14 holes for M12screws
 distance between holes 230x230 mm
 Tip dresser's head = 4x M10 screws
 distance between holes 40x40 mm.
 Tip-dressing position = swivelling units are set on site by the customer. Standard units can be adjusted through the setting of 2 arms. A third arm is optional (see spare parts)

ELECTRIC AND PNEUMATIC CONNECTIONS

Power= 0.37 kW
 Frequency= 50/60 Hz
 Voltage= 380/480 or 500 VAC + 24 VDC
 Duty cycle= S2-10 sec.
 Current = 1.05 A (380V-50 Hz)
 1.15 A (480V-60 Hz)
 0.84 A (500V-50 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

TIP DRESSER'S FEATURES

Distance cutter center - carter edge= 42 mm
 Tip-dresser's head height H = 20 mm
 Cutter rotation speed loadless= 200 rpm
 Cutter rotating direction= clockwise
 Tip-dresser's head equalization height= +/- 10 mm
 Standard cutter holder gear= 34R0-10021

MOTION ACTUATOR

Air supply = 5÷8 bar - ISO 8573 Class 3.4.3
 Air plug= Ø 3/8"
 Air supply pipe= minimum inner Ø 10 mm
 Cylinder bore = 80 mm
 Cylinder stroke = 200 mm

MAINTENANCE

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

Before supplying air, purge water and impurities from the pneumatic circuit.

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.

STANDARD COLOUR SCHEME

Structural steelwork = RAL 9010 white
 Electric box = RAL 7035 grey
 Moving parts = RAL 1021 yellow

WARRANTY

12 months, spare and wearable parts excluded.

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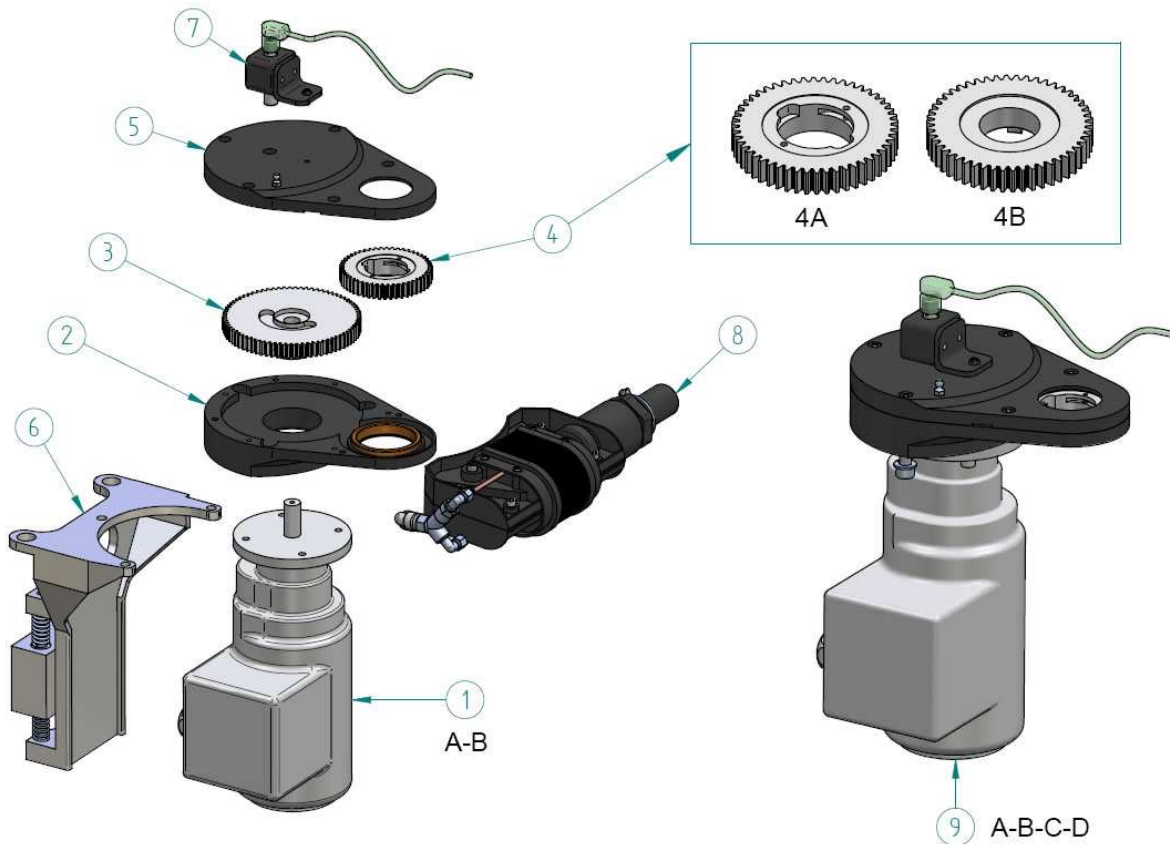


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POS.	SRE DELTA TIP DRESSER'S HEAD SPARE PARTS	CODE	PCS.
1a	GEARMOTOR 0,37KW/380-480V/50-60HZ	07E3-02409	1
1b	GEARMOTOR 0.37KW/500V/50HZ	07E3-02878	1
2	LOWER CARTER WITH BUSH	28RA-03376	1
3	SRE DELTA MOTOR GEAR	06I4-01726	1
4a	CUTTER HOLDER GEAR RFRW WITH PLUNGERS	34R0-10021	1
4b	CUTTER HOLDER GEAR SRE DELTA FOR RFA BUSHES	06P4-02474	1
5	UPPER CARTER WITH BUSH	28RA-03375	1
6	HEAD SUPPORT WITH EQUALIZATOR	28HM-03381	1
7	SENSOR GROUP WITH CABLE	29RI-04401	1
8	PLASTIC SUCTION DEVICE WITH BRUSHES AND PNEUMATIC CONNECTION	29RI-04588	1
9a	DELTA TIP-DRESSER'S HEAD WITH SENSOR 380V RFRW	29RI-04471-AA	1
9b	DELTA TIP-DRESSER'S HEAD WITH SENSOR 380V RFA	29RI-04471-AB	1
9c	DELTA TIP-DRESSER'S HEAD WITH SENSOR 500V RFRW	29RI-04471-AS	1
9d	DELTA TIP-DRESSER'S HEAD WITH SENSOR 500V RFA	29RI-04471-AR	1

SINTERLEGHE s.r.l.

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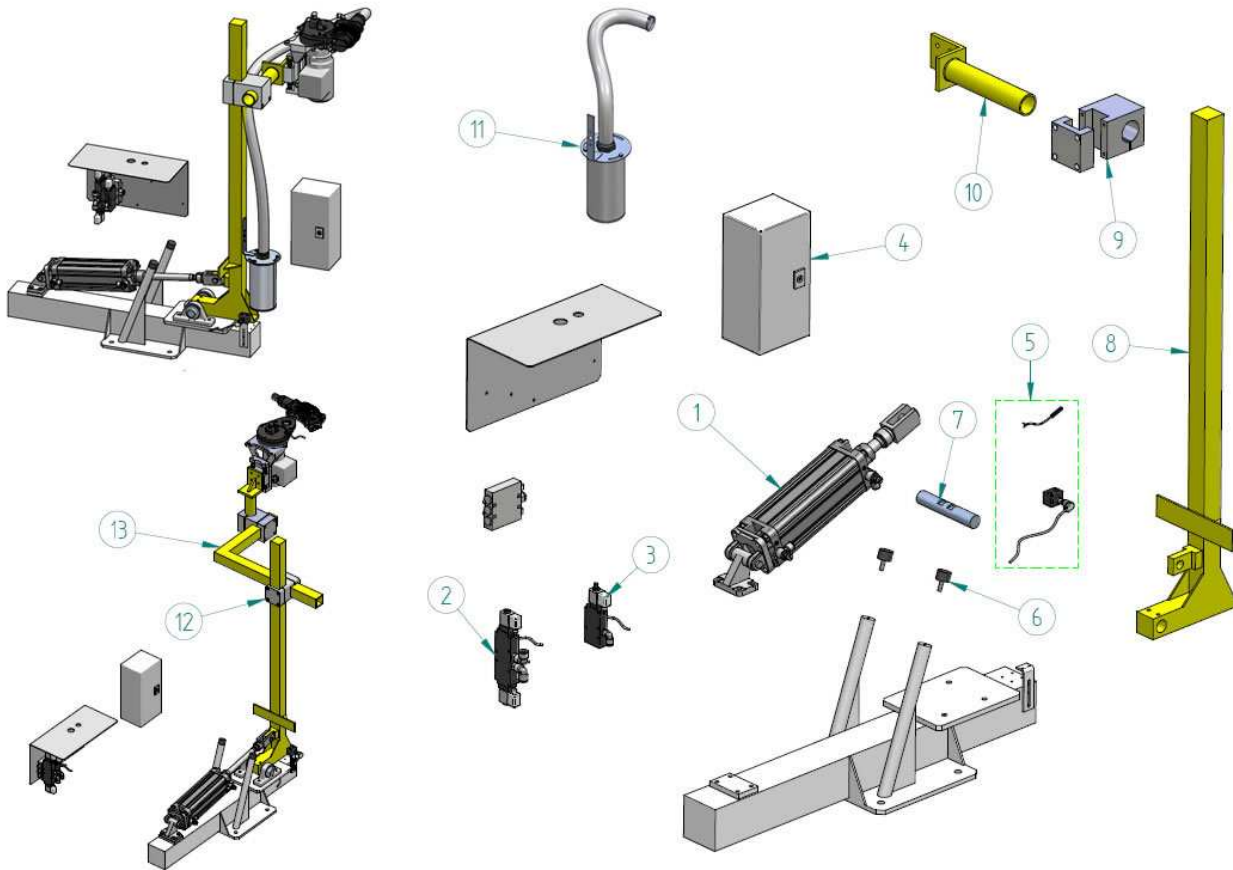
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POS.	SPO A SPARE PARTS	CODE	PCS.
1	COMPLETE CYLINDER KIT FOR SPO A	19RA-04699	1
2	SOLENOID VALVE WITH CABLE FOR SPO A CYLINDER	29RI-04473	1
3	SOLENOID VALVE WITH CABLE	29RI-04400	1
4	SPO-A ELECTRIC BOX	18QR-03461	1
5	POSITION SENSORS SPO A	29RI-04475	1
6	ANTIVIBRATION MOUNTING D30XH20 MM8X25	19RA-03990	2
7	SPO A HUB Ø30 L170 C40	10BO-04137	1
8	SWIVEL ARM SPO A L1200 Q50X50	10BO-04099	1
9	SQUARE-ROUND CROSS CLAMP 50X50 Ø50	19RA-01269	1
10	FLANGE FOR TIP DRESSER'S HEAD SPO A L450 Ø50	10BO-05038	1
11	CYLINDRICAL SWARVES TRAY WITH PIPE	29RI-04826	1
12	OPTIONAL: SQUARED CROSS CLAMP 50X50	19RA-01446	1
13	OPTIONAL: INTERMEDIATE "L" SHAPED ARM SPO A L400X600 Q50X50	10BO-04100	1