

ELECTRIC SWIVELLING UNIT SPO E

code 99BE-03730 = SPO E

Code: **MD_C04**

Review date: 080529

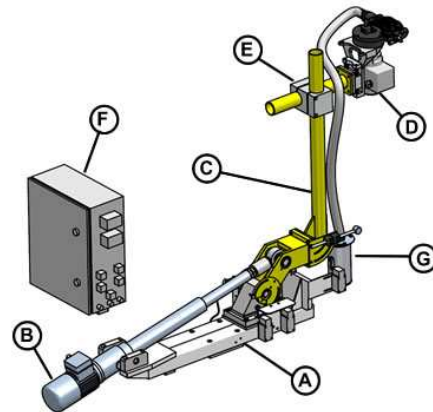
TOTAL QUALITY MANAGEMENT



RAVITEX®
 dressing quality

SPO E electric swivelling unit consists of:

- A: beam supporting a cylinder
- B: swivelling arm motion system, including an electric cylinder, joints and bearings.
- C: swivelling arm supporting the tip-dresser's head
- D: 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.
- E: cross clamp allowing height and position adjustments of the tip-dresser's head.
- F: power and command box.
- G: cylindrical box for the storage of copper swarves.



APPLICATION: STATIONARY WELDING GUNS

Complies with directives 89/392 EEC

OVERALL DIMENSIONS

X (length) = 1500 - 2000 mm
 Y (width) = 310 mm
 Z (height) = 400 - 1300 mm
 Swivel extent = 110°
 Maximum load @ L =1000mm: 35 Kg.
 Overall weight: 120 Kg

INTERFACE

Beam (A) = 1000x200x80 mm
 4x Ø 13 holes for M12screws distance between holes 120x150mm
 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.

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
 2 x slowing down induction sensor
 2 x mechanical switches for work and rest positions
 2 x mechanical safety switches for work and rest positions

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

Motor = electric asynchronous three-phase with clutch.
 Voltage = 380/480 or 500 VAC
 Frequency = 50/60 Hz
 Power= 0.550 Kw
 Cylinder linear speed = 117mm/sec.
 Cylinder stroke = 300 mm

MAINTENANCE

Lubrication = permanent
 Tip-dresser's head= multipurpose grease with PTFE
 Reduction unit= sintetic 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.

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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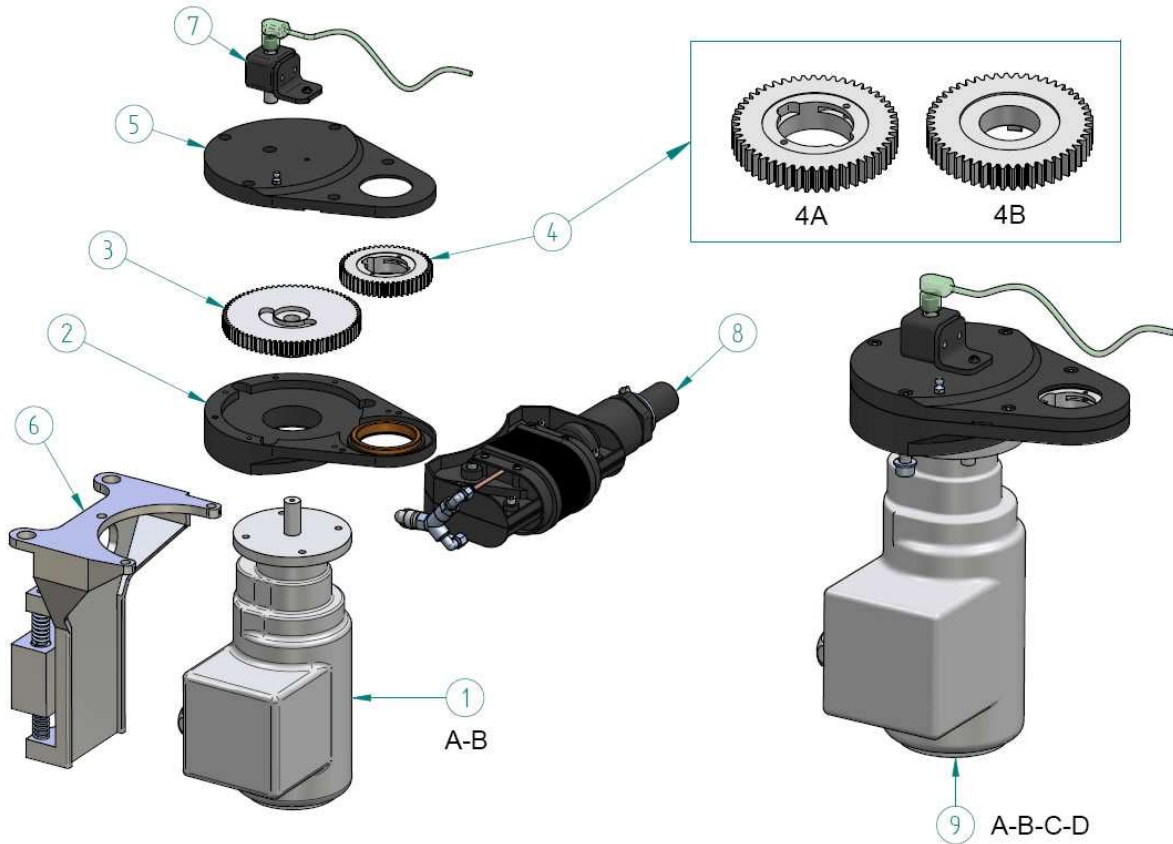
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POS.	SRE DELTA TIP DRESSER'S HEAD SPARE PARTS	CODE	PCS.
1a	GEARMOTOR 0,37KW/380-480V/50-60HZ	07E3-02409	1
1b	GEARMOTOR 0.37KW/500V/50HZ	07E3-02878	1
2	LOWER CARTER WITH BUSH	28RA-03376	1
3	SRE DELTA MOTOR GEAR	06I4-01726	1
4a	CUTTER HOLDER GEAR RFRW 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-04470-AS	1
9d	DELTA TIP-DRESSER'S HEAD WITH SENSOR 500V RFA	29RI-04470-AR	1

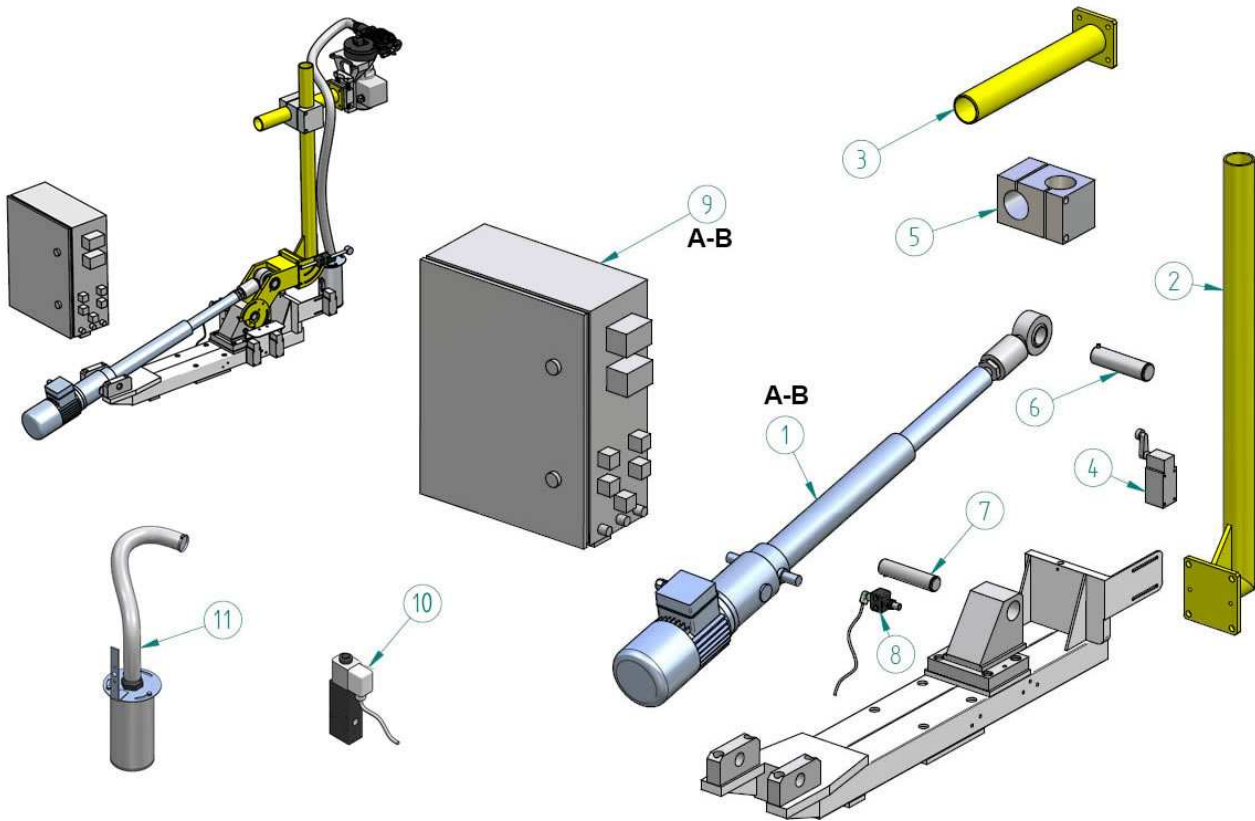
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POS.	SPO E SPARE PARTS	CODE	PCS.
1a	MOTION ACTUATOR FOR SPO E 380V WITH JOINT	07E3-03320	1
1b	MOTION ACTUATOR FOR SPO E 500V WITH JOINT	07E3-03805	1
2	SPO E "L" SHAPED ROUND ARM 930mm FE420	10BO-02924	1
3	SPO E FLANGE FE420 L 400mm	10BO-02324	1
4	MECHANICAL STROKE-END SWITCH	29RI-04851	4
5	ROUND CROSS CLAMP Ø60	19RA-04778	1
6	SHAFT FOR RING NUT AND EYELET	19RA-02798	1
7	ACTUATOR SIDE SHAFT	19RA-02616	1
8	COMPLETE SLOWING DOWN SENSOR	29RI-04850	2
9a	COMPLETE ELECTRIC BOX SPO E 380V	18QR-03251	1
9b	COMPLETE ELECTRIC BOX SPO E 500V	18QR-03932	1
10	SOLENOID VALVE WITH CABLE	29RI-04400	1
11	CYLINDRICAL SWARVES TRAY WITH PIPE	29RI-04826	1