

ELECTRIC SWIVELLING UNIT SPO EV
 code 99BE-04906= SPO EV

Code: **MD_C04**

Review date: 080529

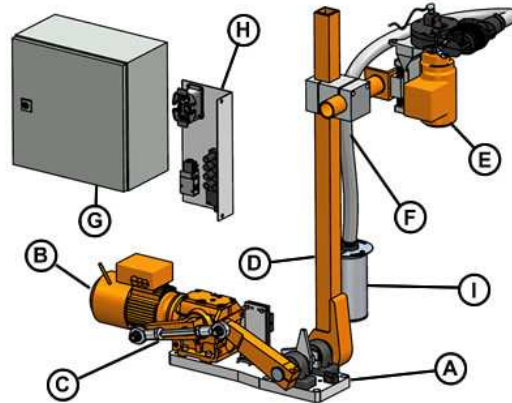
TOTAL QUALITY MANAGEMENT



RAVITEX®
 dressing quality

The electric swivelling unit SPO EV consists of:

- A: base plate
- B: bevel gearmotor for the movement of the swivel arm.
- C: system of pivoting arms for the connection of the swivel arm to the bevel gearmotor.
- 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: cross-clamp for the setting of tip-dressing position.
- G: power and control box.
- H: plate for electric and pneumatic connections.
- I: cylindrical box for copper swarves.



APPLICATION: STATIONARY WELDING GUNS

Complies with directives 89/392 EEC

OVERALL DIMENSIONS

X (length) = 880 mm
 Y (width) = max 310 mm with standard head configuration
 Z (height) = max 1380 mm
 Swivel angle = 89.5°

Overall weight: 85 Kg

INTERFACE

Base plate (A) = 520x160x30 mm
 Fixing = 4 holes Ø 13 distance between holes 130 x 170 mm for M12 screws
 Tip dressers head = 4 screws M10 distance between holes 40x40 mm.

Tip dressing position= the swivelling units are supplied with the possibility to be set along 2 axis. A third axis is optional.

PNEUMATIC AND ELECTRIC CONNECTIONS

Power = 0.37 Kw Frequency = 50/60 Hz
 Voltage= 380/480 or 500 VAC + 24 VDC
 Current: 1.05 A (380V-50Hz)
 1.15A (480V-60Hz)
 0.84 A (500V-50 Hz)

Duty cycle = S2-10 sec.
 Suitable air flow rate = 450 l/min at 6 bar
 Inner diameter of air pipes = Ø 6 mm
 Air supply= 5+8 bar - ISO 8573 Classe 3.4.3
 N°2 sensori induttivi di rallentamento.
 N°1 mechanical switch for working and rest positions

TIP DRESSER'S FEATURES

Distance between cutter center/carter edge= 42 mm
 Tip dresser's head height H = 20 mm
 Cutter rotation speed loadless = 200 g/min
 Cutting rotation direction = orario
 Equalisation range = +/- 10 mm
 Standard cutter-holder gear= 34R0-10021

MOTION ACTUATOR

Motor= bevel gearmotor with self ventilation
 Voltage= 380/420 VAC.
 Frequency = 50 Hz
 Power = 0.37 kW
 Current= 1.12 A

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
 Motion actuator= sin ISO VG 220

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 COLOR SCHEME

Structural steelwork = RAL 1019
 Moving parts= RAL 2000
 Motors = RAL 2000

WARRANTY

12 months wearable or spare parts excluded

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POS.	SRE DELTA TIP DRESSER'S HEAD SPARE PARTS	CODE	QTY
1	GEARMOTOR 0,37KW/380-480V/50-60HZ	07E3-02409-AQ	1
2	LOWER CARTER WITH BUSH	28RA-03376	1
3	SRE DELTA MOTOR GEAR	06I4-01726	1
4	CUTTER HOLDER GEAR RFRW WITH PLUNGERS	34R0-10021	1
5	UPPER CARTER WITH BUSH	28RA-03375	1
6	HEAD SUPPORT WITH EQUALIZATOR	28HM-03381	1
7	SENSOR GROUP WITH CABLE	29RI-04401-A1	1
8	PLASTIC SUCTION DEVICE WITH BRUSHES AND PNEUMATIC CONNECTION	29RI-04588-AH	1
9	DELTA TIP-DRESSER'S HEAD WITH SENSOR 380V RFRW	29RI-04471-AF	1
10	SOLENOID VALVE WITH CABLE	29RI-04400-AF	1

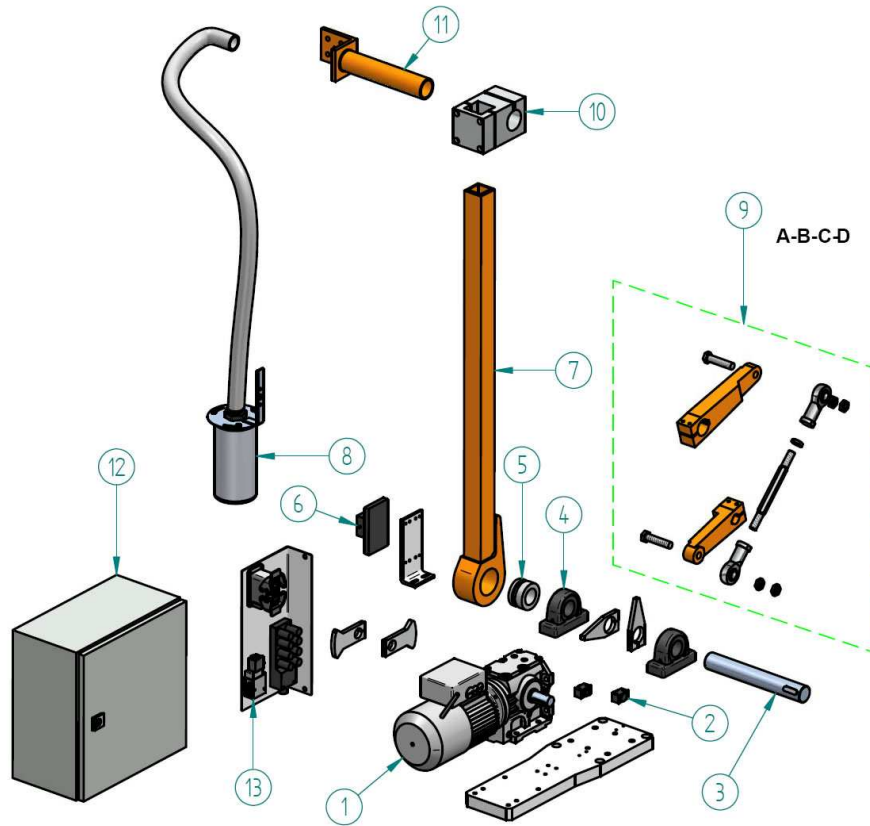
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POS.	SPO EV SWIVELLING UNIT SPARE PARTS	CODE	QTY
1	MOTORGear 0,55kW/440V/60Hz	07E3-04891-AQ	1
2	M18X1 SENSOR WITH CABLE AND CLAMP	29RI-04908-A1	2
3	SHAFT WITH KEY	19RA-04904	1
4	RSHE40-N SUPPORT	19RA-04893	2
5	LOCKING SET RLK 130 40X65	19RA-04892	1
6	SPO EV POSITIONING SENSOR	08S2-05022	1
7	SPO EV SWIVELLING ARM	19RA-04883-AQ	1
8	CYLINDRICAL SWARVES TRAY WITH PIPE	29RI-04826	1
9a	LINKAGE KIT SPO EV (BAR LENGTH L=184 mm)	19RA-04905	1
9b	LINKAGE KIT SPO EV (BAR LENGTH L=190 mm)	42K0-10068	1
9c	LINKAGE KIT SPO EV (BAR LENGTH L =196 mm)	42K0-10069	1
9d	LINKAGE KIT SPO EV (BAR LENGTH L =204 mm)	42K0-10070	1
10	CROSS CLAMP SQUARE 50X50 ROUND D50	19RA-01269	1
11	FLANGE FOR TIP DRESSER'S HEAD SPO A L450 Ø50	10BO-05038-AQ	1
12	SPO EV ELECTRIC BOX	25Q0-10001-AP	1
13	SPO EV PLATE FOR CONNECTIONS	25Q0-10028	1