

ELECTRIC TIP-DRESSER SRE R CPU DELTA TWIN

Code 99SE-04577 = SRE R CPU DELTA TWIN

Code: **MD_C04**

Review date: 080529

TOTAL QUALITY MANAGEMENT



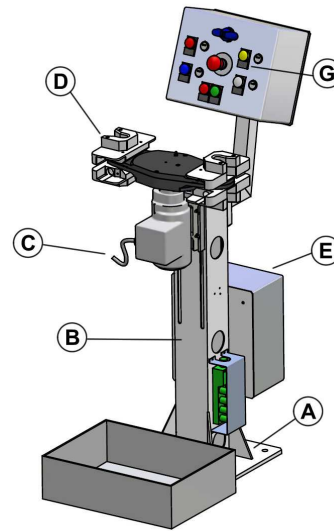
RAVITEX®
 dressing quality

SRE R CPU DELTA TWIN tip dresser consists of:

- A : base plate.
- B : pillar welded to the base plate.
- C : double tip-dresser's head including an electric motor (380 V) and a gear train for the transmission of the motion to the cutter.
- D : safety centering device for manual welding guns
- E : pneumatic group.
- F : electric box.
- G : control board for the tip-dressing operations.

Operators are informed of the tip dressing necessities through light signals. During tip-dressing welding power is automatically deactivated and restored as the process ends positively.

Tip dressing parameters are set from the welding box and can be modified only by maintenance staff, not by in-line operators. As a result, tip-dressing cycles are objectively performed and repeated. The CPU controls up to 4 welding guns.



APPLICATION: FROM 1 UP TO 4 HANGING MANUAL WELDING GUNS WITH DIFFERENT ELECTRODES PAIRS

In compliance with the Machinery Directive 89/392 EEC

OVERALL DIMENSIONS

X (length) = 700 mm
 Y (width) = 450 mm
 Z (adjustable tip-dressing height) = 430 - 860 mm
 Z (maximum overall height) = 1200 mm
 Overall weight: 45 Kg

INTERFACE

Base(A): 300x300 mm, 4x Ø 14 holes for M12screws
 distance between holes 230x230 mm
 Tip dresser's head = 4x M10 screws
 distance between holes 70x70 mm.

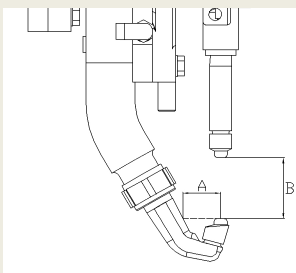
ELECTRIC AND PNEUMATIC CONNECTIONS

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)
 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
 Standard cutter holder gear= 34R0-10021

COLLISION CHECK WELDING GUN – TIP-DRESSER



DIMENSION
(mm)

HEAD MODEL

B ≥ 23

Minimum dimension for all tip-dressers heads

31 ≤ A < 43

DELTA RV

A ≥ 43

DELTA

A ≤ 31

Advise with Sinterleghe

MAINTENANCE

Lubrication = permanent
 Tip-dresser head = multipurpose grease with PTFE
 Reduction unit= synthetic oil ISO VG 320

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

WARRANTY

12 months, wearable and spare parts excluded.

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SINTERLEGHE s.r.l.

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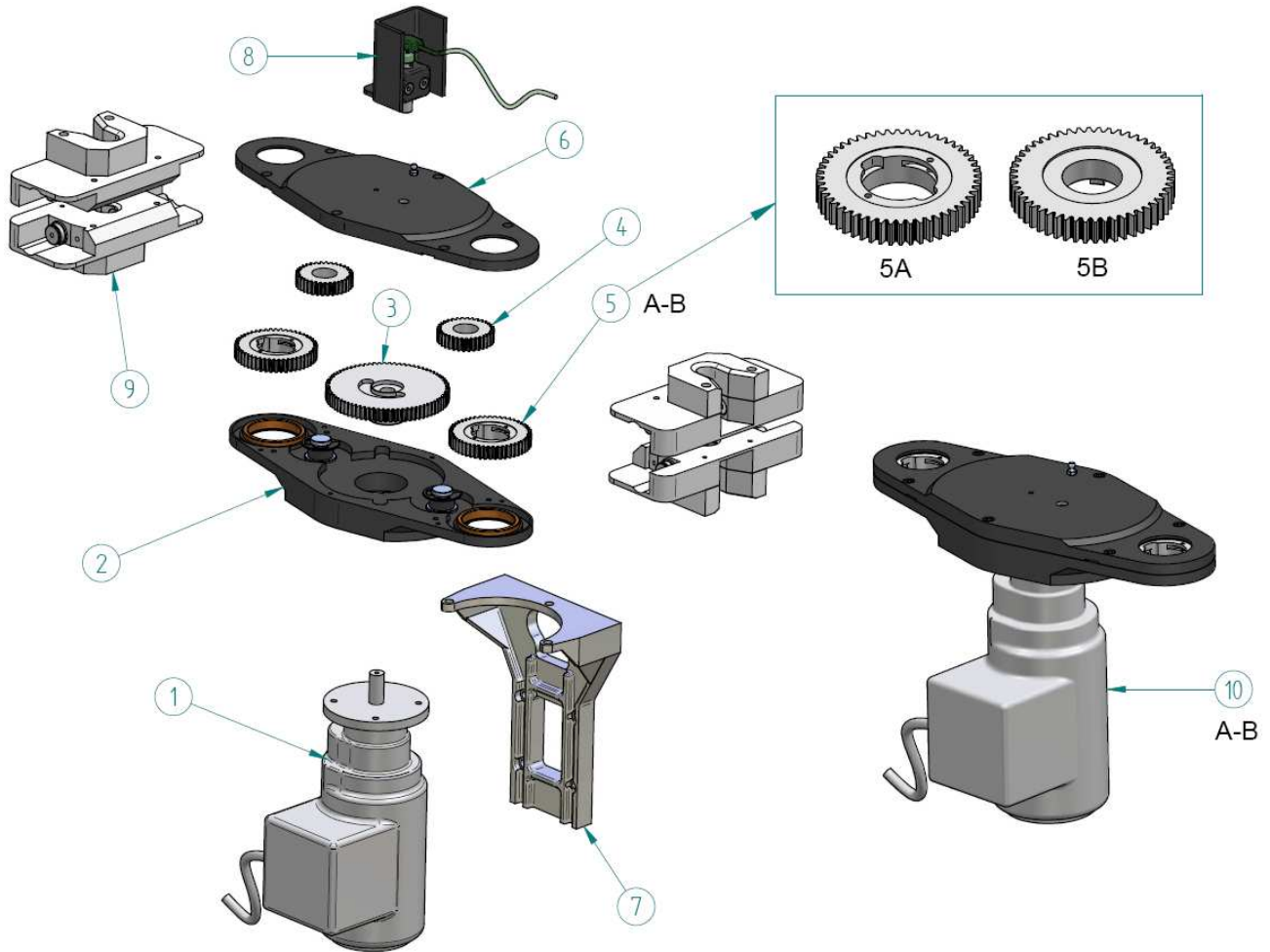
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POS.	SRE R CPU DELTA TWIN TIP DRESSER'S HEAD SPARE PARTS	CODE	PCS.
1	GEARMOTOR 0,37KW/380-480V/50-60HZ	07E3-02409	1
2	SRE DELTA TWIN LOWER CARTER WITH BUSHES AND PIVOTS	28RA-04629	1
3	SRE DELTA MOTOR GEAR	06I4-01726	1
4	SRE R DELTA TWIN/SCA NEUTRAL GEAR	06I4-03224	2
5a	CUTTER HOLDER GEAR RFRW WITH PLUNGERS	34R0-10021	2
5b	CUTTER HOLDER GEAR FOR RFA BUSHES	06P4-02474	2
6	SRE DELTA TWIN UPPER CARTER WITH BUSHES	28RA-04630	1
7	MACHINED HEAD SUPPORT 70X70	13HM-03992	1
8	SENSOR KIT WITH CABLE AND PROTECTION	28RA-04561	1
9	SAFETY SENSOR GROUP SRE R CPU DELTA	28RA-04092	2
10a	SRE-DELTA TWIN TIP-DRESSER'S HEAD RFRW	141D-03215-AA	1
10b	SRE-DELTA TWIN TIP-DRESSER'S HEAD RFA	141D-03215-AB	1



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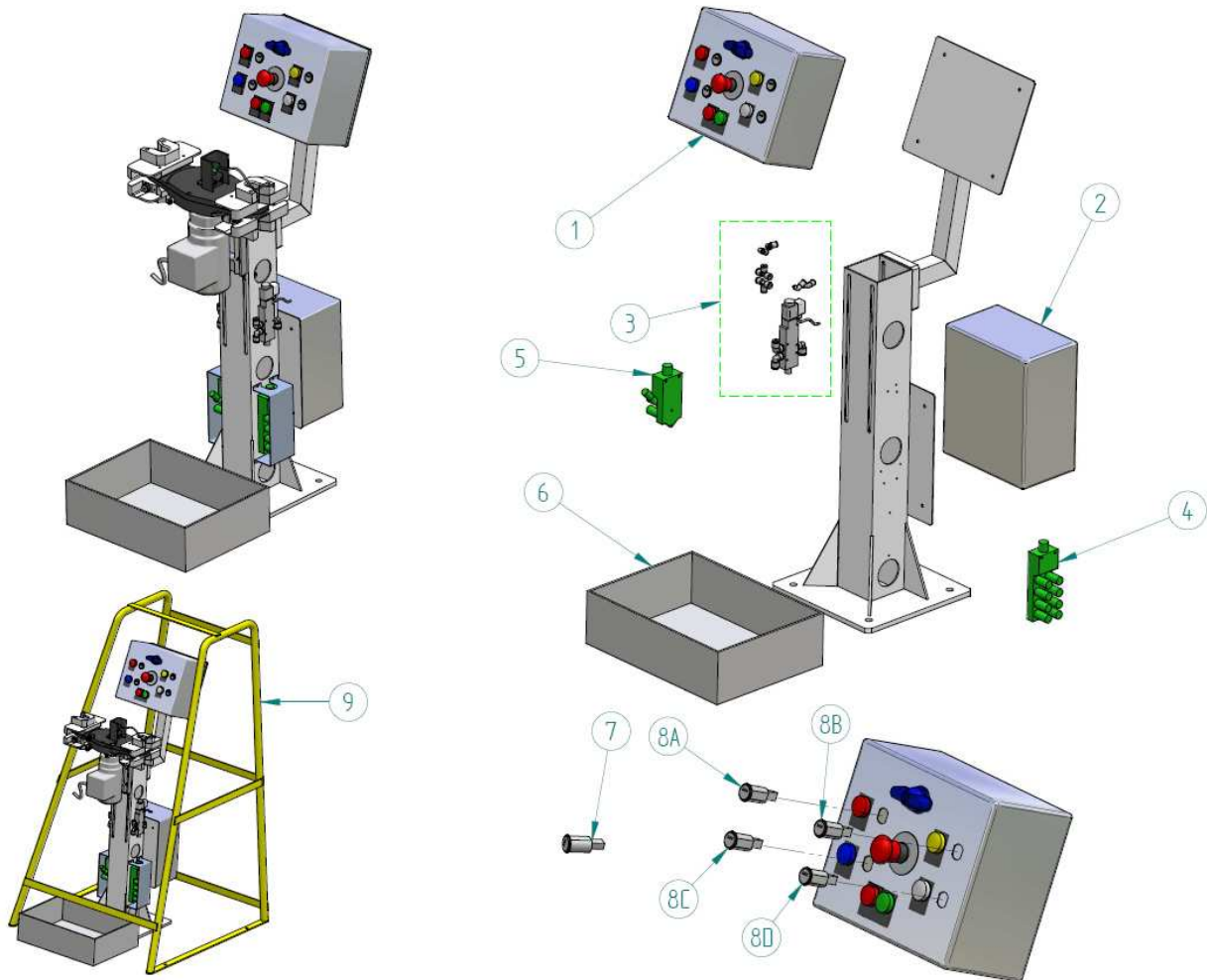
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POS.	SRE R CPU DELTA TWIN SPARE PARTS	CODE	PCS.
1	CONTROL BOARD SRE R CPU DELTA TWIN	18QR-04625	1
2	POWER BOX SRE R CPU DELTA	18QR-03959	1
3	PNEUMATIC GROUP SRE-RCPU WITH PIPES AND CONNECTIONS	29RI-04619	2
4	PASSIVE SPLITTER BOX 8 CHANNELS 1 SIGNAL 24VDC	12S4-04527	1
5	PASSIVE SPLITTER BOX 4 CHANNELS 1 SIGNAL 24VDC	12S4-04583	1
6	SWARVES TRAY 400X300X120 GRAY	21BX-04231	1
7	MULTILOCK COMBINATION "B" + NUT	18QR-04492	1<N<4
8A	MULTILOCK COMBINATION "A1" + NUT	18QR-04493	1
8B	MULTILOCK COMBINATION "A2" + NUT	18QR-04494	1
8C	MULTILOCK COMBINATION "A3" + NUT	18QR-04495	1
8D	MULTILOCK COMBINATION "A4" + NUT	18QR-04496	1
9	OPTIONAL: PROTECTION FOR SRE R CPU DELTA	13HM-04543	1