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VIBRATION WELDER

INPUT

Power supply (min.)	c.s. 400V 50Hz Three-phase-N-T.
Pneumatic power	5 bar
Maximum power required	30 kW

OUTPUT

Upper laying weight	75-180 Kg.
Generator power	27 A.
Vibration frequency	100-120 Hz.
Vibration amplitude	up to 4 mm.
PP equivalent welding area	600 cm ² .

MECHANICAL DATA

Vibration table dimensions	1420 mm x 500 mm.
Table stroke	800 mm.
Table maximum speed	250 mm/s.
Maximum thrust (Hydraulic movement)	36 kN net.
Lifting table dimensions	1800 mm x 850 mm.
Table height	710 mm.
Front door span	1800 mm x 1160 mm.
Upper door threshold	1800 mm.
Clearance between planes	1100-1500 (adjustable) mm.
Overall dimensions	W 3500 mm x D 2000 mm x H 2900 mm.
Total weight	8700 Kg.
Hydraulic oil	180 Lt. / ISO32.

CONTROL

PLC Control	SIEMENS S7-CPU IM151-ET200.
Operating panel	SIEMENS TP277 10 inch.
Vibration frequency tuning	Continuous REALTIME *
Welding phases	8 (pressure, amplitude).
Welding depth sensitivity	0.01 mm.
Work settings memory	31 automatic equipment + 32 manual.
Type of communication	PROFIBUS.
The digital generator ensures very short swing on/off vibration phases (50ms)	

REFERENCES

Noise level	≤ 80 dB. (din 45835) **
Work outcome definition	automatic (good/reject).
Work outcome printer	CUSTOM PLUS.
Planes compatible with:	Branson 2790, 2900, 2913.M-2900H, M-2913H and M906.
Work pneumatic movements	Up to 8 valves and 2 vacuum circuits.
Tele-assistance	optional.
Rear door	optional.

* Thanks to our third-generation controller we have been able to eliminate the necessity of the auto-tuning cycle: the machine can adapt to the vibration frequency in real-time following the mechanical reactions of the vibrating system. Therefore, the outcome is a neater and more efficient vibration than the one obtained employing second-generation old systems.

** Peak values can be higher for short periods depending on the application.

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Hall 11 / C63





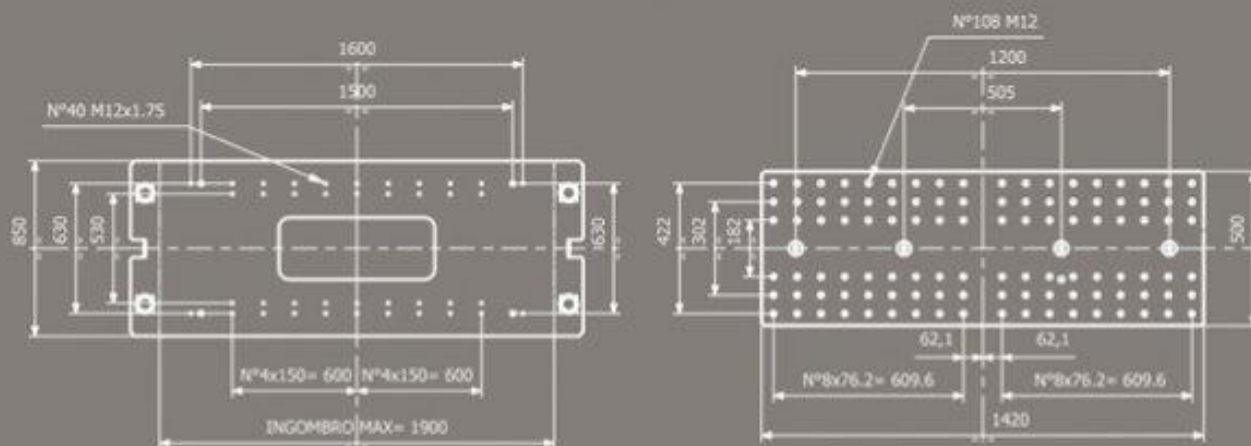
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DIMENSIONS



INTERNAL DIMENSIONS



THERMOPLASTICS MATERIALS WELDING SYSTEMS
 Cemas s.r.l. strada degli Occhioni 23 10022 Carmagnola TO
 Tel 0110712006 Fax 0110723456
www.cemaslettra.it info@cemaslettra.it

COMPANY
 WITH QUALITY MANAGEMENT
 SYSTEM CERTIFIED BY DNV
 ISO 9001:2000

As general agency of Cemas Elettra S.r.l. in Germany

Baum
 Baumstrasse 8-10 42699 Soltau +49
 D-03546 194
 D-03546 194
 Tel +49 (0) 3825 401-374 Fax +49
 3825 401-375
www.baum.de