

DR. FRITSCH

SONDERMASCHINEN

Brazing Machine

SLM 800



Dr. Fritsch Sondermaschinen GmbH, 70736 Fellbach, Germany

Technical Specification

SLM 800

- for steel center diameter 220 mm – saw blade diameter 2,000 mm (pit or substructure required as of saw blade Ø 1,600 mm)
- very short cycle and change-over times
- automatic adjustment of the blade thickness by central blade clamping
- automatic adjustment of segment thickness by central segment clamping
- automatic positioning of the saw blade by servomotor
- automatic height positioning of the saw blade by laser sensor
- brazing system with segment magazines, solder feed and inductor arranged at working height
- segment feed by means of two belt magazines
- programmable segment positioning
- two axis-controlled gripper systems for the automatic positioning of the segments on the blank
- adjustable contact pressure of the segments during the brazing process
- facility for brazing with temperature and time ramps
- easy operation by means of a touch screen operating panel which is adjustable in height
- active exhaustion of solder vapors

OPTIONS

- automatic flux feeding
- manual brazing of drop segments
- chiller
- quality control and quality documentation by connecting the IPA NT control system (available modules IPA NT Monitor, Organizer and Messenger)

DESIGN AND FUNCTIONING

- automatic feeder for silver solder
- electric drive for blade rotation
- blade rotation with forked light barrier or by entering the pitch in the program
- optimized cooling pads (copper)
- temperature measuring and control unit with optical pyrometer
- high-frequency generator (15 kVA), semi-conductor technology, with high efficiency and controlled output, included integrated air conditioner

The diameter adjustment of the saw blade is effected by means of a laser sensor allowing for the exact repeatability of the brazing position approach.

The cooled central clamping jaws allow for an equal clearance on both segment sides – independent of the blank thickness and the selected segments. The time-consuming positioning of the segments is no longer required.

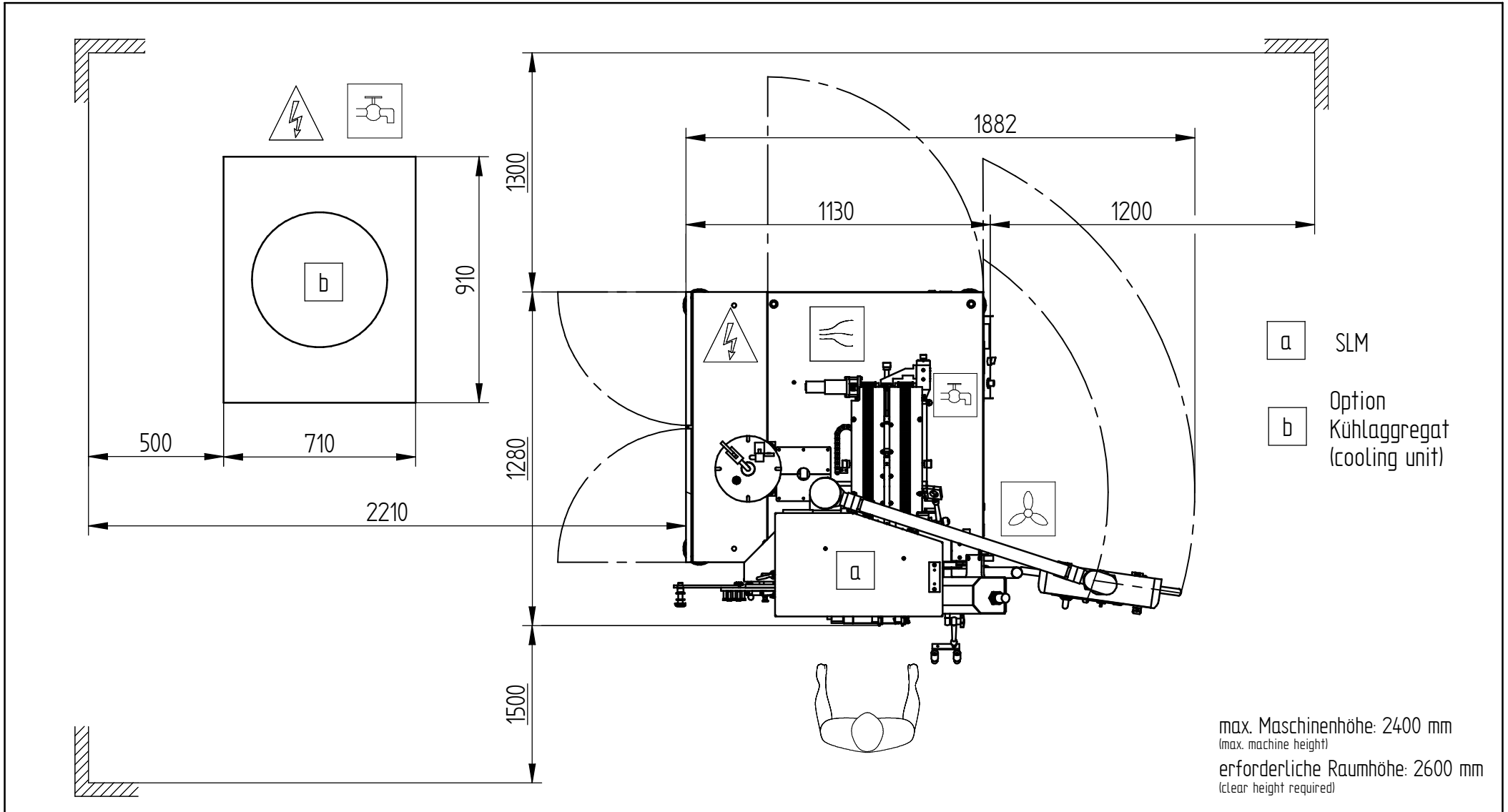
By means of an automatic feeder, the silver solder is supplied between the saw blade and the segments; the flux is applied automatically on the upper and lower side of the solder.

The segments are fed from the magazines and positioned on the saw blade by central grippers. The segments are brazed according to the preset parameters.

TECHNICAL DATA

Total connected load:	16 kVA
Supply voltage:	3 x 400 V, 50/60 cps other voltages upon request.
Total nominal current:	3 x 23 A
Protection by fuses	3 x 35 A (to be provided by the customer)
Cooling water:	
- pressure:	3 - 5 bar
- consumption:	approx. 10 l/min
- temperature:	min. 15 °C, max. 25 °C
Compressed air:	
- consumption:	approx. 250 l/min.
- pressure:	4 – 6 bar
Suction system:	to be provided by the customer
- connection:	connecting piece Ø 40 mm
- air flow:	approx. 600 m ³ /h
Diameter range:	min. steel center diameter 220 mm; max. saw blade diameter 2,000 mm (pit or substructure required as of saw blade Ø 1,600 mm)
Segment dimensions:	Length: 20 - 50.8 mm Thickness: 1.8 – 20 mm Height: 5 - 30 mm
Dimensions of machine:	Length: approx. 2,000 mm Depth: approx. 1,200 mm Height: approx. 2,300 mm
Weight:	approx. 800 kg

- Technical data and design are subject to modifications -



Symbol	Bedeutung (meaning)	Symbol	Bedeutung (meaning)	XX cm — —	DFT029052.dft ASM029050.asm		<h3>Aufstellplan</h3> <p>floor plan</p>																	
	Elektrik (electrics)		Gas (gas)		<table border="1"> <tr> <td></td> <td>Datum</td> <td>Name</td> </tr> <tr> <td>Bearb.</td> <td>11.10.2011</td> <td>P_Schaefer</td> </tr> <tr> <td>Gepr.</td> <td></td> <td></td> </tr> <tr> <td>Norm</td> <td></td> <td></td> </tr> </table>			Datum	Name	Bearb.	11.10.2011	P_Schaefer	Gepr.			Norm			<table border="1"> <tr> <td colspan="2">DR. FRITSCH</td> </tr> <tr> <td colspan="2">Sondermaschinen GmbH</td> </tr> <tr> <td colspan="2">D-70722 Fellbach</td> </tr> </table>	DR. FRITSCH		Sondermaschinen GmbH		D-70722 Fellbach
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	Pneumatik (pneumatics)		Wand (wall)			<p>Zeichnungs Nr.: 15E</p>	Bl. 3 / 4																	
	Kuehlwasser (cooling water)		Arbeiter (operator)																					
	Absaugung (suction)																							