

2. TILT AND TURN TABLES



200 tons tilt and turn table

- **HDL** Hollow shaft tilt and turn table, 125 – 500 kg
- **VDL** Height-adjustable hollow shaft tilt and turn table, 125 – 500 kg
- **HTZ** Tilt and turn table, 1000 – 3200 kg
- **HVZ** Height-adjustable tilt and turn table, 1000 – 3200 kg
- **HDN** Tilt and turn table, 5 – 50 t
- **HDV** Height-adjustable tilt and turn table, 5 – 25 t
- **DKT** Tilt and turn table, 200 t



2.2. PRODUCTION SERIES HTZ / HVZ

- Rotary drive via three-phase current motor with separate fan and posistor protection.
- Continuous regulation through frequency converter from 0.05 to 1.0 r.p.m..
- Tilt drive through toothed quadrant and spur-gear motor.

Tilt and turn tables		HTZ / HVZ 1000	HTZ / HVZ 2000	HTZ / HVZ 3200
Carrying force	kg	1000	2000	3200
Speed range	r.p.m.	0.05-1.0	0.05-1.0	0.05-1.0
Control range		1:20	1:20	1:20
Torque with 1 rotary drive	Nm	1000	2000	3200
Torque with 2 rotary drives	Nm	2000	4000	6400
Speed range (OPTION)	r.p.m.	0.0015 - 1.5	0.0015 - 1.5	0.0015 - 1.5
Control range (OPTION)		1:1000	1:1000	1:1000
Control accuracy (OPTION)	%	0.25	0.25	0.25
Tilting moment	Nm	4300	10000	16640
Tilting angle	degree	135	135	135
Tilting time for 90°	sec.			
Welding current transfer	Amp.	1000	1000	1000
Mains voltage	Volt	400	400	400
Current consumption (fuse protection)	Amp.	16	16	20
Weight of the device approx.	kg	1200	1300	1800
* Specifications subject to alterations				

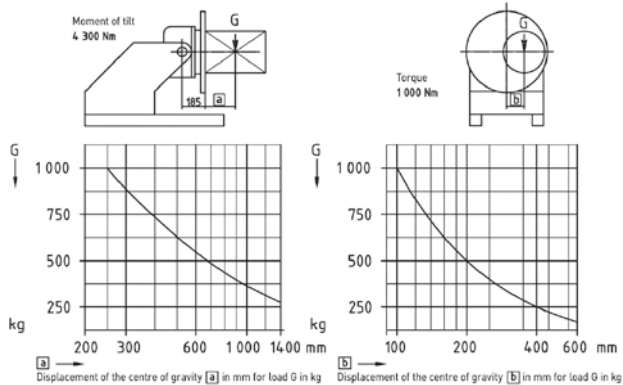
2.2.1. HTZ / HVZ 1000



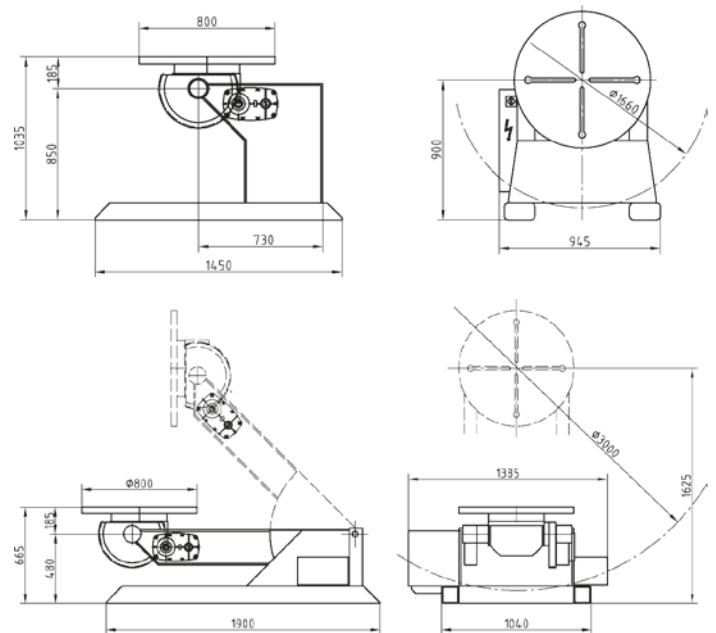
Tilt and turn table **HTZ 1000**

Tilt and turn table **HVZ 1000**

Load diagram



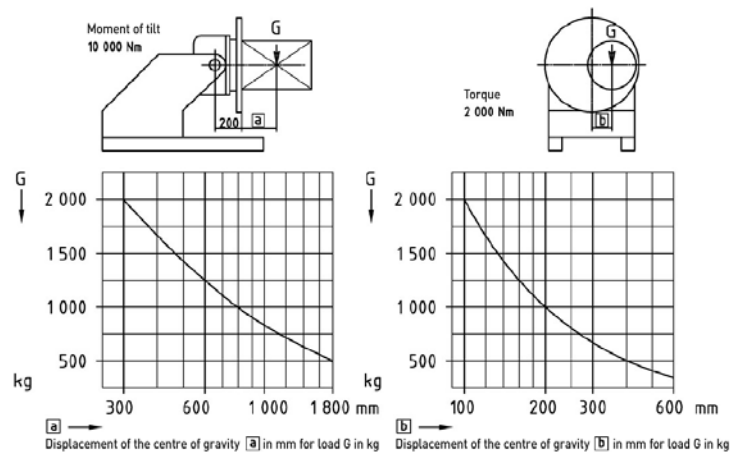
Dimensions





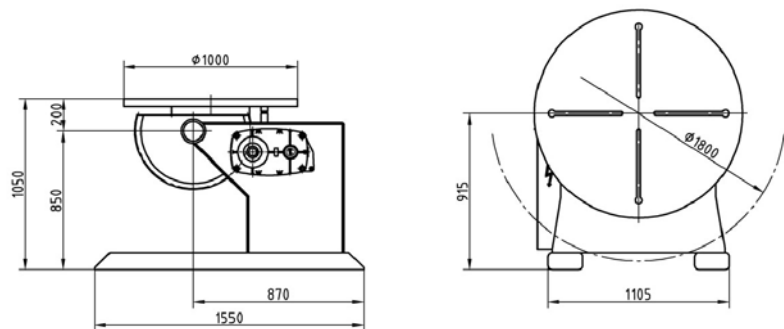
2.2.2. HTZ 2000 / HVZ 2000

Load diagram

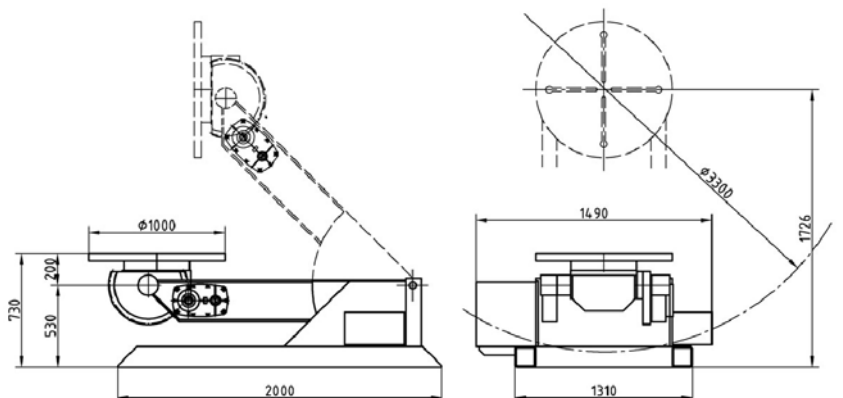


Dimensions

HTZ 2000



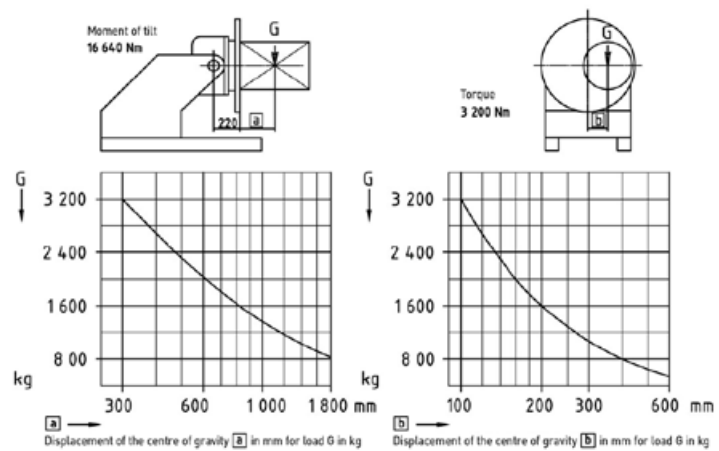
HVZ 2000





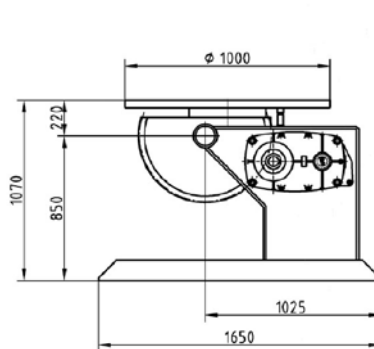
2.2.3. HTZ 3200 / HVZ 3200

Load diagram

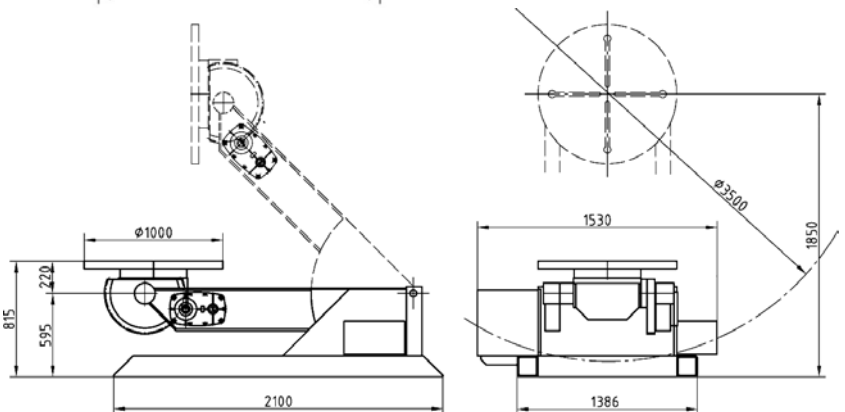


Dimensions

HTZ 3200



HVZ 3200



2.2.4. PRODUCTION SERIES HTZ / HVZ OPTIONS



- Rotary drive via AC servo motor and regulation via transistor converter for a control range of 1:1000 and control accuracy of 0.25 % at speeds of 0.0015 to 1.5 r.p.m.
- Rotational speed calculator
Automatic adjustment of the correct speed following digital pre-selection of the workpiece diameter from 1 to 5000 mm and speed of welding from 1 to 1000 mm/min.
adjustment of \varnothing in mm and in mm/min.
- Foot actuated switch turning „Left-Off-Right“ including protection hood



2.3. HTN / HDV PRODUCTION SERIES

- Completely operational with welding current transfer 1000 A.
- Mains cable, 7 m long, with remote control at the control cabinet; pluggable with 7 m long control cable.
- Table top in play-free pre-tensioned ball bearing slewing rim including precise and quenched and tempered internal gear
- Rotary drive through three-phase current motor with separate fan and posistor protection.
- Regulation through frequency converter.
- Continuous table top speed from 0.01 to 1.0 r.p.m.

Tilt and turn table		HDN / HDV 5	HDN / HDV 10	HDN / HDV 15	HDN / HDV 25
Carrying force	kg	5000	10000	15000	25000
Speed range	r.p.m.	0.001 - 1.0	0.001 - 1.0	0.001 - 1.0	0.001 - 1.0
Control range	1:1000	1:1000	1:1000	1:1000	
Control accuracy	%	0.25	0.25	0.25	0.25
Torque with 1 rotary drive	Nm	5000	10000	17250	26000
Torque with 2 rotary drives	Nm	10000	20000	34500	52000
Tilting moment	Nm	31750	76000	135000	241250
Tilting angle	degree	135	135	135	135
Tilting time for 90°	sec.	29	51	64	64
Table top diameter	mm	1000,1200	1200,1500	1750,2000	2000,2500
Welding current transfer	Amp.	1200	1200	1200	1200
Mains voltage	Volt	400	400	400	400
Current consumption (fuse protection)	Amp.	16	32	32	32
Weight of the device approx.	kg	1850/3000	3150/4900	5800/9500	10000/16000
* Specifications subject to alterations					

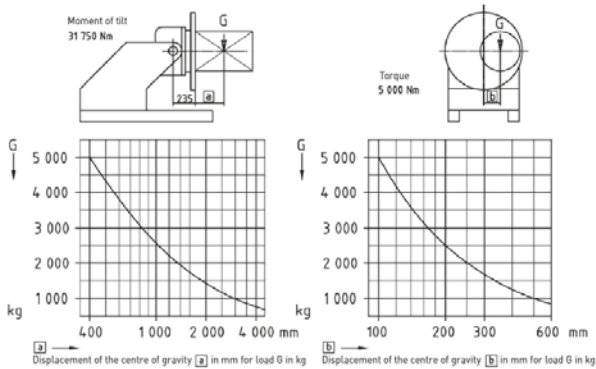
2.3.1. HDN / HDV 5 X 400



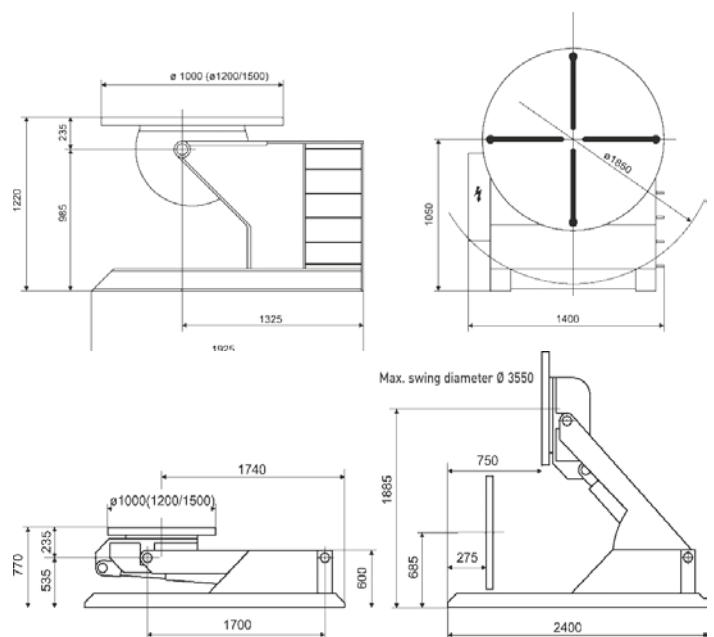
Tilt and turn table HDN 5 x 400

Tilt and turn table HDV 5 x 400

Load diagram



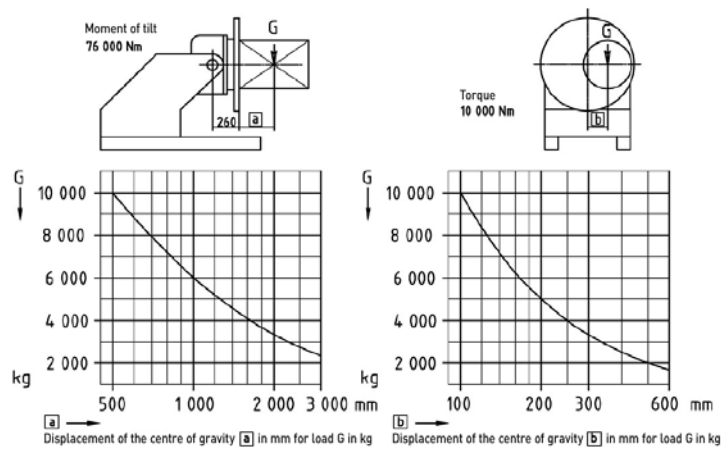
Dimensions



2.3.2. HDN / HDV 10 X 500

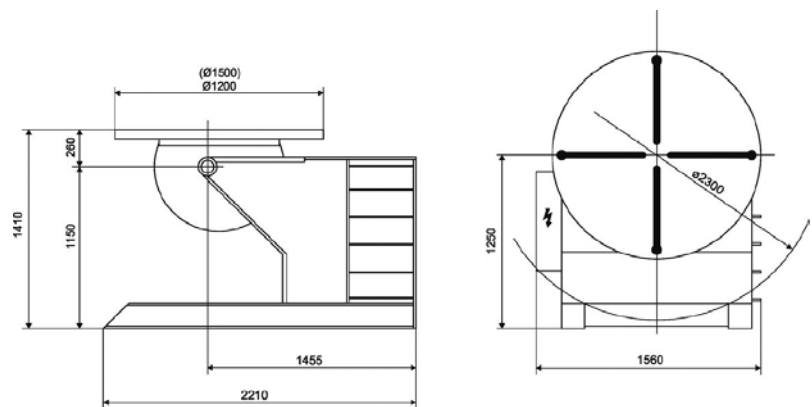


Load diagram

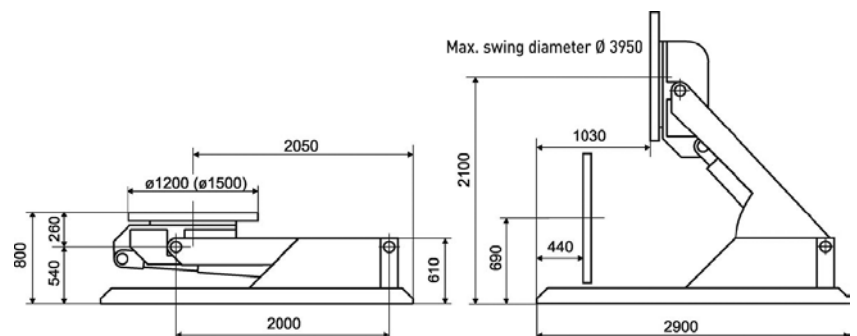


Dimensions

HDN 10 x 500



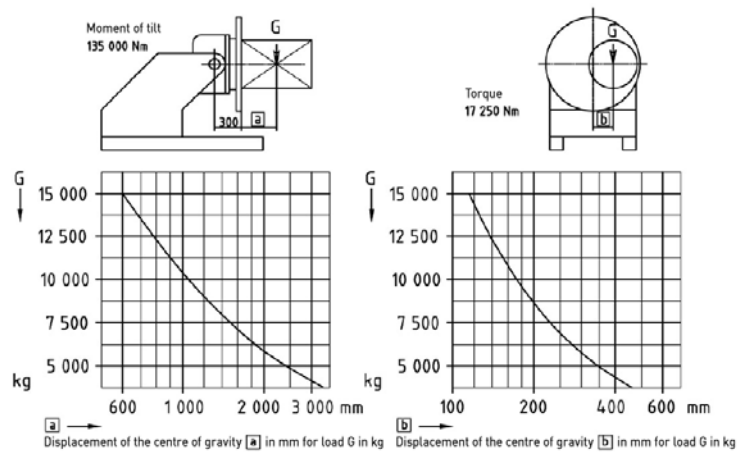
HDV 10 x 500



2.3.3. HDN / HDV 15 X 600

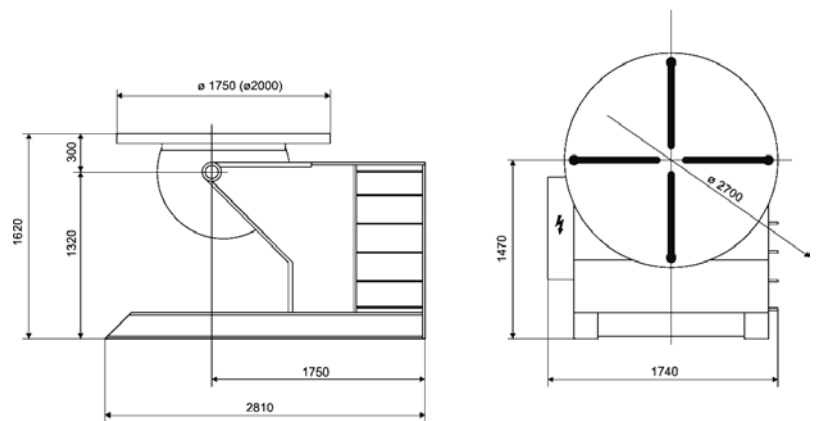


Load diagram

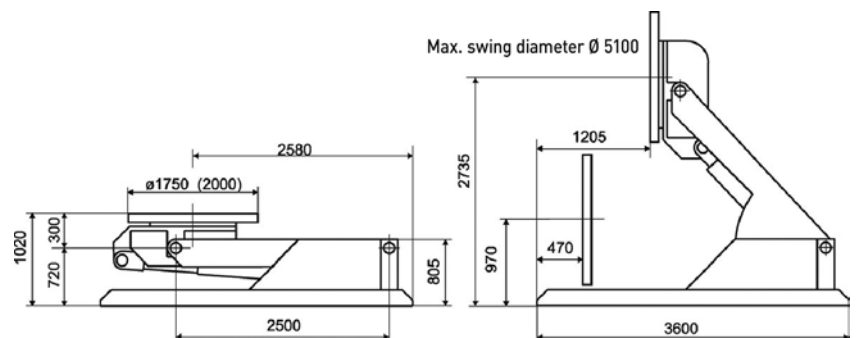


Dimensions

HDN 15 x 600



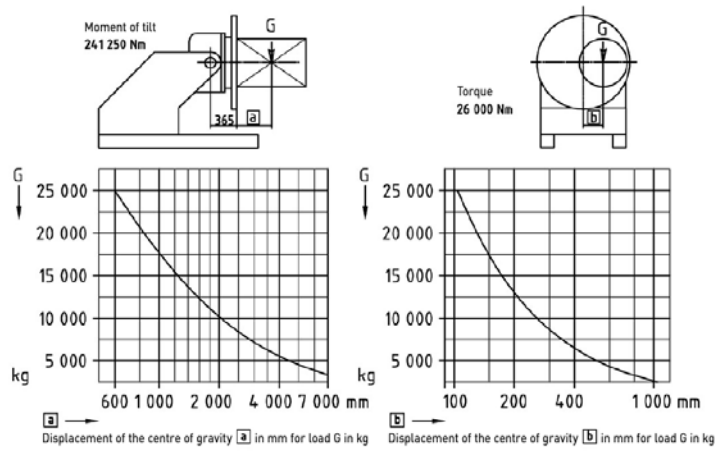
HDV 15 x 600



2.3.4. HDN / HDV 25 X 600

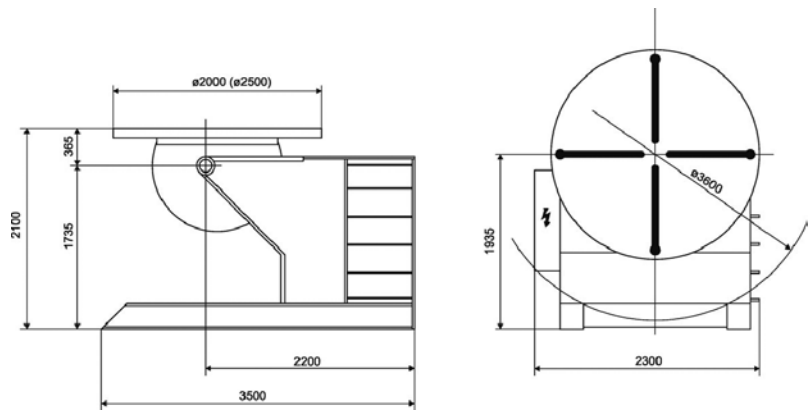


Load diagram

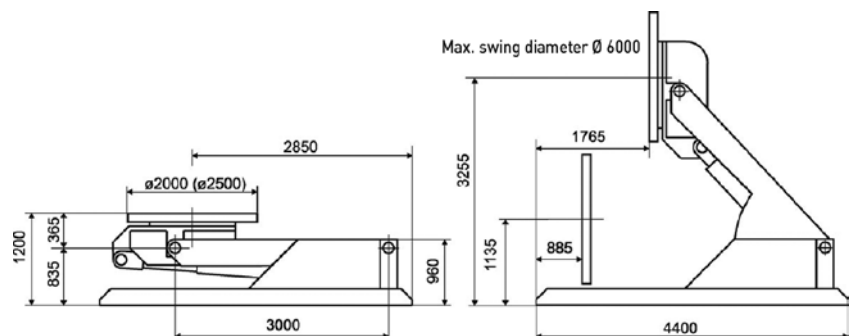


Dimensions

HDN 25 x 600



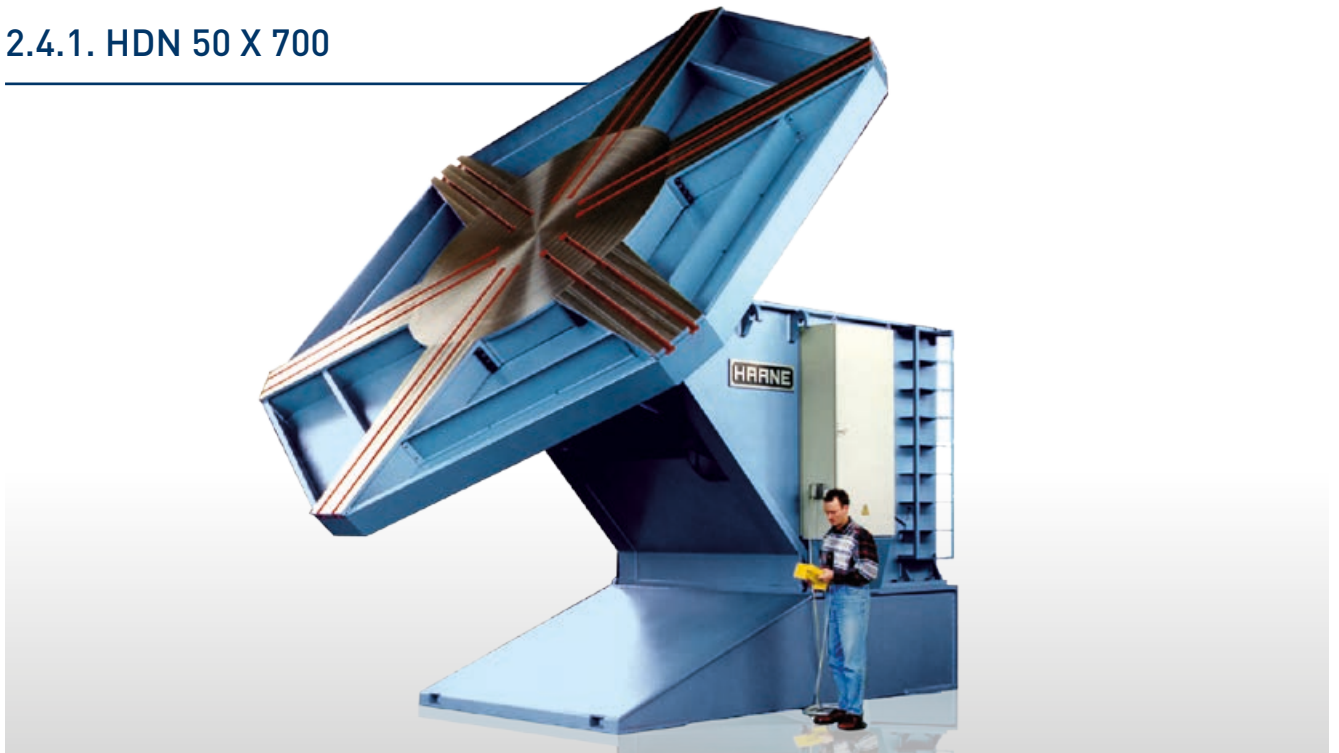
HDV 25 x 600





2.4. SPECIAL DESIGNS

2.4.1. HDN 50 X 700



Tilt and turn table		HDN 50 x 700
Carrying force	kg	50000
Speed range	r.p.m.	0.0045 - 0.9
Control range		1 : 200
Control accuracy	%	1
Torque with 1 rotary drive	Nm	45000
Torque with 2 rotary drives	Nm	90000
Tilting moment	Nm	610000
Tilting angle	degree	135
Tilting time for 90°	sec.	120
Table top diameter	mm	6000
Welding current transfer	Amp.	1200
Mains voltage	Volt	400
Current consumption (fuse protection)	Amp.	80
Weight of the device approx.	kg	42500

* Specifications subject to alterations

2.4.2. DKT 200



Tilt and turn table		DKT 200
Carrying force	t	200
Speed range	r.p.m.	0.0006 - 0.6
Control range		1 : 1000
Control accuracy	%	0.25
Torque with 1 rotary drive	kNm	220
Torque with 2 rotary drives	kNm	440
Tilting moment	kNm	8800
Tilting angle	degree	270
Tilting time for 90°	sec.	75
Table top diameter	mm	6000
Welding current transfer	Amp.	2500
Mains voltage	Volt	3 x 400
Current consumption (fuse protection)	Amp.	100
Weight of the device approx.	t	120

* Specifications subject to alterations

2.4.3. DKTV 50 HEIGHT ADJUSTABLE CRADLE-TYPE POSITIONER



Pre-programmable positions, PLC controlled, safety monitoring.



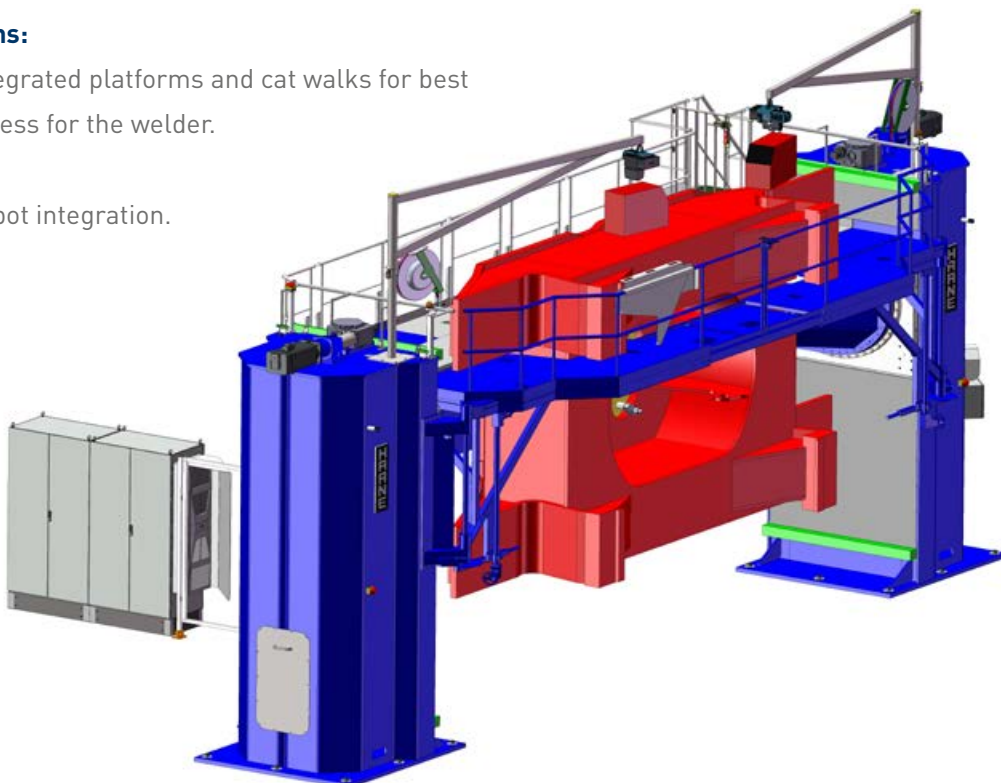
TECHNICAL DATA:

Load capacity:	50 t
Swing diameter:	7.640 mm
Rotation speed:	1 rpm
Turning time:	15 sec / 90°
Turning torque:	250.000 Nm
Height adjustment:	2.500 mm
Welding current transfer:	2.000 Ampere
Weight, unloaded:	45.000 kg

Options:

1: Integrated platforms and cat walks for best access for the welder.

2: Robot integration.



2.4.4. ALL KINDS OF CUSTOMIZED POSITIONERS



2.4.4.1 HDV 40 Height adjustable positioner for rotating and tilting, including a customized table plate.



TECHNICAL DATA:

Load capacity:	40.000 daN
Rotation speed:	0,8 rpm
Rotation torque:	80.000 Nm
Speed accuracy:	1:100
Tilting torque:	580.000 Nm
Tilting angle:	135°
Height adjustment:	2.770 mm
Table plate diameter:	6.000 mm
Swing diameter:	7.000 mm
Welding current transfer:	1.500 Ampere
Mains:	3 x 400 Volt
Fuse:	125 Ampere
Weight, unloaded:	36.000 kg