

## 4. L AND I - POSITIONER



For the welding of demanding elements, the handling using L- and I-positioners will be facilitated enormously. The L- and I-positioner production series has been derived from the standard components of the tilt and turn tables.

Dimensions such as turning diameter, weight and features will be adapted customer-specifically to the elements of the respective welding elements or to the respective case of application. The positioner can be used fully automatically in robot operation incl. indexing or for manual workplaces using the respective operator unit.



L-Positioner



I-Positioner



## 4.1. L AND I - POSITIONER 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 with precise and quenched internal gear.
- Rotary drive through three-phase current motor with separate fan and posistor protection.
- Regulation through frequency converter.
- Tabletop speed, continuously from 0.01 - 1.0 r.p.m..
- Lifting drive via trapezoidal threaded spindle, with integrated safety nut.

Positioner		L2 / I2	L3 / I3	L4 / I4	L5 / I5
Carrying force	kg	2000	3000	4000	5000
Speed range	r.p.m.	0.01 - 1.0	0.01 - 1.0	0.01 - 1.0	0.01 - 1.0
Torque	Nm	2000	3000	4000	5000
Tilting moment	Nm	8000/-	12000/-	16000/-	20000/-
Tilting angle	degree	359/-	359/-	359/-	359/-
Tilting speed	r.p.m.	0.5/-	0.5/-	0.5/-	0.5/-
Tilting time for 180°	sec.	60/-	60/-	60/-	60/-
Table top diameter	mm	1200	1200	1200	1200
Turning diameter acc. to UVV	mm	3500/-	3500/-	3500/-	3500/-
Welding current transmission	Amp.	1000	1000	1000	1000
Mains voltage	Volt	400	400	400	400
Current consumption (fuse protection)	Amp.	25	25	25	25
* Specifications subject to alterations					

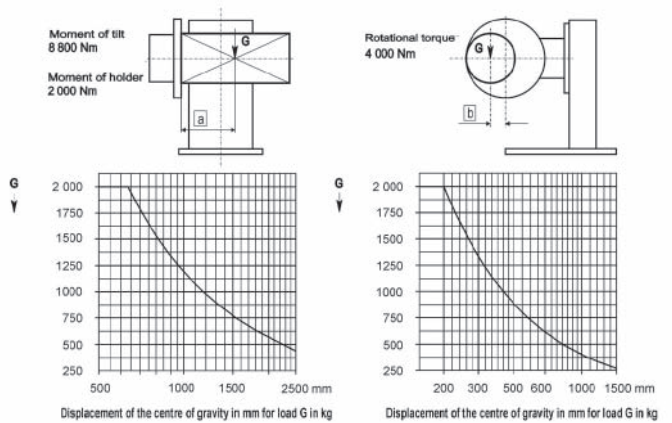
## 4.2. PRODUCTION SERIES – L AND I POSITIONER OPTIONS

- Rotary drive via AC servomotor and regulation via transistor converter for control range 1:1000 and control accuracy 0.25 % at speeds of 0.0015 - 1.5 r.p.m.
- Rotational speed calculator Automatic adjustment of correct speed following digital pre-selection of work piece diameter from 1 - 2000 mm and speed of welding from 1 - 1000 mm/min. Adjustment of  $\phi$  in mm and v in mm/min.
- Foot actuated switch turning „Left-Off-Right“ with protection hood

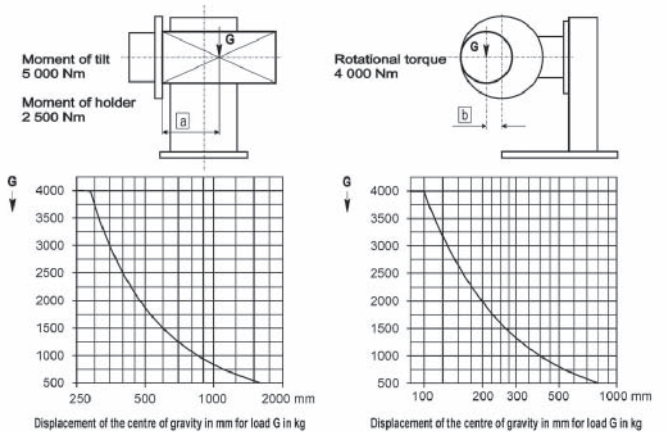


## 4.3. L AND I POSITIONER LOAD DIAGRAMS

### L2 / I2



### L4 / I4



### L5 / I5

