

PROMESS electro-mechanical assembly presses are particularly suitable for demanding joining, forming or testing tasks with integrated force-distance monitoring. A typical area of application is automated assembly processes that require high repeatability and monitoring of the joining quality, as well as documentation options.

DESIGN

The assembly press is based on a spindle with guidance, which is installed in a solid steel housing. The systems consist of robust mechanical components with AC servo motor, ball or roller gear drive spindle for converting rotational movement into linear movement, integrated force transducer for direct measurement of the joining forces, as well as the control.

KEY FEATURES

- Integrated force, position and signal control
- Real-time force-distance analysis directly in the servo amplifier
- No external analysis system required
- Safety brake for category 4 optional
- Envelope and window functions
- Robust, tried-and-tested servo drive technology, no special hollow shaft motor solution

ADDITIONAL FEATURES

- Absolute encoder eliminates the need for a reference run
- Positioning by means of external position transducers possible
- Only one measurement range required, thanks to high-precision force transducer
- Drift-free force measurement with high-precision strain gauge force transducer for push and pull forces
- All customary bus systems are supported
- Compensation against bending
- Service life of bearings and threaded drive >12 million cycles
- In-house production
- Most comprehensive range of assembly presses
- Modular design allows versatile equipment configurations



FUNCTIONAL PRINCIPLE

Actuation is performed by an AC servo motor. The rotational movement of the servo motor is transferred to the ball or roller gear drive and the press ram, where it is converted to linear movement. With the spindle drive, the assembly press is able to apply the full force both in push and pull directions. The sequence of movements can be easily specified using the included control and monitoring software. The envelope and window functions make full monitoring and documentation of the assembly process possible.



MAIN FUNCTIONS	
Nominal load	+/- 25kN
Stroke	350 mm
Nominal speed	250 mm/s
Acceleration	2000 mm/s ²
Dwell time of nominal load	at least 6 s
Weight	46,2 kg
Max. tool weight	10 kg *
FORCE MEASURING	
Characteristic value	0,5 mV / V
Transducer accuracy (dismantled)	0,5 %
System accuracy	< 1 %
Smallest measuring step	6,25 N
Amplifier / W*H*D	Alu. die-cast hous. / 64*35*58 mm
Output signal	+/- 10 VDC
Protection class	IP 54
DISTANCE MEASURING	
Resolution	0,5 µm/0,5 µm
Repeatability of positioning	< 0,01 mm **
DRIVE / (W*H*D)	
	SP1406 / (100*386*219 mm)
Mains voltage	3 AC 380 V - 480 V, +/-10%
Cable cross sectional – area	2,5 / 1,5 mm ²
Protection class	IP 20
Weight	5,8 kg
Recommended protection	IEC / 16 A
Temperature range	- 10 ... + 50 °C
Thermal power loss	158 W
ADDITIONAL INPUTS	
1x Analog / 1x Incremental	11 Bit / Encoder (max. 410 kHz)
INTERFACE PC	
	Ethernet / RS 485
PLC INTERFACE (24 VDC)	
Standard (Option)	3I / 4O (16I / 16O)
OPTION: PLC FIELDBUS	
INTERFACE	Profibus, CANOpen, Interbus, DeviceNet

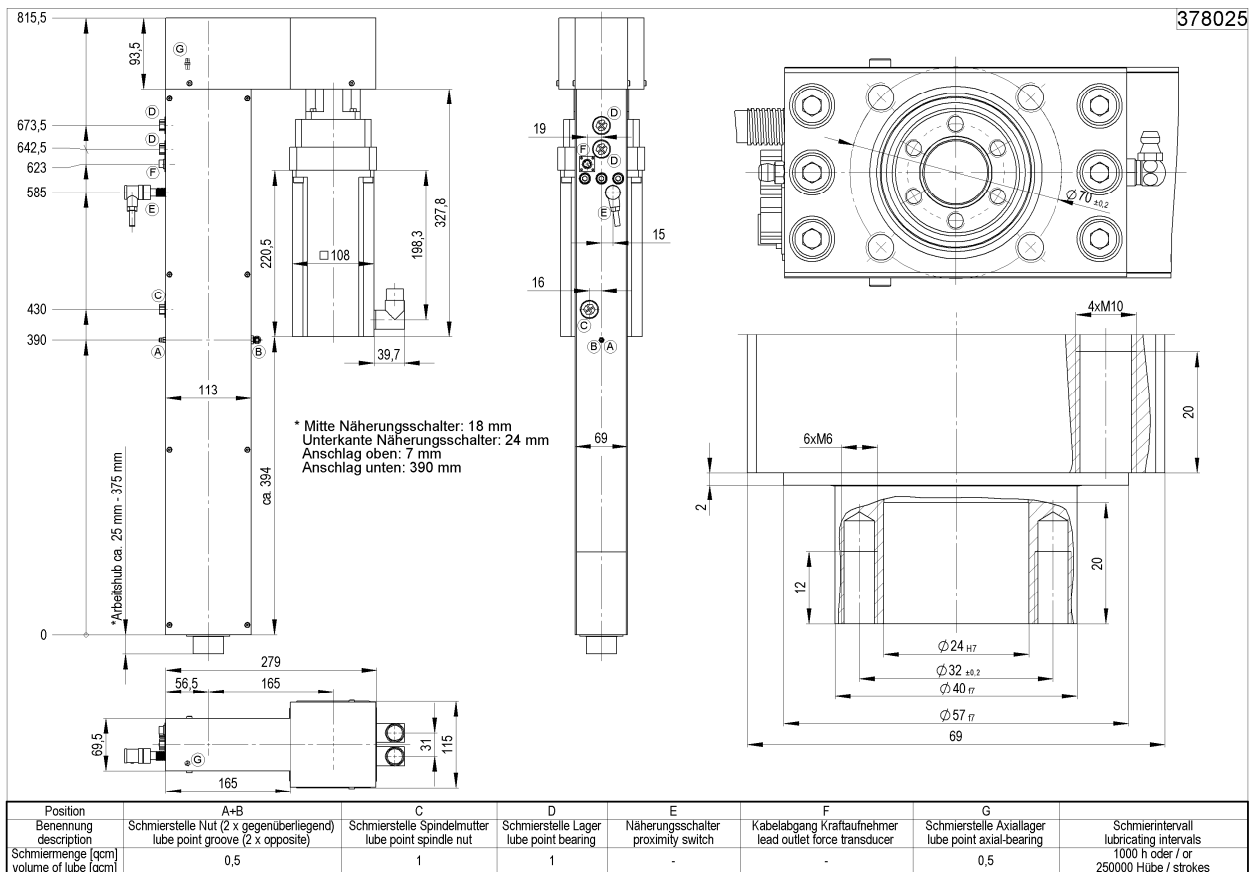
* if using a holding break = nominal load / ** at thermal steady-state

SCOPE OF SUPPLY AND SERVICE

A complete package consisting of press mechanics with drive chain, servo amplifier and the Windows-based operating software is included in the scope of supply of an assembly unit. The entire system is completely preconfigured and calibrated by PROMESS and ready for operation.

The system can be optionally modified using cable sets, field busses, press frames, mounting plates or electric cabinets.

PROMESS offers first-rate support with spare parts and service from a single source. This includes pilot testing, process analysis, start-up support and maintenance contracts.



All specifications in the data sheets are valid at the print date. Before basing your own calculations/usage on the listed information, please inform yourself whether the information at your disposal is up-to-date. We do not accept any liability for correctness of the information.. Status: Sept. 2009