

Technical sheet

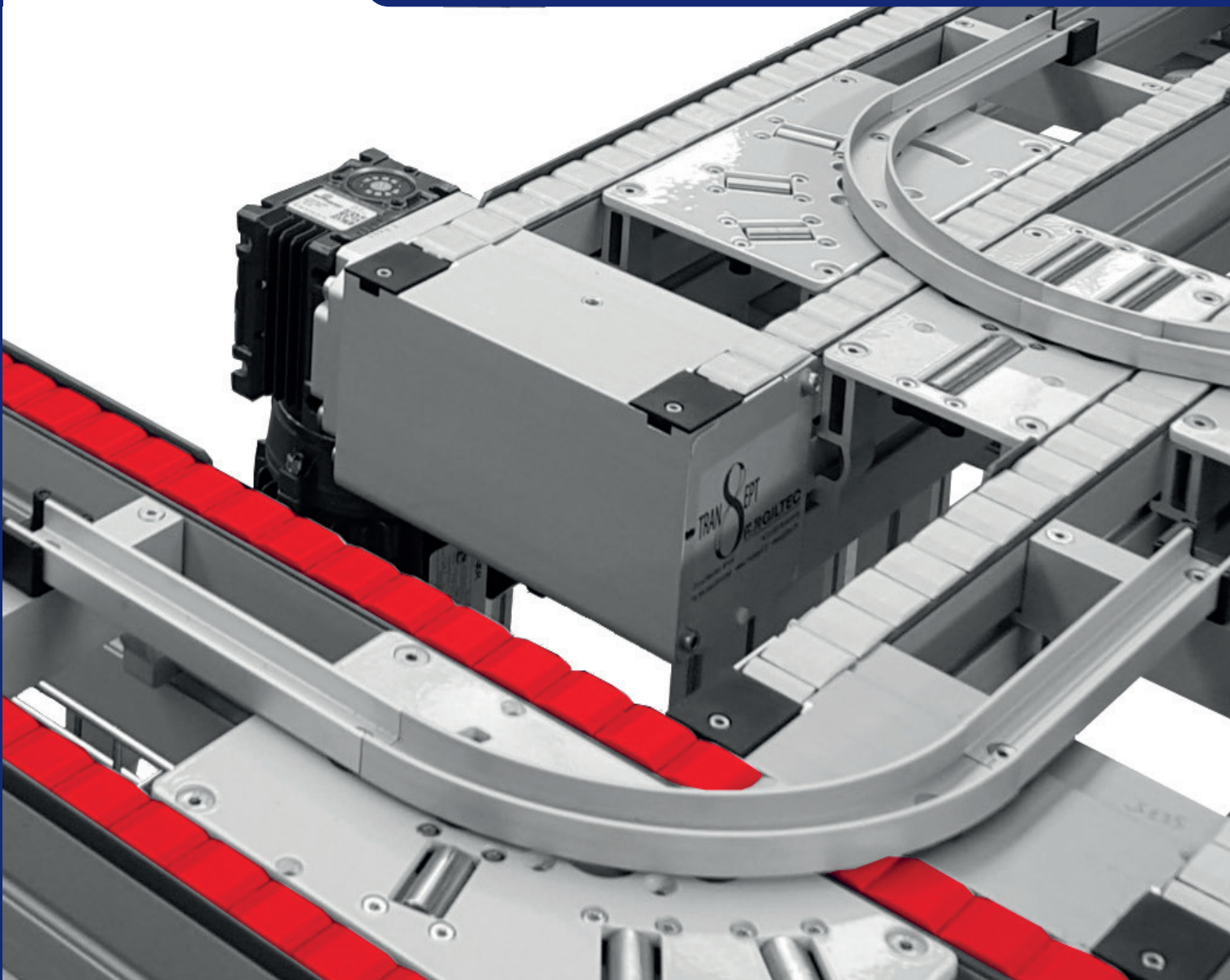
Chain pallet transfer system TR



/ TR TRANSFER SYSTEM

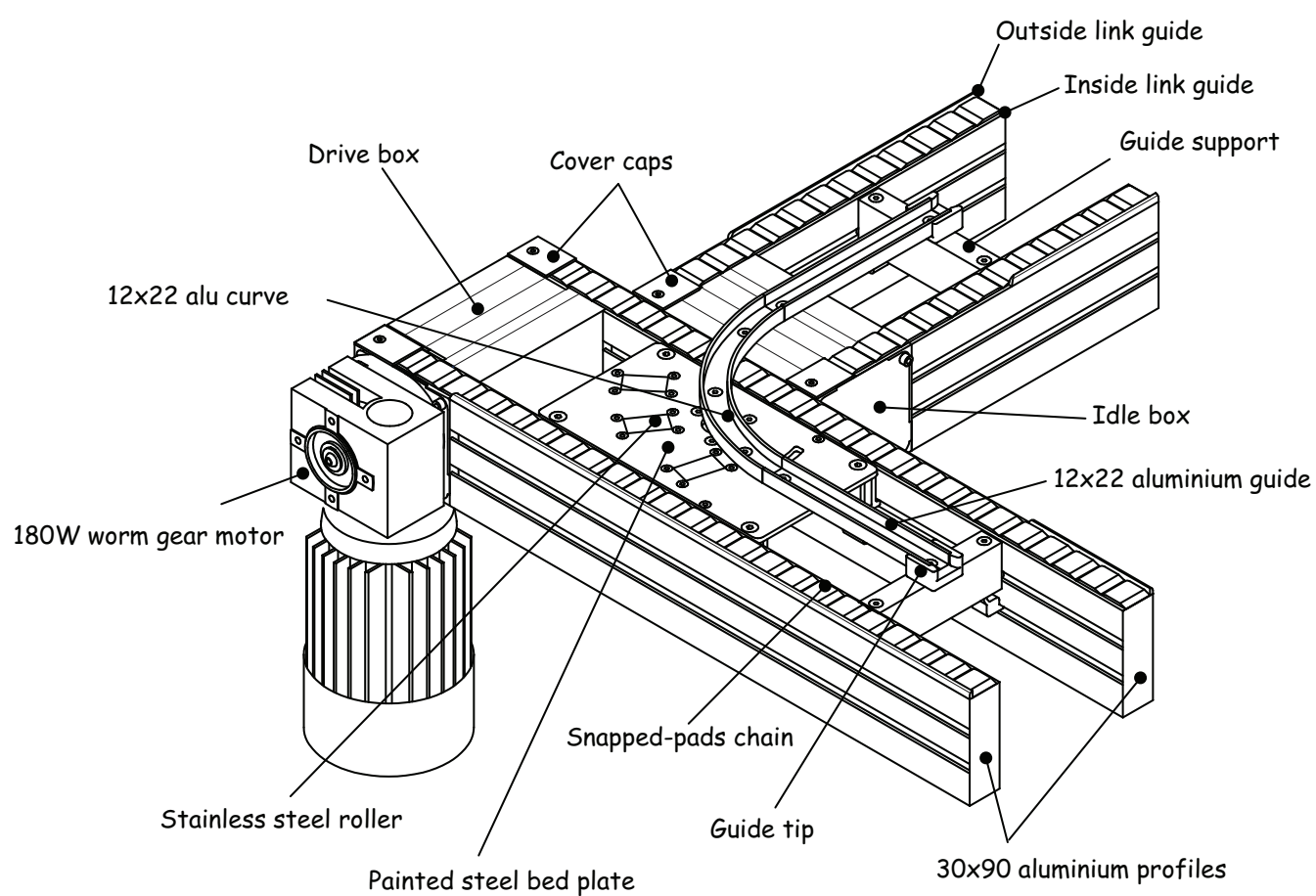
Transfer TR

Configurable and modular. Quick and easy to assemble.

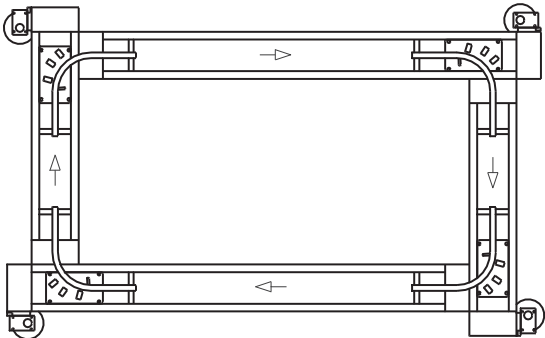


The chain and runner solution!

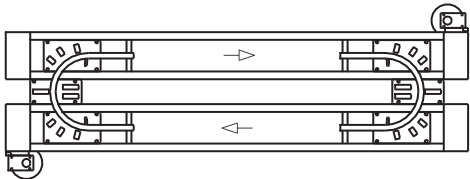
- > Simple and robust construction
- > Tray loads up to 10 kg
- > Track widths 100, 175, 250, 325, 400
- > Non-standard width possible, without curve functions



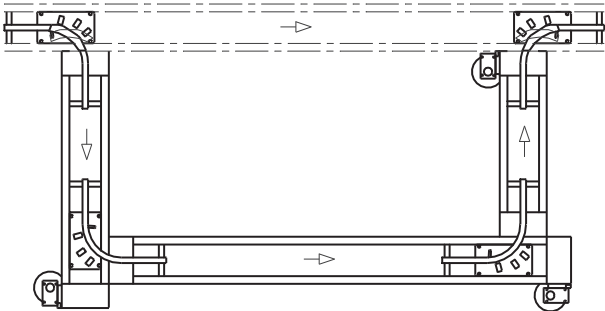
Description (modules)



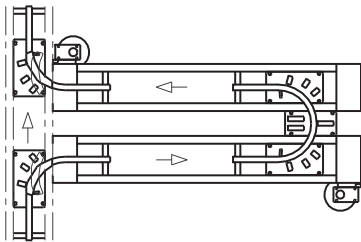
Rectangular basis



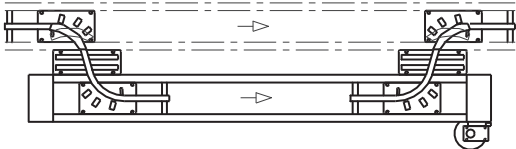
Hippodrome basis



Shunt

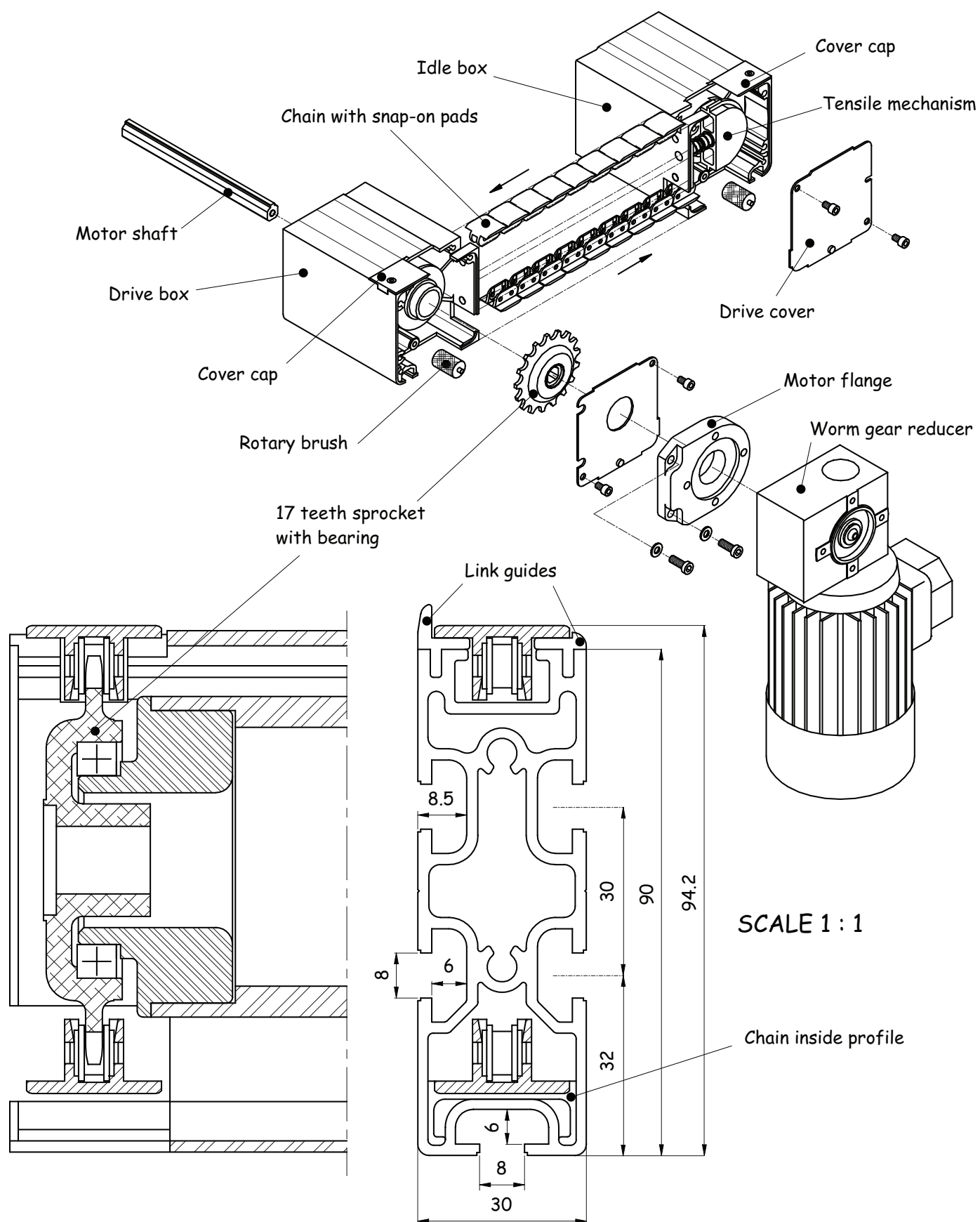


Spur track



Diversion

Description (drive)



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Straight section

Technical data

Each straight section incorporates two 30 mm x 90 mm aluminium profiles sections equipped with lateral guides (fuchsia coloured guides) for the guidance of the workpiece carriers.

The maximum loading for each straight section used in **accumulation** of workpiece carriers is up to: **75 kg** (however, should the transfer speed exceed 15m/min, this value should be decreased to 50 kg).

Worm gear motor reducer, size 30 mm.

Three-phase motor 180W 63 B14:

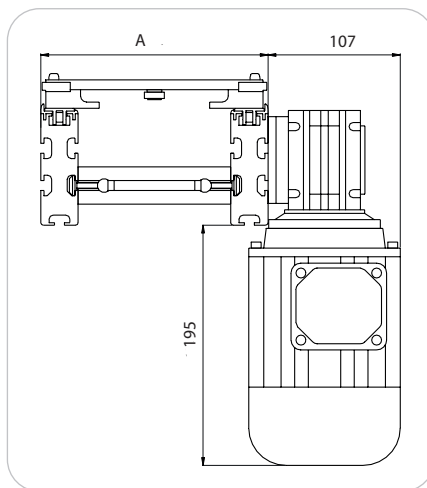
- 50Hz 230/400V
- 60Hz 230/460V

Standard speed (input 50Hz) :

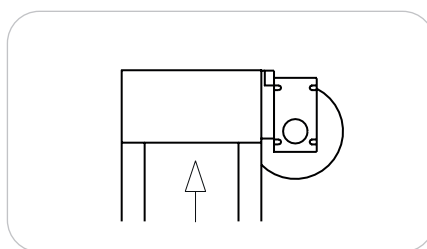
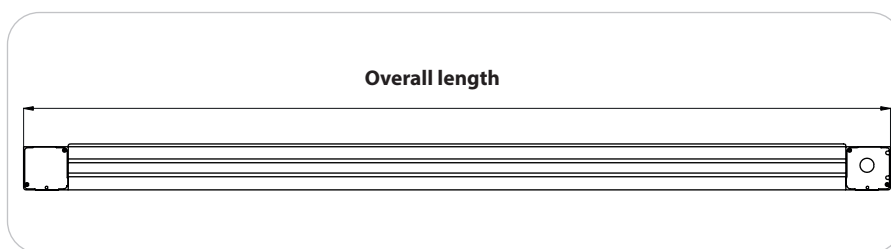
14,6 m/min.

Other speeds:

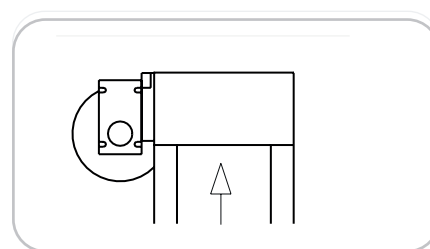
- use frequency inverter (from 30Hz to 70Hz)
- and/or other worm gear ratio (ref. 7161)



Line	A (mm)
100	112
175	183
250	258
325	333
400	408



Right side motor mount



Left side motor mount

Designation / Dimensions	Order unit	Reference
Straight section right side motor mount line 100	1 kit	4140
Straight section right side motor mount line 175	1 kit	6141
Straight section right side motor mount line 250	1 kit	6144
Straight section right side motor mount line 325	1 kit	6147
Straight section right side motor mount line 400	1 kit	6150
Straight section left side motor mount line 100	1 kit	4141
Straight section left side motor mount line 175	1 kit	6142
Straight section left side motor mount line 250	1 kit	6145
Straight section left side motor mount line 325	1 kit	6148
Straight section left side motor mount line 400	1 kit	6151

Example straight section line 175, overall length 3500 mm, with right side motor mount

6141-3500

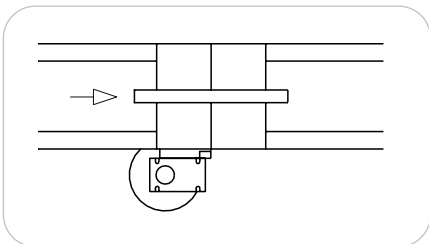
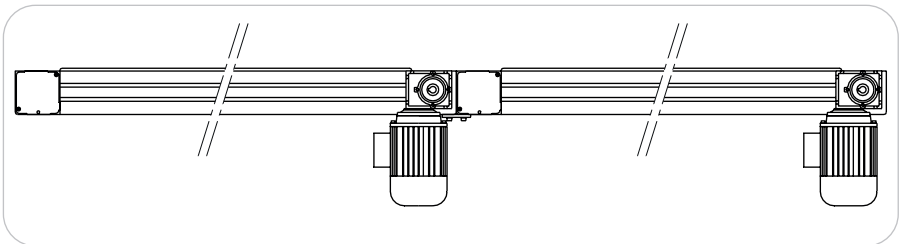
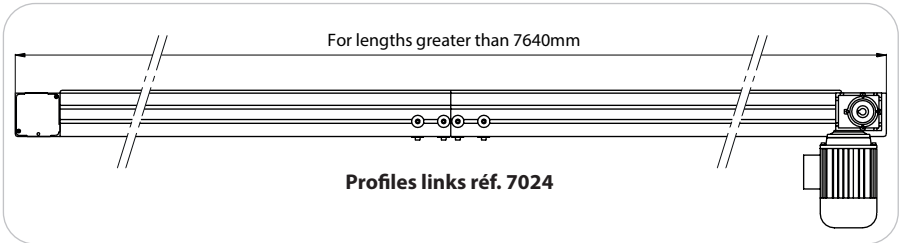
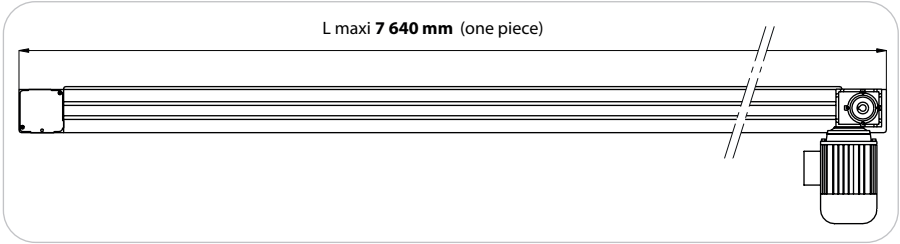
Lengths maxi / mini and continuities

Technical data

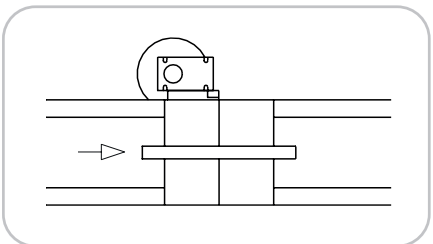
Lengths maxi / mini and continuities

Length maxi: **7 640 mm** (one piece).

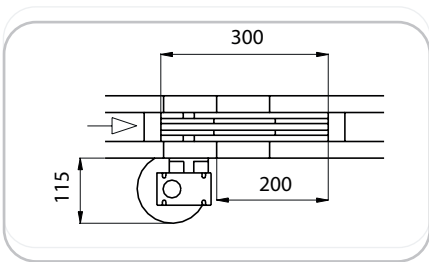
Possible length greater to 7 640 mm.



Continuity lines 175 to 400
right side motor mount



Continuity lines 175 to 400
left side motor mount



Continuity line 100
right side motor mount

Designation / Dimensions	Order unit	Reference
Continuity line 175, 250, 325, 400, right or left side motor mount	1 pce	4156
Continuity line 100, right side motor mount	1 pce	4061
Continuity line 100, left side motor mount	1 pce	4062

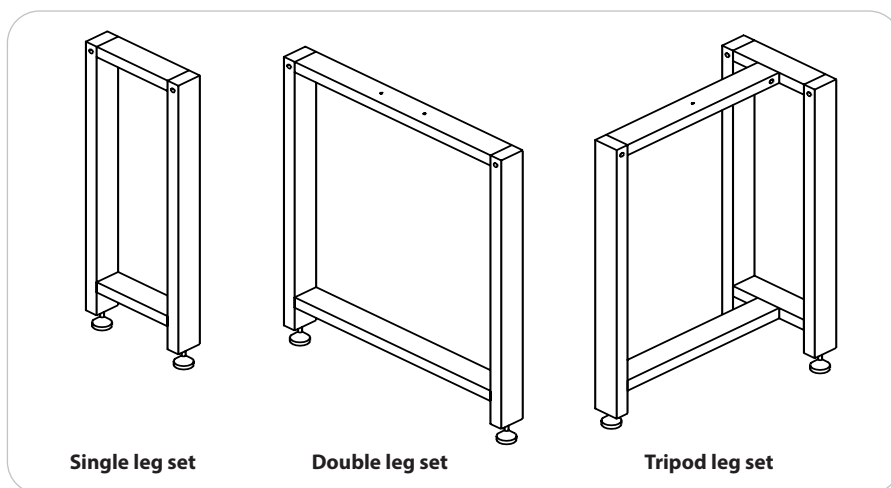
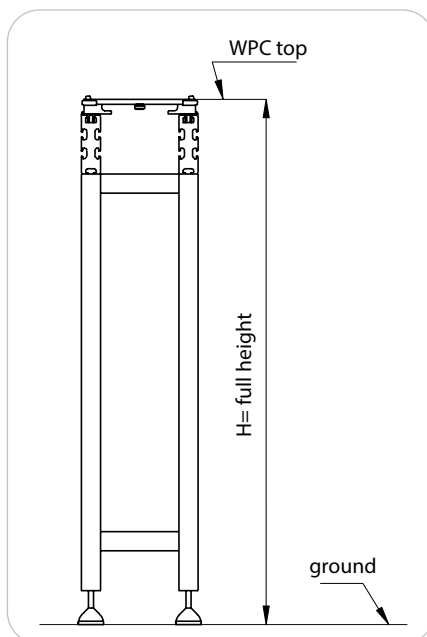
Leg sets

Technical data

Leg sets are used to support the transfer sections. It is recommended that leg sets are spaced at 2 meters intervals. Leg sets are generally made of standard profile (30x60) or another one if required.

They are delivered and equipped with adjustable feet and fixing accessories (ground fasteners not included).

Tripod leg set 8056 fits very well with perpendicular straight sections.

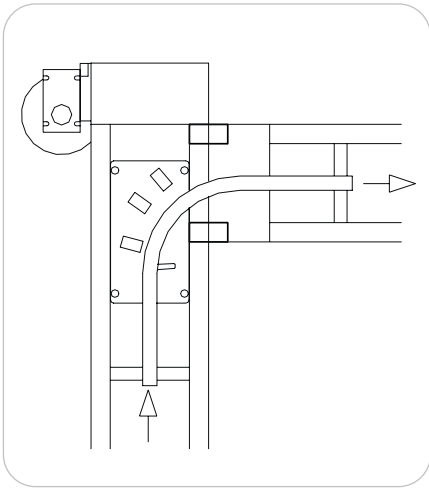


Designation / Dimensions	Order unit	Reference
Single leg set line 100	1 kit	6049
Single leg set line 175	1 kit	6050
Single leg set line 250	1 kit	6051
Single leg set line 325	1 kit	6052
Single leg set line 400	1 kit	8055
Double leg set line 100 (180° curve)	1 kit	6063
Double leg set line 100 (I/O combination)	1 kit	6065
Double leg set line 175	1 kit	6053
Double leg set line 250	1 kit	6054
Double leg set line 325	1 kit	6055
Double leg set line 400 (I/O combination)	1 kit	8054
Tripod leg set line 175	1 kit	8056
Tripod leg set line 250	1 kit	8057
Tripod leg set line 325	1 kit	8058
Tripod leg set line 400	1 kit	8059

Links

Technical data

Link 4056 (perpendicular sections) and fixing 4156 (aligned sections) ensure reliable geometry when assembling the transfer system.



Designation / Dimensions	Order unit	Reference
Link perpendicular section	1 kit	4056
Link aligned section	1 kit	4156

Workpiece carrier Line 100

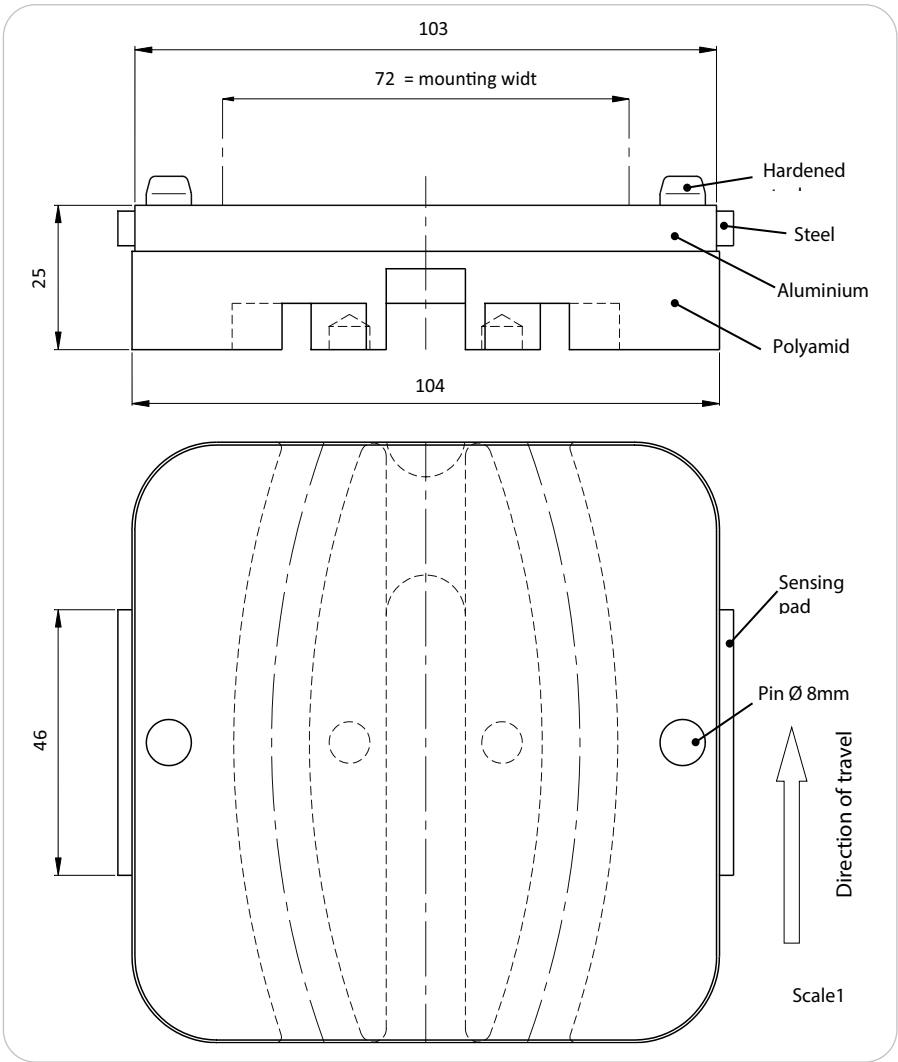
Technical data

Workpiece carriers (WPC) are used to locate and transfer parts during the whole production and assembly cycle. Line 100 WPC is made of aluminium plate and polyamid pad and is equipped with grooves to ensure perfect guidance through curves and other functions.

For indexing, Ø 8mm pins are provided and allow precise positioning in X, Y and Z axis within a +/- 0.03mm repeatability. Special contour features within the WPC pad ensures total immobilization at a stop position. Steel pads on either side allow sensing with conventional inductive sensors. Mechanical data processing can be provided as described in page 262.

Line 100 workpiece carrier can accommodate payloads up to **5 kg**.

Empty weight: **0,3 kg**



Designation / Dimensions	Order unit	Reference
Workpiece carrier line 100	1 kit	8006

Stop/Pad/Anti-backslash/Anti-lift/Sensing Line 100

Technical data

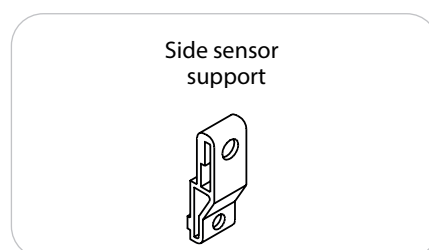
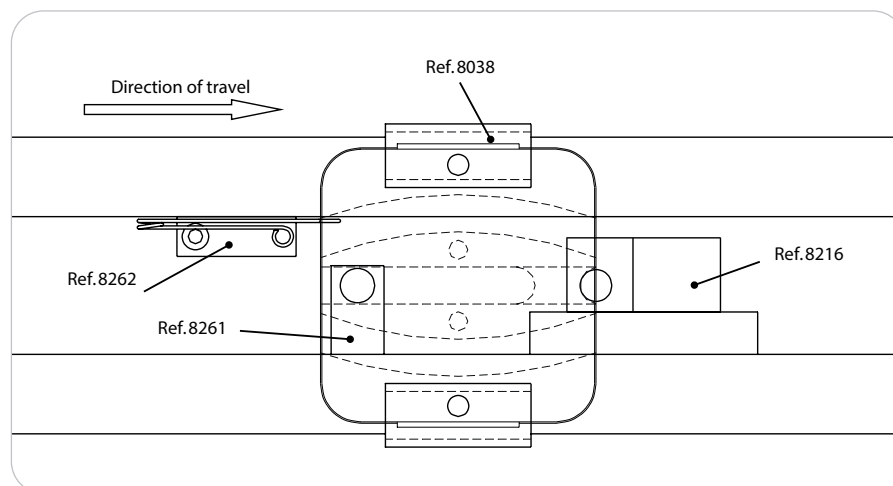
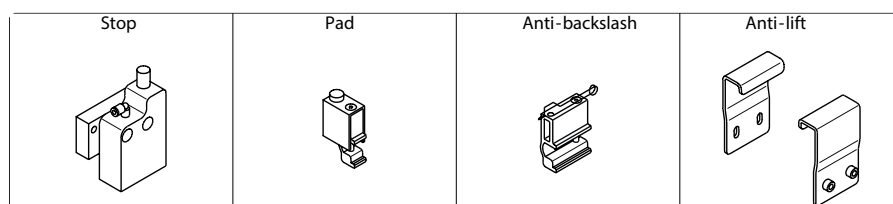
The stop unit provides a simple stop facility when precise positioning of the workpiece carrier is not necessary.

The stop may also be used for flow control and prioritisation of workpiece carriers prior to and after « mobile » functions and precise station stops.

The pad improves the stop precision and the anti-backslash kit reduces the WPC bounce, providing better cycle times. When unloading pieces at manual workstations, the anti-lift kit prevents the operator from lifting of the WPC from the transfer line.

Stop:

- ✗ stop capability: 75 kg
- ✗ stop accuracy +/-0,3mm (with pad)
- ✗ cylinder Ø 25mm, simple acting
- ✗ lubricated or not, cleaned air, 5 to 6 bars
- ✗ connector for Ø4 mm pipe (provided)
- ✗ acetal body, stainless steel plunger
- ✗ sensing up/down positions: on request ref. 8014 (M8 sensors not included).



Side sensor support

When stopping within a workstation, workpiece carriers may be detected using inductive sensors M12 (recommended span 4mm), with or without connectors, fitted to supports 8095. These sensors also ensure flow and priority control.

Designation / Dimensions	Order unit	Reference
Stop line 100	1 kit	8216
Pad line 100	1 kit	8261
Anti-backslash line 100	1 kit	8262
Anti-lift line 100	1 kit	8038
Side sensor support line 100	1 kit	8095

Positioning tool 40 kg (stroke 6 mm) Line 100

Technical data

When a process requires precise positioning for the workpiece carriers, the positioning tool 40 kg (stroke 6 mm) ensures a +/- 0.03mm XYZ repeatability.

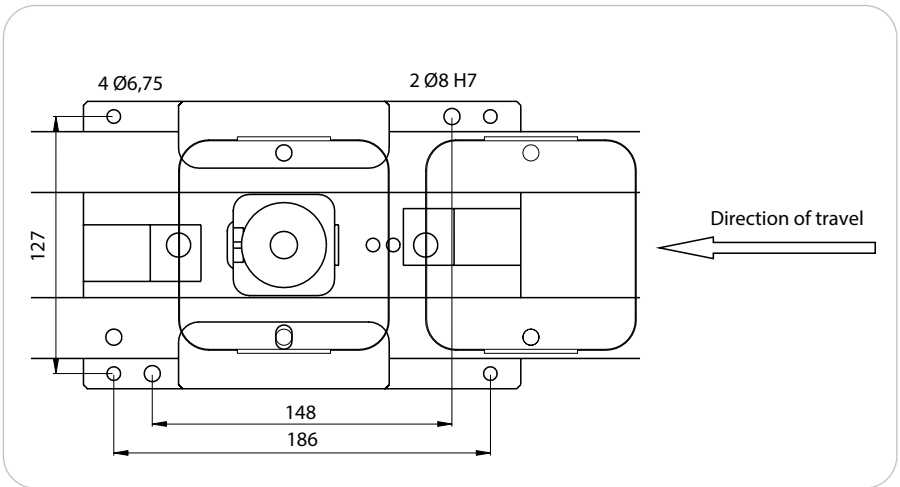
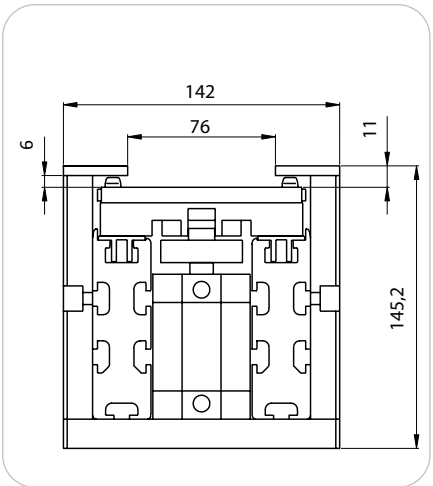
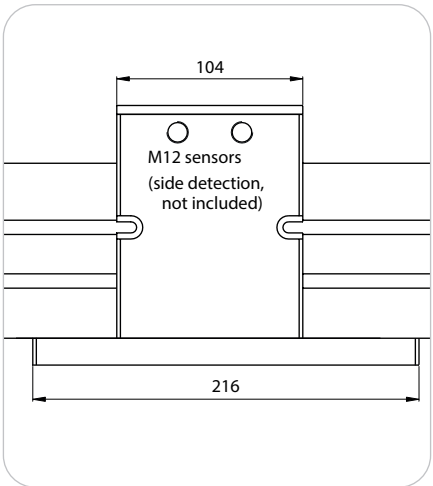
The positioning tool is manufactured from high grade aluminium. A double-acting pneumatic cylinder lifts and secures the workpiece carrier in hardened steel jaws.

Two sensors fitted on the cylinder body ensure detection of up/down positions. Threads in the side of the positioning tool allow the use of M12 sensors (not included).

The positioning tool 40 kg (stroke 6 mm) is delivered with 2 stops 8016, pre-fitted on its base. These stops must be ordered separately.

Cylinder:

- ✗ Ø 32mm, double acting
- ✗ lubricated or not, cleaned air, 4 to 6 bars
- ✗ connectors Ø 4mm pipe (included)
- ✗ 2 sensors (included)



IMPORTANT

- ⚠ **✗ The positioning tool must be fitted to a stable and robust structure in order to ensure the accuracy of this function**
- ✗ The positioning tool must be fully guarded once fitted.**

Designation / Dimensions	Order unit	Reference
Positioning tool 40 kg stroke 6 mm line 100	1 kit	8035

Positioning tool 40 kg (strokes 50 and 100 mm) Line 100

Technical data

The positioning tool 50 mm or 100 mm stroke version of the positioning tool 40 kg ensures a $\pm 0.03\text{mm}$ XYZ repeatability.

The positioning tool is manufactured from high grade aluminium. A double-acting pneumatic cylinder lifts and secures the workpiece carrier in hardened steel jaws.

Two sensors fitted on the cylinder body ensure detection of up/down positions. Threads in the side of the positioning tool allow the use of M12 sensors (not included).

The positioning tool 40 kg (stroke 50/100mm) is delivered with 2 stops 8016, pre-fitted on its base. These stops must be ordered separately.

Cylinder:

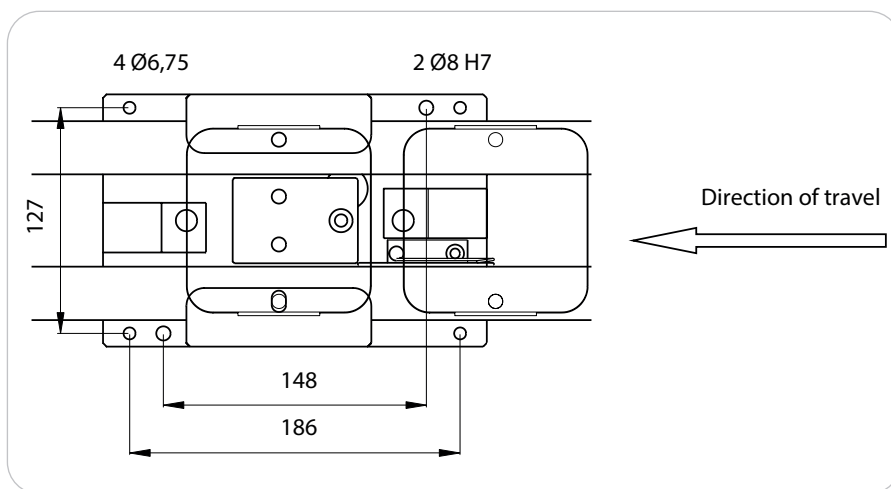
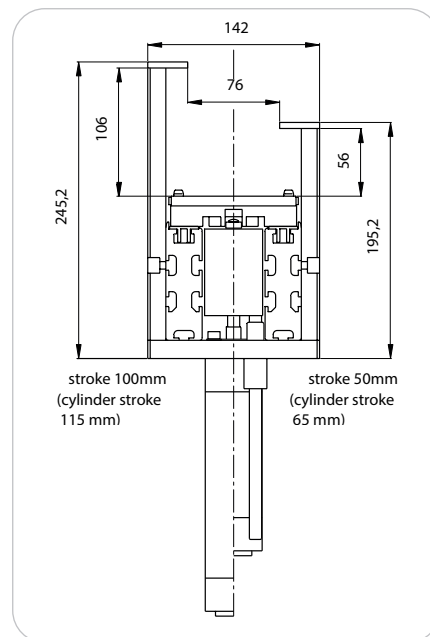
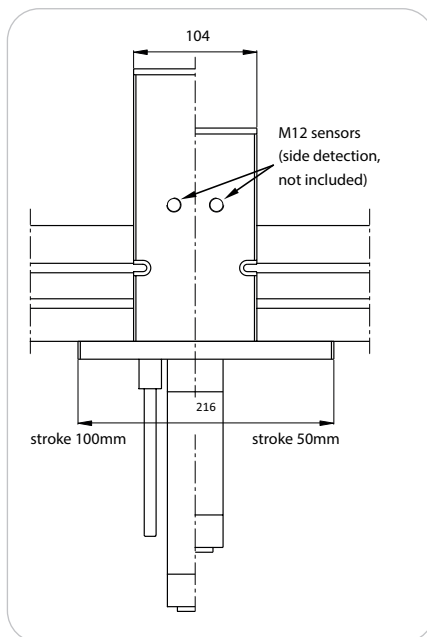
- ✗ Ø 32mm, double acting
- ✗ lubricated or not, cleaned air, 4 to 6 bars
- ✗ connectors Ø 4mm pipe (included)
- ✗ 2 sensors (included)

IMPORTANT



✗ The positioning tool must be fitted to a stable and robust structure in order to ensure the accuracy of this function

✗ The positioning tool must be fully guarded once fitted.



Designation / Dimensions	Order unit	Reference
Positioning tool 40 kg stroke 50 mm line 100	1 kit	8135
Positioning tool 40 kg stroke 100 mm line 100	1 kit	8235

Positioning tool 160 kg (stroke 6 mm) Line 100

Technical data

When a process requires precise positioning under strong efforts, the positioning tool 160 kg (stroke 6 mm) ensures a +/- 0.03mm XYZ repeatability.

The positioning tool is manufactured from high grade aluminium. A double-acting pneumatic cylinder lifts and secures the workpiece carrier in hardened steel jaws.

Two sensors fitted on the cylinder body ensure detection of up/down positions. Threads in the side of the positioning tool allow the use of M12 sensors (not included).

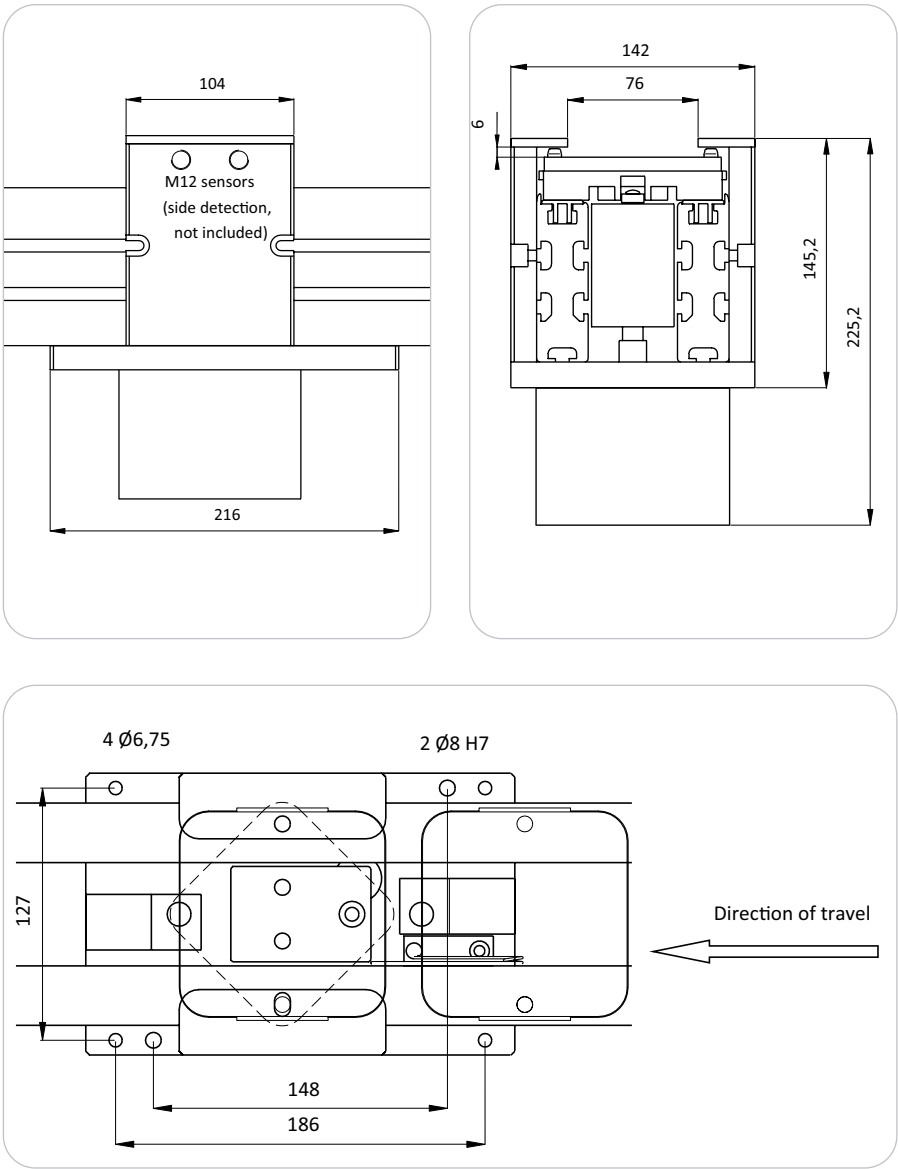
The positioning tool 160 kg (stroke 6 mm) is delivered with 2 stops 8016, pre-fitted on its base. These stops must be ordered separately.

Cylinder:

- ✗ Ø 63 mm, double acting
- ✗ lubricated or not, cleaned air, 4 to 6 bars
- ✗ connectors Ø 4mm pipe (included)
- ✗ 2 sensors (included)

IMPORTANT

- ⚠ **✗ The positioning tool must be fitted to a stable and robust structure in order to ensure the accuracy of this function**
- ✗ The positioning tool must be fully guarded once fitted.**



Designation / Dimensions	Order unit	Reference
Positioning tool 160 kg stroke 6 mm line 100	1 kit	8036

Curve 90° (static) Line 100

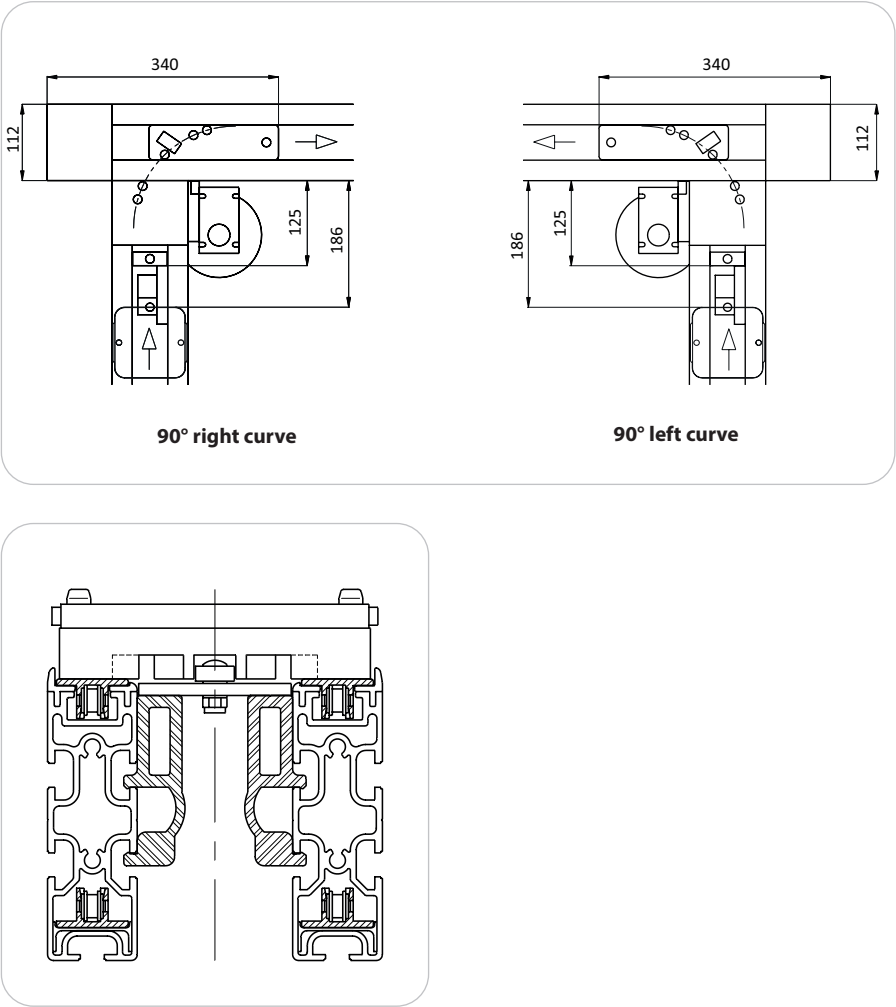
Technical data

Using the 90° curve, it is possible to cross from one section perpendicular to another. Grooves under the workpiece carriers ensure perfect guidance on ball bearings fixed upon the bed plates.

Specially designed claws allow the bed plates to be fitted easily.

In this configuration, accumulation of workpiece carriers is possible. The small content of mechanical elements and features within the 90° curve results in high reliability

The minimum distance at which the workpiece carriers may be stopped in relationship to the curve is shown in the drawings above.



Designation / Dimensions	Order unit	Reference
Curve 90° (static) right line 100	1 kit	4022
Curve 90° (static) left line 100	1 kit	4023

Curve 90° (mobile) Line 100

Technical data

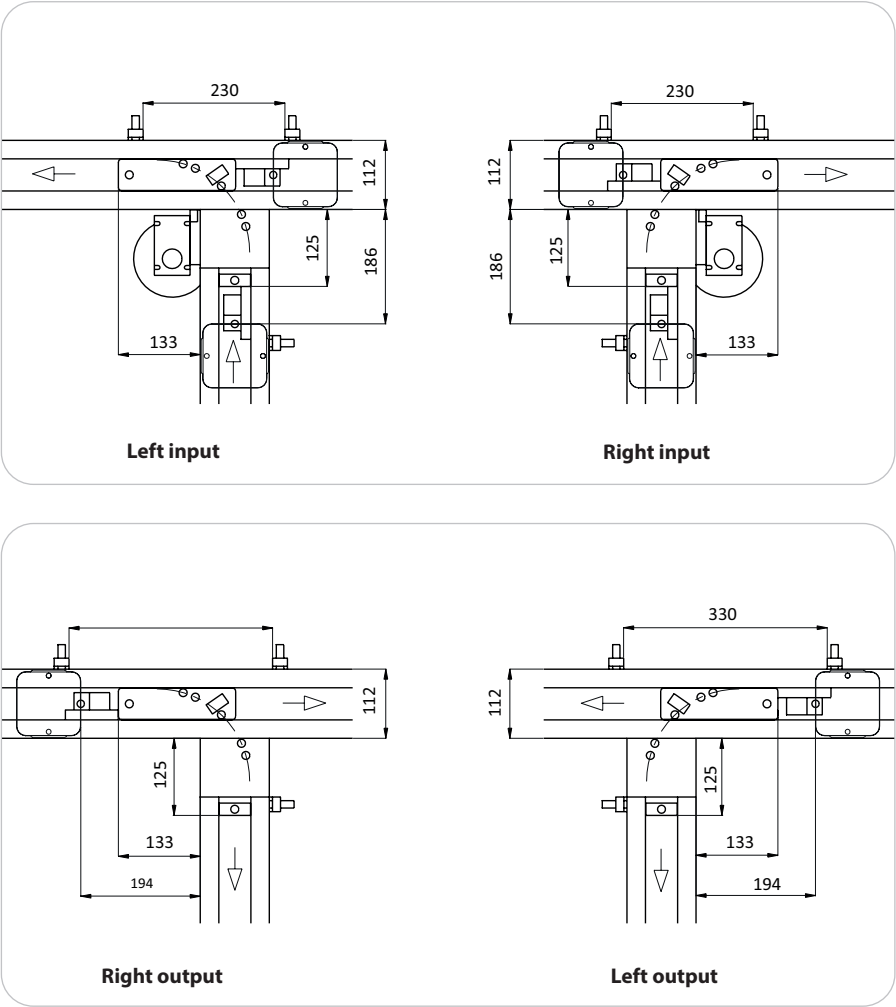
The 90° curve « mobile » allows workpiece carriers to be introduced from a secondary section to a main one (« input ») or from a main section to a secondary one (« output »).

Grooves under the workpiece carriers ensure perfect guidance on ball bearings fixed upon the bed plates.

This function is « mobile » due to the retractable main bed plate. The 90° curve « mobile » presents a reduced flowstoppage rate requiring minimum automation.

Retractable bed plate cylinder:

- ✗ Ø 16 mm, double acting
- ✗ lubricated or not, cleaned air, 5 to 6 bars
- ✗ connectors for Ø 4 mm pipe (included)
- ✗ sensors on cylinder body (not included)



Designation / Dimensions	Order unit	Reference
Curve 90° mobile Left input line 100	1 kit	4024
Curve 90° mobile Right input line 100	1 kit	4025
Curve 90° mobile Right output line 100	1 kit	4024
Curve 90° mobile Left output line 100	1 kit	4025

Curve 180° Line 100

Technical data

Using the 180° curve, it is possible to cross from one section in parallel to another operating in the opposite direction.

Four combinations cover all possible configurations.

This function is « mobile » due to the retractable bed plate. In the « static/static » curve, accumulation of workpiece carriers is possible. The bed plate between the sections (« middle bed plate ») is equipped with a motorized roller to aid workpiece carriers through the curve.

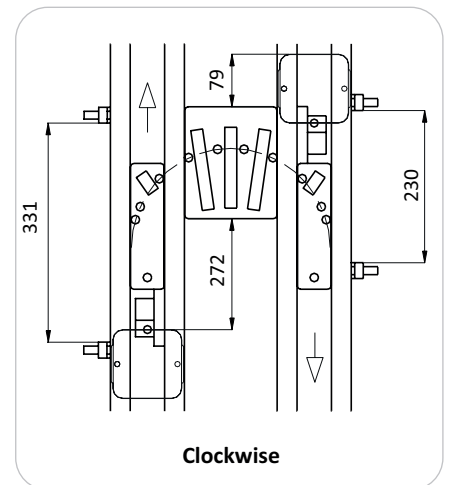
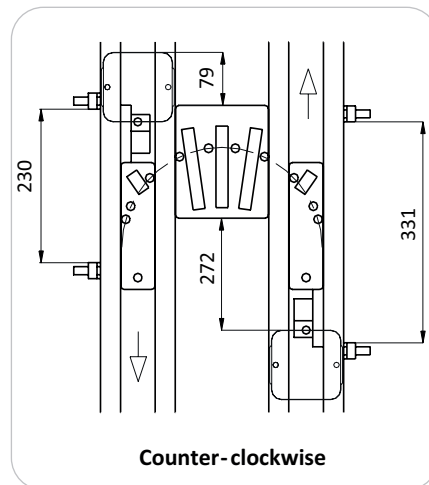
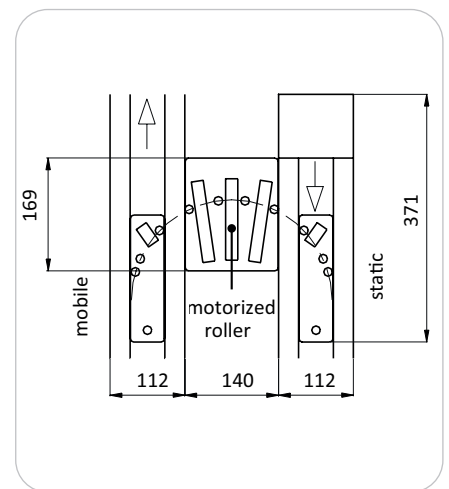
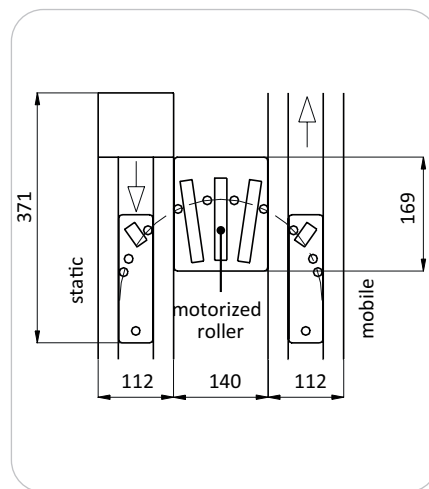
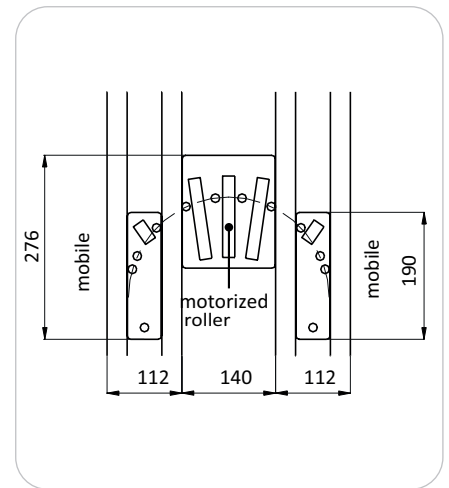
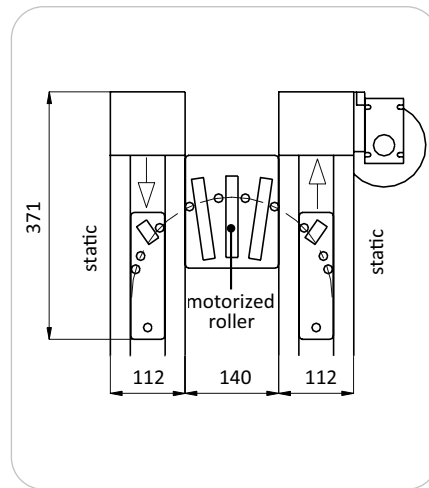
Retractable bed plate cylinder:

- ✗ Ø 16 mm, double acting
- ✗ lubricated or not, cleaned air, 5 to 6 bars
- ✗ connectors for Ø 4 mm pipe (included)
- ✗ sensors on cylinder body (not included)

Intermediate motorized roller:

- ✗ power 6,3 W
- ✗ voltage 220 V single-phase
- ✗ frequency 50 Hz
- ✗ rated current 73 mA

The minimum distance at which the workpiece carriers may be stopped in relationship to the curve is shown in the drawings below.



Designation / Dimensions	Order unit	Reference
Curve 180° static/static line 100	1 kit	4012
Curve 180° static/mobile line 100	1 kit	4013
Curve 180° mobile/static line 100	1 kit	4014
Curve 180° mobile/mobile line 100	1 kit	4015

Combination input/output Line 100

Technical data

The function of the input/output combination is adapted to transfer workpiece carriers from one section to another operating in parallel and running in the same direction.

This function is « mobile » due to the retractable bed plate. The bed plate between the sections (« middle bed plate ») is equipped with two motorized rollers (driven by only one motor) to aid workpiece carriers through the transfer sections.

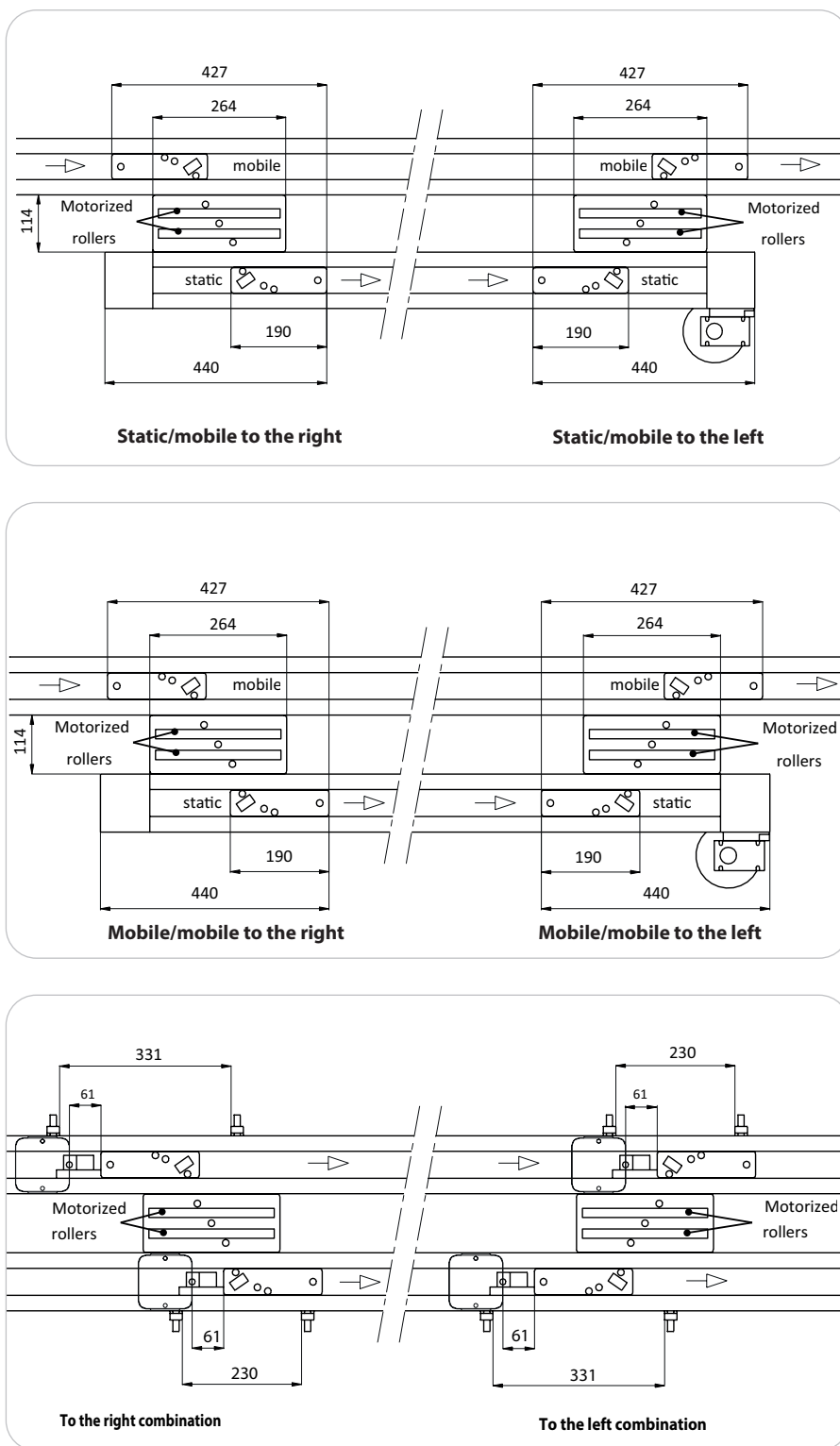
Retractable bed plate cylinder:

- ✗ Ø 16 mm, double acting
- ✗ lubricated or not, cleaned air, 5 to 6 bars
- ✗ connectors for Ø 4 mm pipe (included)
- ✗ sensors on cylinder body (not included)

Intermediate motorized roller:

- ✗ power 6,3 W
- ✗ voltage 220 V single-phase
- ✗ frequency 50 Hz
- ✗ rated current 73 mA

The minimum distance at which the workpiece carriers may be stopped in relationship to the combination is shown in the drawings below.



Designation / Dimensions	Order unit	Reference
Combination right input/output, static/mobile line 100	1 kit	4017
Combination right input/output, mobile/mobile line 100	1 kit	4018
Combination left input/output, static/mobile line 100	1 kit	4020
Combination left input/output, mobile/mobile line 100	1 kit	4021

[illegible]

Workpiece carrier Line 175

Technical data

Workpiece carriers (WPC) are used to locate and transfer parts during the whole production and assembly cycle. Line 175 WPC are made of aluminium plate and polyamid pad and are equipped with ball bearings to ensure perfect guidance through curves and other functions.

For indexing, Ø 8mm pins are provided and allow precise positioning in X, Y and Z axis within a +/- 0.03mm repeatability.

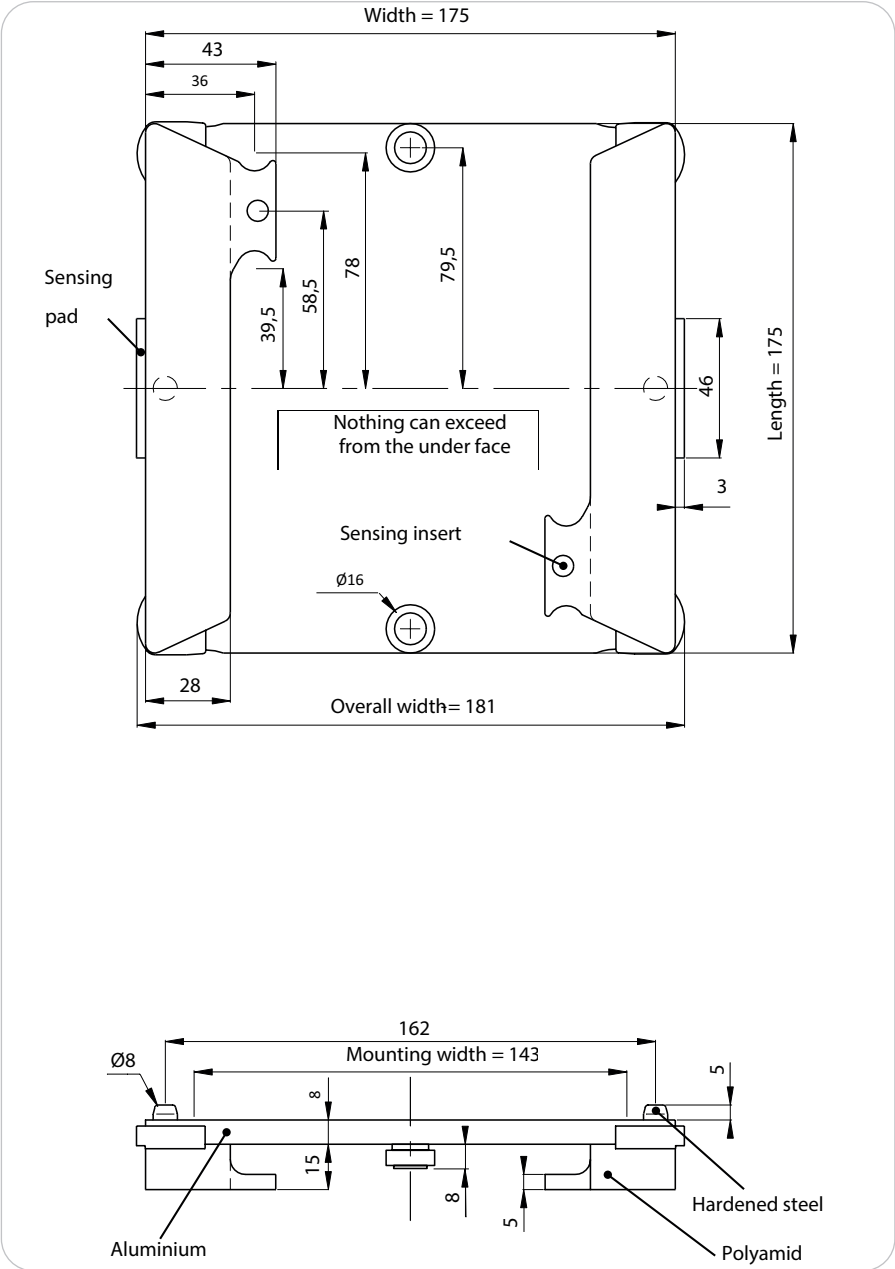
Special contour features within the WPC pad ensures total immobilization at a stop position.

Steel pads on either side allow sensing with conventional inductive sensors. Mechanical data processing can be provided as described in page262.

Line 175 workpiece carriers (references 8000 and 8001) can accommodate payloads up to 7 kg.

WPC plate is made of anodized aluminium. Flatness is better than 0.5mm. Detachable molded polyamid pads may be replaced easily. Friction coefficients are 0.25 (carrying) and 0.50 (accumulation).

Empty weight: **0,7 kg**



Designation / Dimensions	Order unit	Reference
Workpiece carrier 175x175 Line 175	1 kit	8000

Workpiece carrier Line 175

Technical data

Workpiece carriers (WPC) are used to locate and transfer parts during the whole production and assembly cycle. Line 175 WPC are made of aluminium plate and polyamid pad and are equipped with ball bearings to ensure perfect guidance through curves and other functions.

For indexing, Ø 8mm pins are provided and allow precise positioning in X, Y and Z axis within a +/- 0.03mm repeatability.

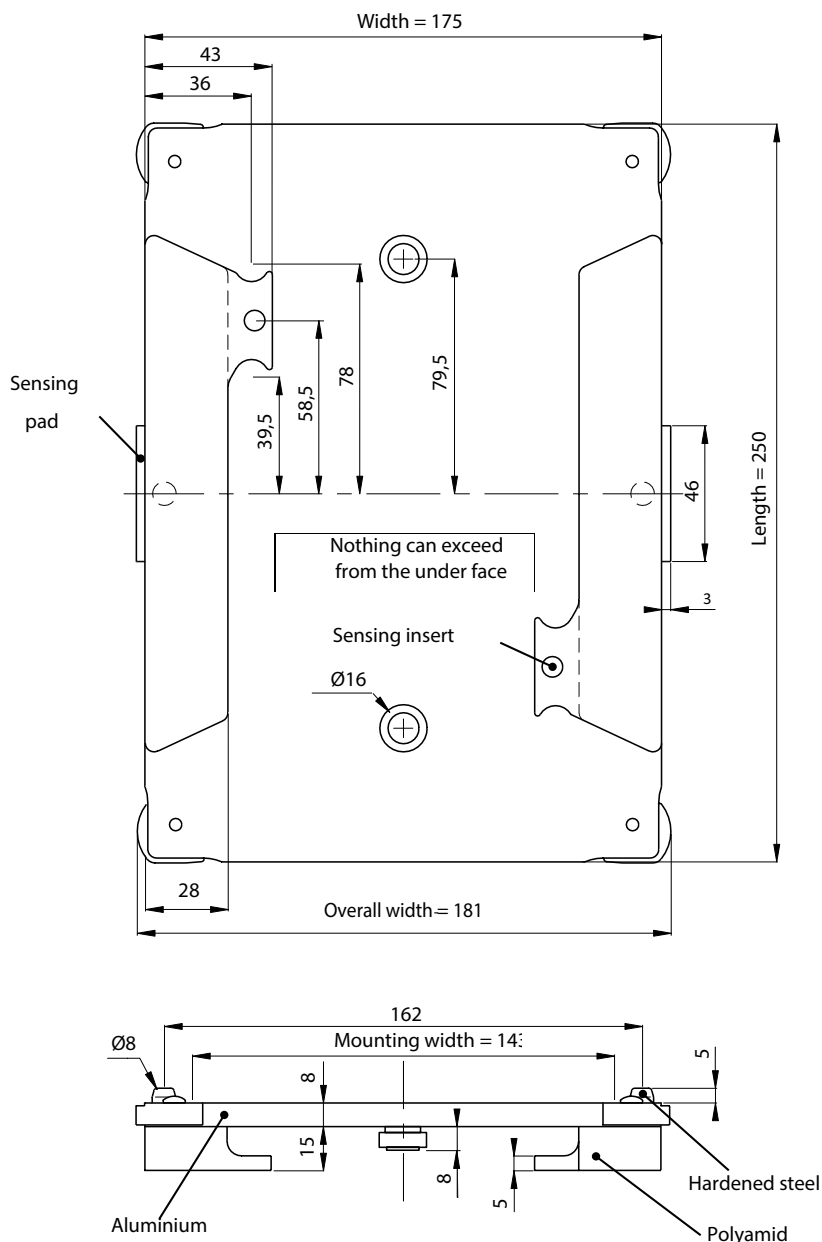
Special contour features within the WPC pad ensures total immobilization at a stop position.

Steel pads on either side allow sensing with conventional inductive sensors. Mechanical data processing can be provided as described in page 262.

Line 175 workpiece carriers (references 8000 and 8001) can accommodate payloads up to 7 kg.

WPC plate is made of anodized aluminium. Flatness is better than 0.5mm. Detachable molded polyamid pads may be replaced easily. Friction coefficients are 0.25 (carrying) and 0.50 (accumulation).

Empty weight: **1 kg**



Designation / Dimensions	Order unit	Reference
Workpiece carrier 175x250 Line 175	1 kit	8001

Workpiece carrier Line 250

Technical data

Workpiece carriers (WPC) are used to locate and transfer parts during the whole production and assembly cycle. Line 250 WPC are made of aluminium plate and polyamid pad and are equipped with ball bearings to ensure perfect guidance through curves and other functions.

For indexing, Ø 8mm pins are provided and allow precise positioning in X, Y and Z axis within a +/- 0.03mm repeatability.

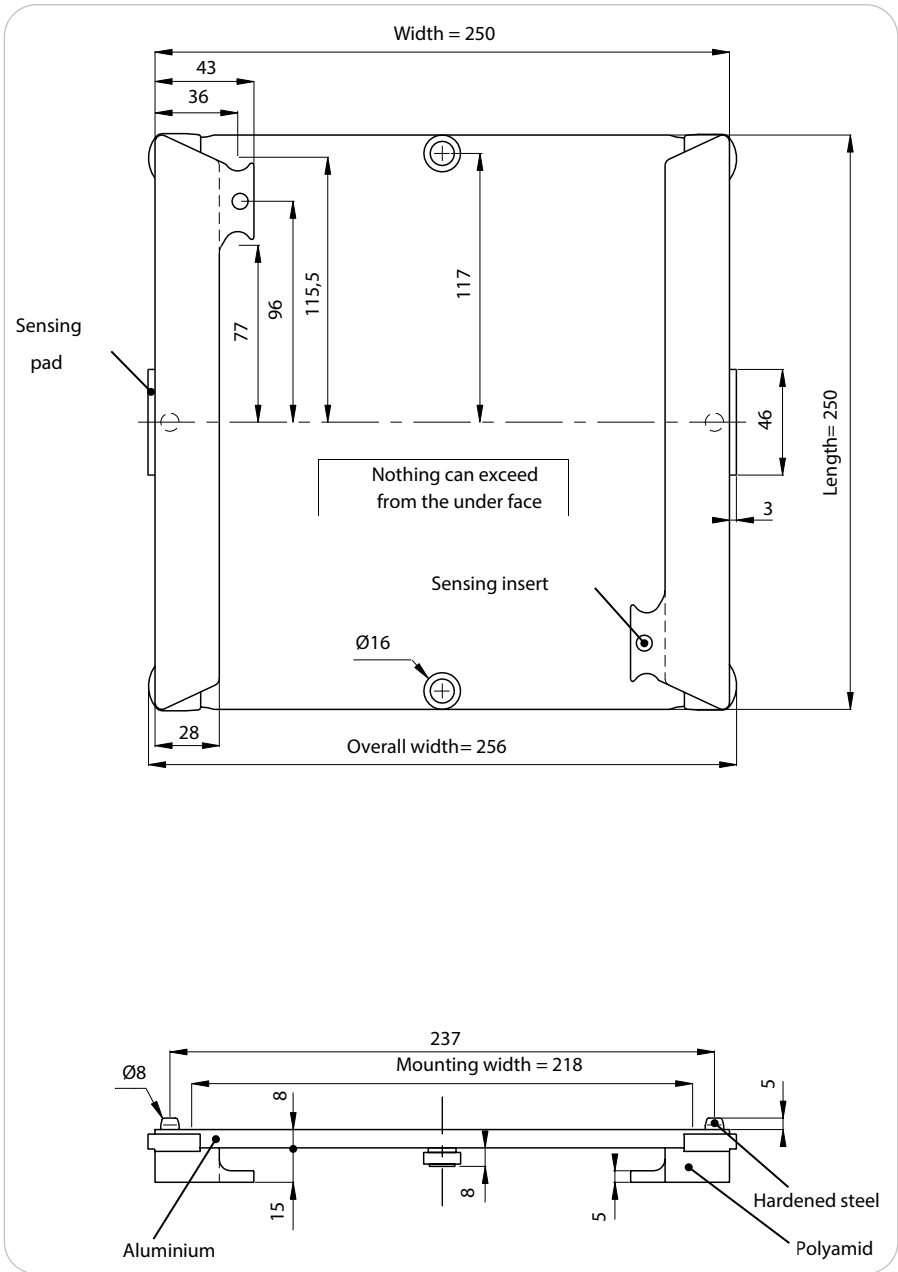
Special contour features within the WPC pad ensures total immobilization at a stop position.

Steel pads on either side allow sensing with conventional inductive sensors. Mechanical data processing can be provided as described in page262.

Line 250 workpiece carriers (references 8002 and 8003) can accommodate payloads up to **10 kg**.

WPC plate is made of anodized aluminium. Flatness is better than 0.5mm. Detachable molded polyamid pads may be replaced easily. Friction coefficients are 0.25 (carrying) and 0.50 (accumulation).

Empty weight: 1 kg



Designation / Dimensions	Order unit	Reference
Workpiece carrier 250x250 Line 250	1 kit	8002

Workpiece carrier Line 250

Technical data

Workpiece carriers (WPC) are used to locate and transfer parts during the whole production and assembly cycle. Line 250 WPC are made of aluminium plate and polyamid pad and are equipped with ball bearings to ensure perfect guidance through curves and other functions.

For indexing, Ø 8mm pins are provided and allow precise positioning in X, Y and Z axis within a +/- 0.03mm repeatability.

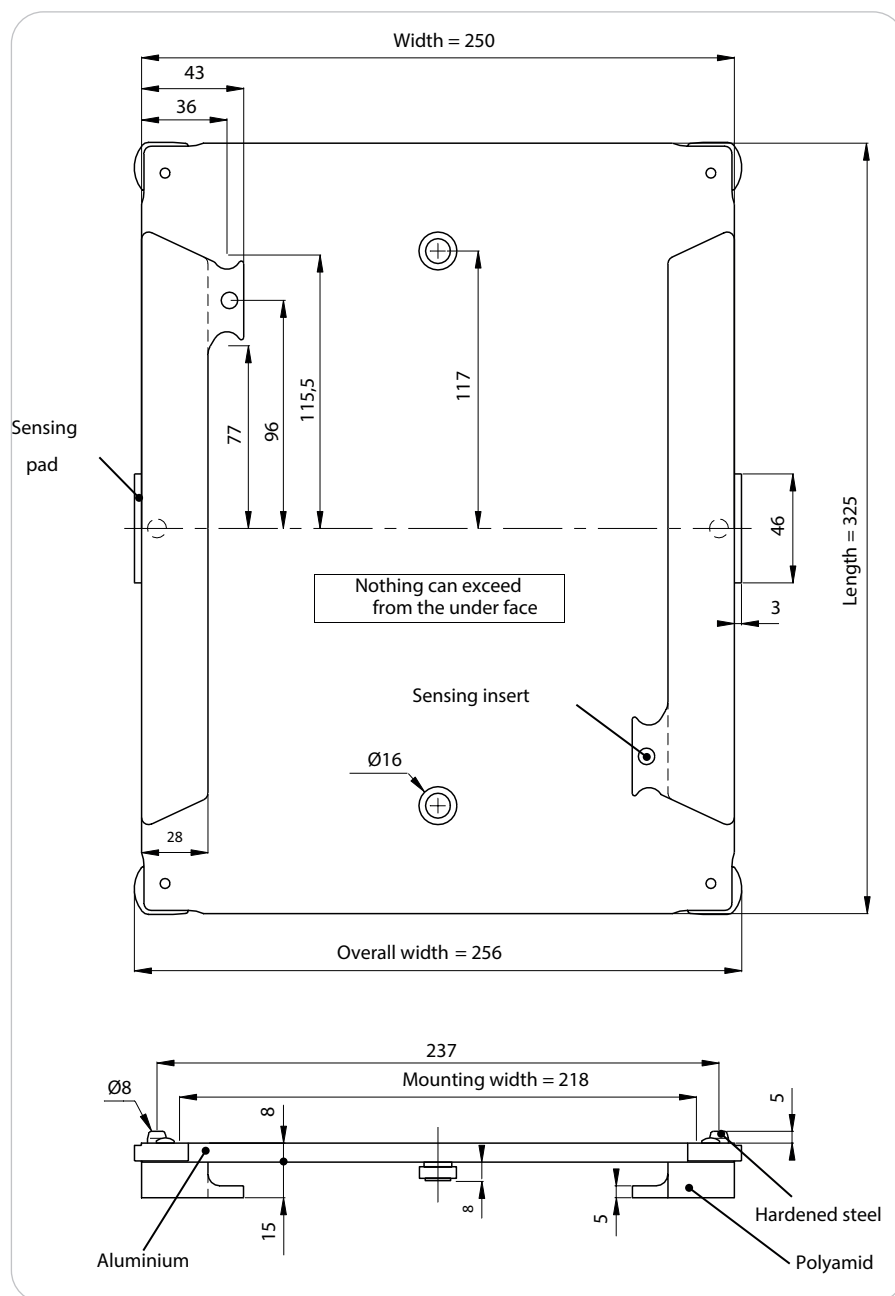
Special contour features within the WPC pad ensures total immobilization at a stop position.

Steel pads on either side allow sensing with conventional inductive sensors. Mechanical data processing can be provided as described in page 262.

Line 250 workpiece carriers (references 8002 and 8003) can accommodate payloads up to **10 kg**.

WPC plate is made of anodized aluminium. Flatness is better than 0.5mm. Detachable molded polyamid pads may be replaced easily. Friction coefficients are 0.25 (carrying) and 0.50 (accumulation).

Empty weight: 2 kg



Designation / Dimensions	Order unit	Reference
Workpiece carrier 250x325 Line 250	1 kit	8003

Workpiece carrier Line 325

Technical data

Workpiece carriers (WPC) are used to locate and transfer parts during the whole production and assembly cycle. Line 325 WPC are made of aluminium plate and polyamid pad and are equipped with ball bearings to ensure perfect guidance through curves and other functions.

For indexing, Ø 8mm pins are provided and allow precise positioning in X, Y and Z axis within a +/- 0.03mm repeatability.

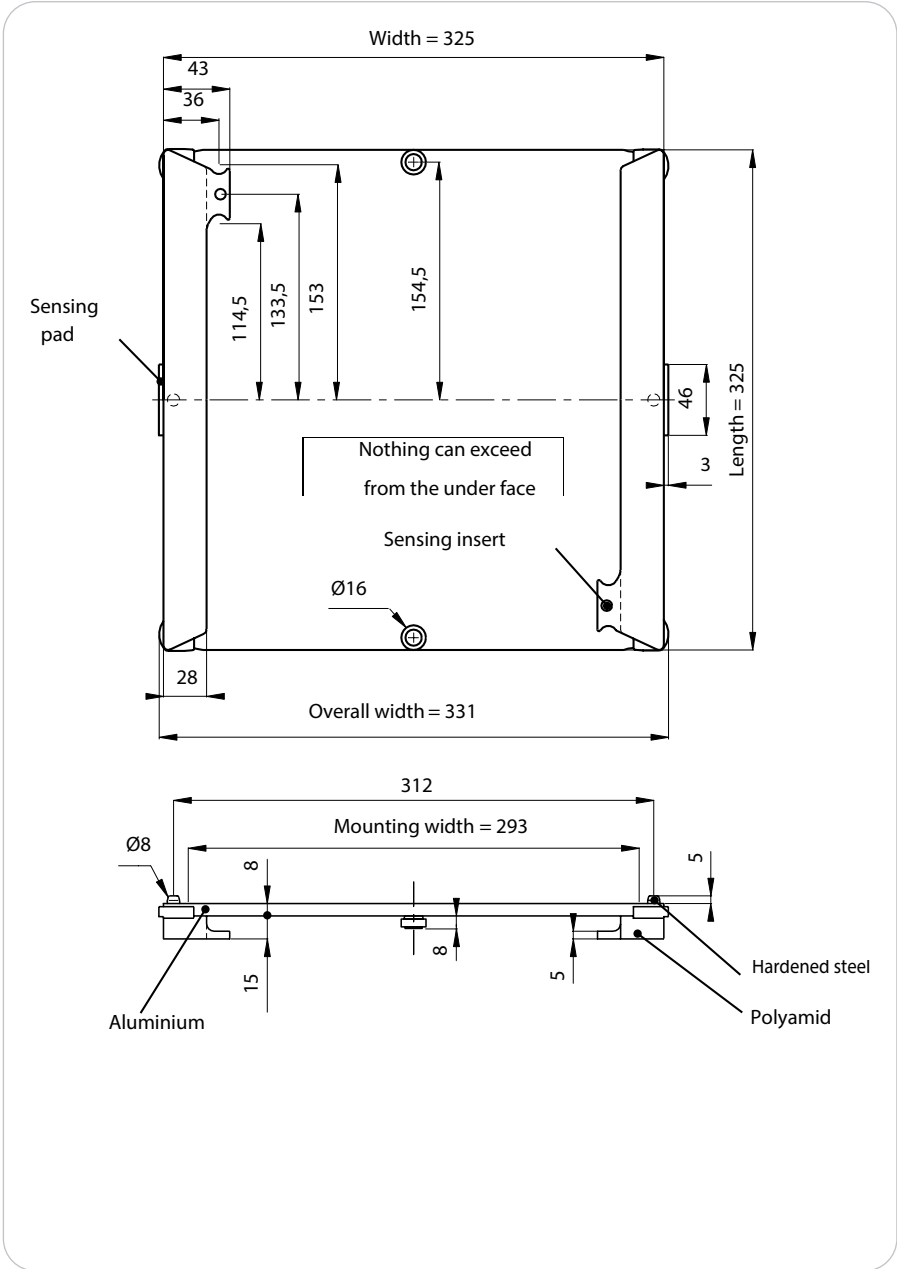
Special contour features within the WPC pad ensures total immobilization at a stop position.

Steel pads on either side allow sensing with conventional inductive sensors. Mechanical data processing can be provided as described in page 262..

Line 325 workpiece carriers (references 8004 and 8005) can accommodate payloads up to **10 kg**.

Friction coefficient:
- 0,25 (carrying)
- 0,50 (accumulation).

Empty weight: 2,5 kg



Designation / Dimensions	Order unit	Reference
Workpiece carrier 325x325 Line 325	1 kit	8004

Workpiece carrier Line 325

Technical data

Workpiece carriers (WPC) are used to locate and transfer parts during the whole production and assembly cycle. Line 325 WPC are made of aluminium plate and polyamid pad and are equipped with ball bearings to ensure perfect guidance through curves and other functions.

For indexing, Ø 8mm pins are provided and allow precise positioning in X, Y and Z axis within a +/- 0.03mm repeatability.

Special contour features within the WPC pad ensures total immobilization at a stop position.

Steel pads on either side allow sensing with conventional inductive sensors. Mechanical data processing can be provided as described in page 262.

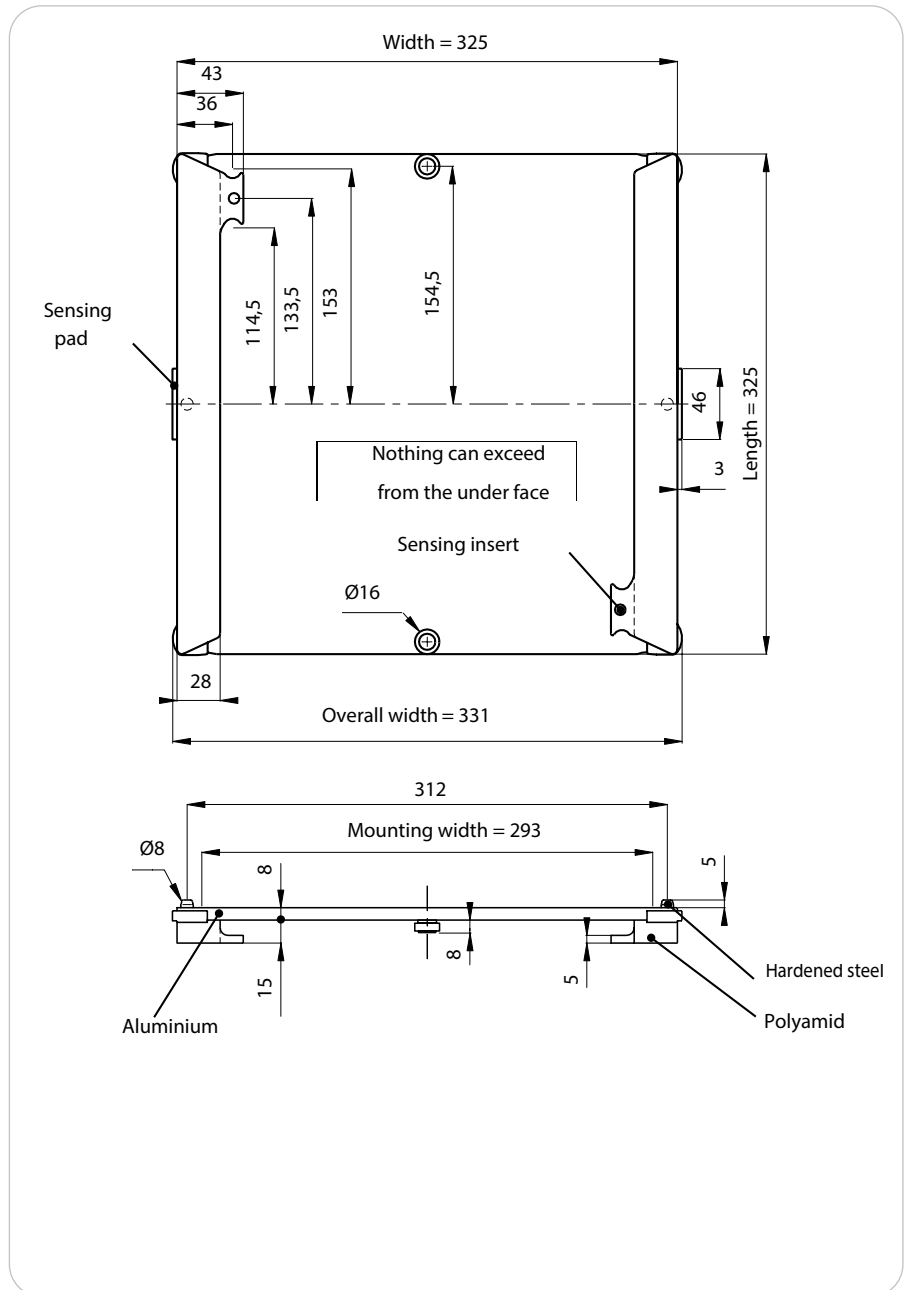
Line 325 workpiece carriers (references 8004 and 8005) can accommodate payloads up to **10 kg**.

WPC plate is made of anodized aluminium. Flatness is better than 0.5mm. Detachable molded polyamid pads may be replaced easily.

Friction coefficient:

- 0,25 (carrying)
- 0,50 (accumulation).

Empty weight: 3,5 kg



Designation / Dimensions	Order unit	Reference
Workpiece carrier 325x475 Line 325	1 kit	8005

Workpiece carrier Line 400

Technical data

Workpiece carriers (WPC) are used to locate and transfer parts during the whole production and assembly cycle. Line 400 WPC is made of aluminium plate and polyamid pad and is equipped with ball bearings to ensure perfect guidance through curves and other functions.

For indexing, Ø 8mm pins are provided and allow precise positioning in X, Y and Z axis within a +/- 0.03mm repeatability.

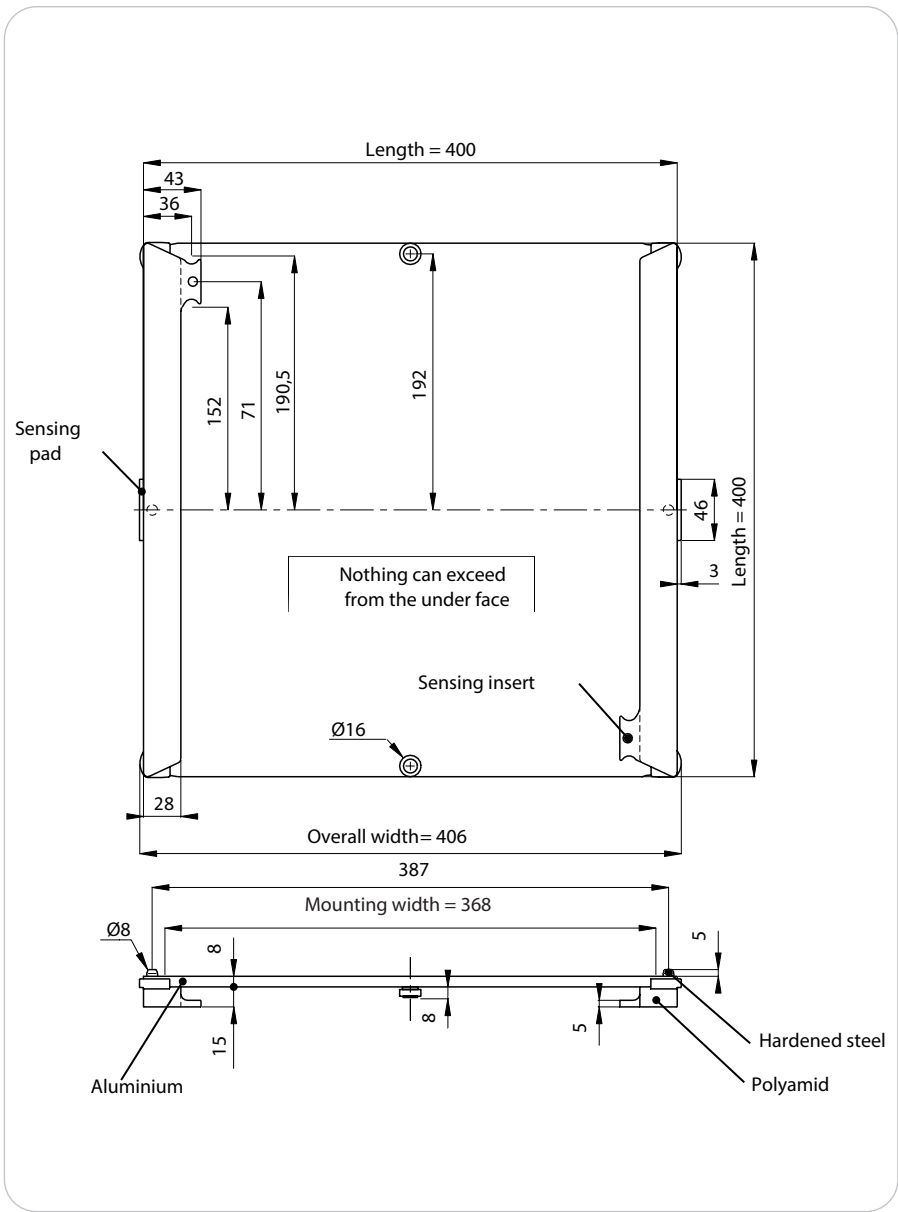
Special contour features within the WPC pad ensures total immobilization at a stop position.

Steel pads on either side allow sensing with conventional inductive sensors. Mechanical data processing can be provided as described in page 262.

Line 400 workpiece carrier (reference 8240) can accommodate payloads up to **10 kg**. WPC plate is made of anodized aluminium. Flatness is better than 0.5mm. Detachable molded polyamid pads may be replaced easily.

Friction coefficient:
- 0,25 (carrying)
- 0,50 (accumulation).

Empty weight: **3,6 kg**



Designation / Dimensions	Order unit	Reference
Workpiece carrier 400x400 Line 400	1 kit	8240

Stop/Pad/Anti-lift/Sensing Lines 175 to 400

Technical data

The stop unit provides a simple stop facility when precise positioning of the workpiece carrier is not necessary.

The stop may also be used for flow control and prioritisation of workpiece carriers prior to and after « mobile » functions and precise station stops.

The pad improves the stop precision by limiting the WPC rotation and the efforts on side fuchsia guides.

Its use is compulsory.

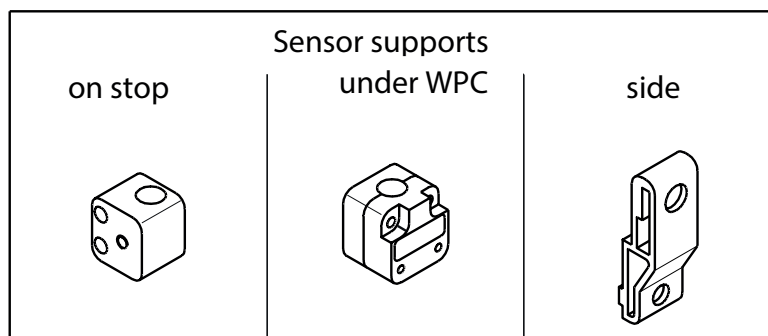
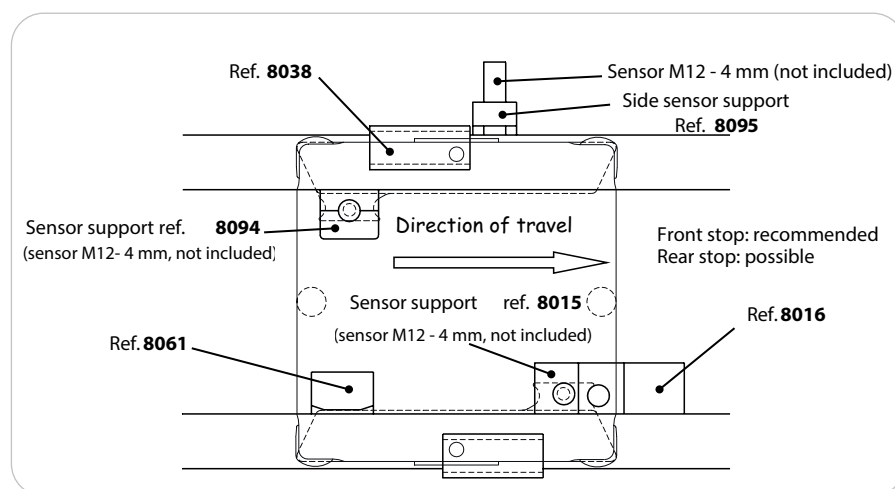
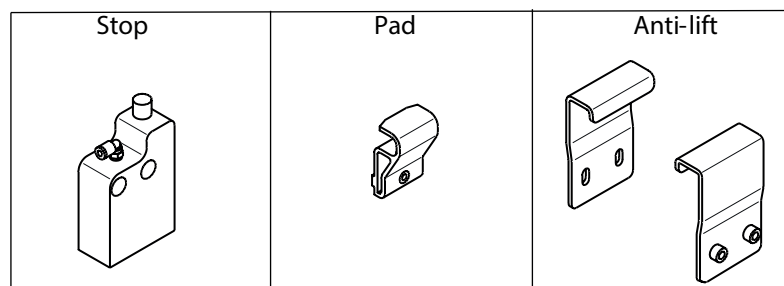
When unloading pieces at manual workstations, the anti-lift kit prevents the operator from lifting of the WPC from the transfer line.

Stop:

- ✗ stop capability: 75 kg
- ✗ stop accuracy +/-0,3mm (with pad)
- ✗ cylinder Ø 25mm, simple acting
- ✗ lubricated or not, cleaned air, 5 to 6 bars
- ✗ connector for Ø 4 mm pipe (provided)
- ✗ acetal body, stainless steel plunger
- ✗ sensing up/down positions: on request ref. 8014 (M8 sensors not included).

Side sensor support

When stopping within a workstation, workpiece carriers may be detected using inductive sensors M12 (recommended span 4mm), with or without connectors, fitted to supports 8015, 8094 or 8095. These sensors also ensure flow and priority control.



Designation / Dimensions	Order unit	Reference
Stopper Lines 175 to 400	1 kit	8016
Pad Lines 175 to 400	1 kit	8061
Anti-lift Lines 175 to 400	1 kit	8038
Sensor support	1 kit	8015
Sensor support from below	1 kit	8094
Sensor support from side	1 kit	8095

Positioning tool 100 kg (stroke 6 mm) Lines 175 to 400

Technical data

When a process requires precise positioning for the workpiece carriers, the positioning 40 kg tool (stroke 6 mm) ensures a +/- 0.03 mm XYZ repeatability.

The positioning tool is manufactured from high grade aluminium. A double-acting pneumatic cylinder lifts and secures the workpiece carrier in hardened steel jaws.

Two sensors fitted on the cylinder body ensure detection of up/down positions.


Threads in the side of the positioning tool allow the use of M12 sensors (not included).

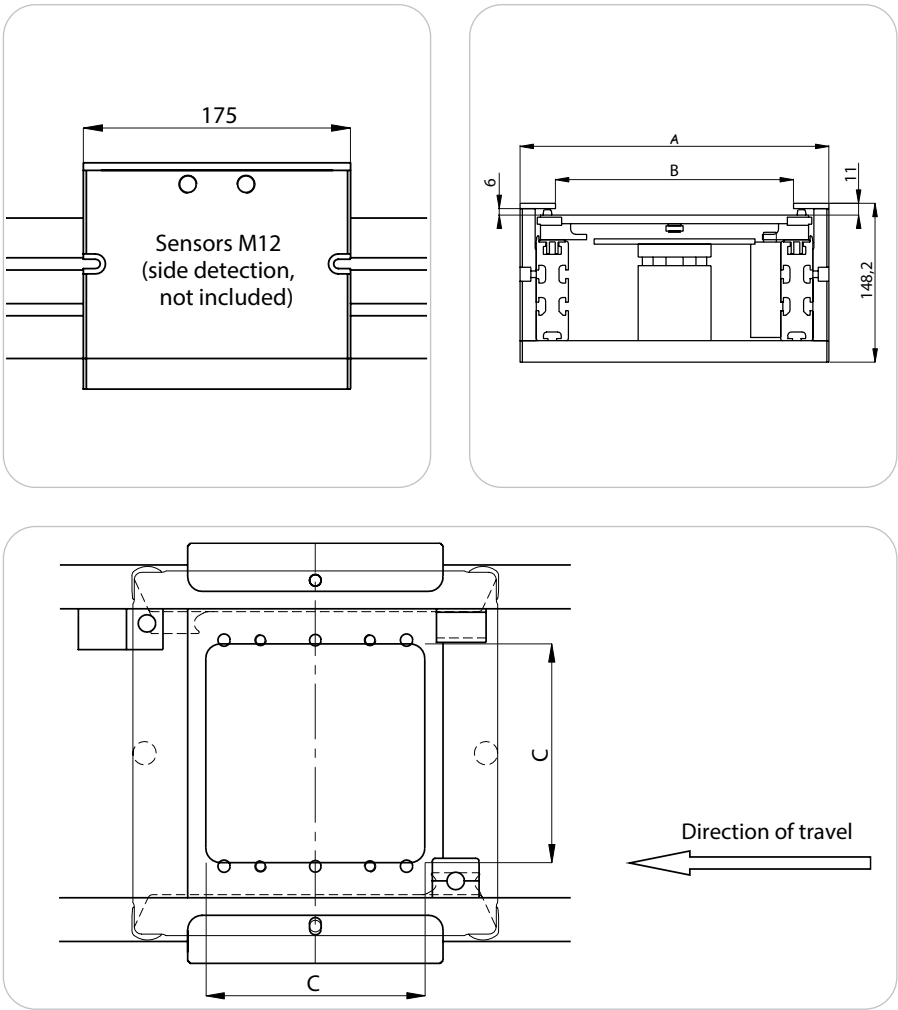
Vertical central available loading: 100 kg.
Provide for 2 stops 8016 and 2 pads 8061.

Cylinder:

- Ø 50 mm, double acting
- lubricated or not, cleaned air, 4 to 6 bars
- connectors Ø 4 mm pipe (included)
- 2 sensors (included)

IMPORTANT

-  **The positioning tool must be fitted to a stable and robust structure in order to ensure the accuracy of this function**
- The positioning tool must be fully guarded once fitted.**



	Line 175	Line 250	Line 325	Line 400
Reference :	8417-MW	8418-MW	8419-MW	8424-MW
A (mm)	213	288	363	438
B (mm)	147	222	297	372
C (mm)	85	150	200	270

Designation / Dimensions	Order unit	Reference
Positioning tool 100 kg stroke 6 mm Line 175	1 kit	8417-MW
Positioning tool 100 kg stroke 6 mm Line 250	1 kit	8418-MW
Positioning tool 100 kg stroke 6 mm Line 325	1 kit	8419-MW
Positioning tool 100 kg stroke 6 mm Line 400	1 kit	8424-MW

Positioning tool 100 kg (strokes 50 and 100 mm) Line 175 to 400

Technical data

The 50 mm or 100 mm stroke version of the positioning tool 40 kg ensures a $\pm 0.03\text{mm}$ XYZ repeatability.

The positioning tool is manufactured from high grade aluminium. A double-acting pneumatic cylinder lifts and secures the workpiece carrier in hardened steel jaws.

Two sensors fitted on the cylinder body ensure detection of up/down positions.

Threads in the side of the positioning tool allow the use of M12 sensors (not included).

Vertical central available loading: 100 kg. Provide for 2 stops 8016 and 2 pads 8061.

Cylinder:

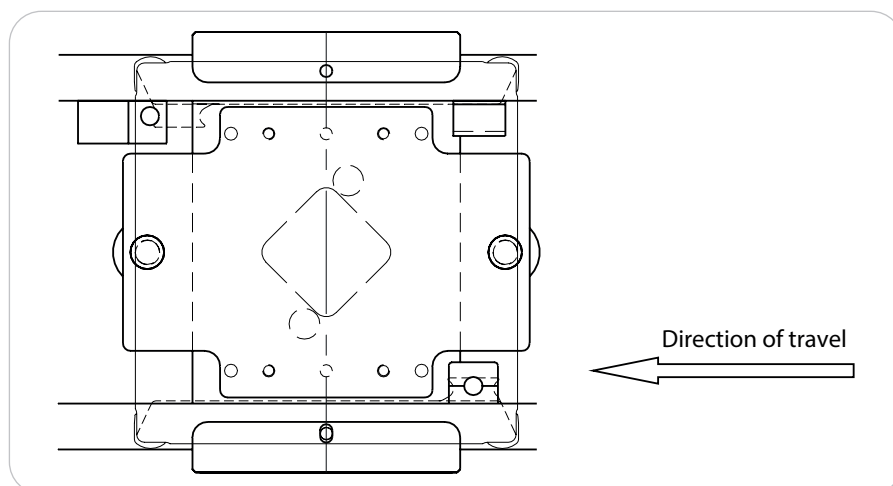
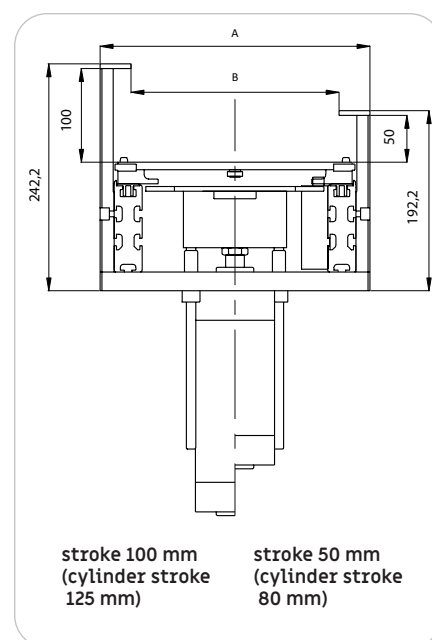
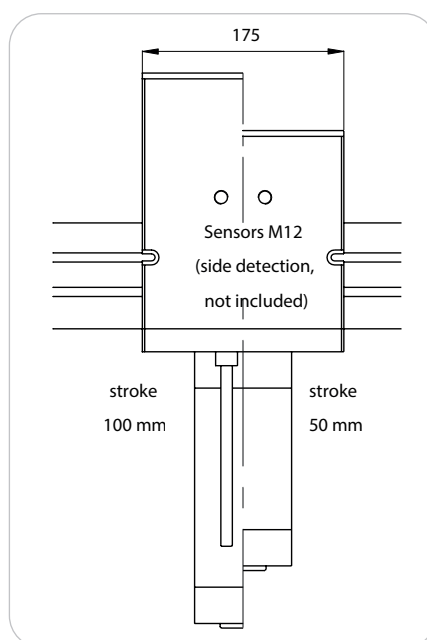
- ✗ Ø 50 mm ISO, double acting
- ✗ lubricated or not, cleaned air, 4 to 6 bars
- ✗ connectors Ø 8 mm pipe (included)
- ✗ 2 sensors (included)

IMPORTANT



✗ The positioning tool must be fitted to a stable and robust structure in order to ensure the accuracy of this function

✗ The positioning tool must be fully guarded once fitted.



	Line 175	Line 250	Line 325	Line 400
Reference (stroke 50mm)	8117	8118	8119	8124
Reference (stroke 100mm)	8217	8218	8219	8224
A (mm)	213	288	363	438
B (mm)	147	222	297	372

Designation / Dimensions	Order unit	Reference
Positioning tool 100 kg stroke 50 mm Line 175	1 kit	8117
Positioning tool 100 kg stroke 50 mm Line 250	1 kit	8118
Positioning tool 100 kg stroke 50 mm Line 325	1 kit	8119
Positioning tool 100 kg stroke 50 mm Line 400	1 kit	8124
Positioning tool 100 kg stroke 100 mm Line 175	1 kit	8217
Positioning tool 100 kg stroke 100 mm Line 250	1 kit	8218
Positioning tool 100 kg stroke 100 mm Line 325	1 kit	8219
Positioning tool 100 kg stroke 100 mm Line 400	1 kit	8224

Positioning tool anvil (stroke 6 mm) Lines 175 to 400

Technical data

When a process requires precise positioning under strong efforts, the anvil positioning tool ensures a $\pm 0.03\text{mm}$ XYZ repeatability. The positioning tool is manufactured from high grade aluminium.

The lift mechanism is designed with synthetic material (reduced maintenance) and is actuated by a double-acting pneumatic.

Two sensors fitted on the cylinder body ensure detection of up/down positions. Threads in the side of the positioning tool allow the use of M12 sensors (not included).

Vertical central available loading: 5000kg (irreversible mechanism). Provide for 2 stops 8016 and 2 pads 8061.

Cylinder:

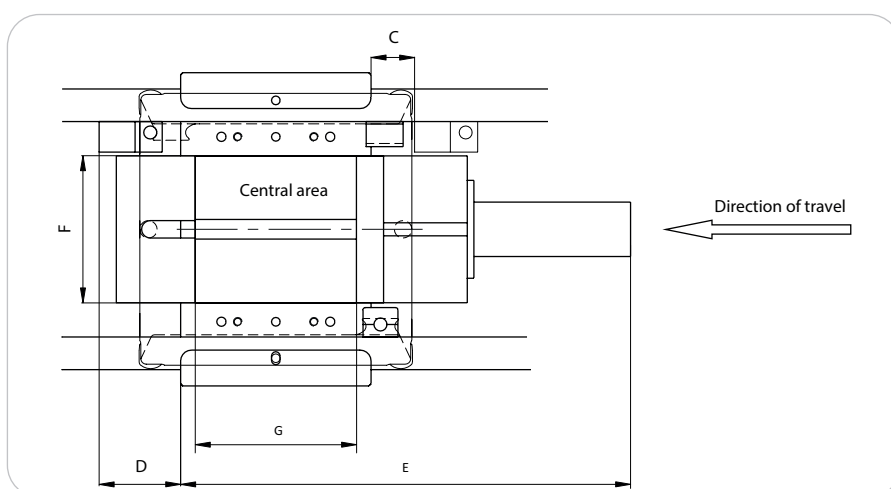
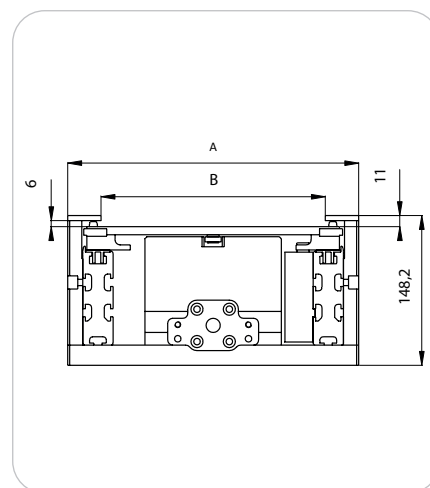
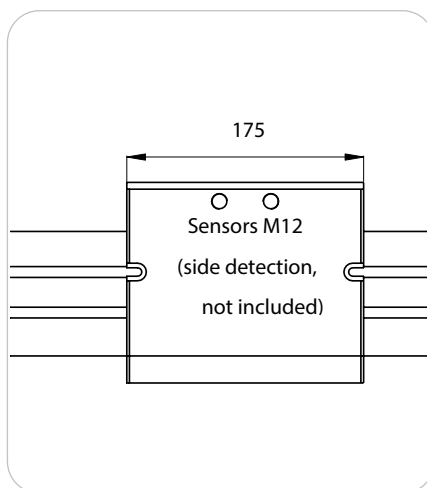
- ✗ Ø 32 mm, double acting
- ✗ lubricated or not, cleaned air, 4 to 6 bars
- ✗ connectors Ø 4 mm pipe (included)
- ✗ 2 sensors (included)

IMPORTANT



✗ The positioning tool must be fitted to a stable and robust structure in order to ensure the accuracy of this function

✗ The positioning tool must be fully guarded once fitted.



	Line 175	Line 250	Line 325	Line 400
Reference :	8020	8021	8022	8324
A (mm)	213	288	363	438
B (mm)	147	222	297	372
C (mm)	70	40	78	116
D (mm)	38	75	112.5	150
E (mm)	382	413.5		
F (mm)	75	130		
G (mm)	80	140		

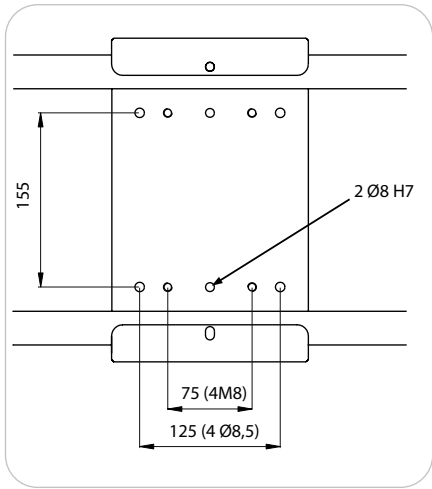
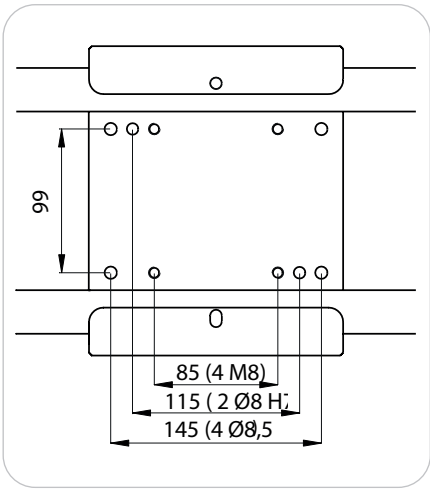
Designation / Dimensions	Order unit	Reference
Positioning tool anvil stroke 6 mm Line 175	1 kit	8420
Positioning tool anvil stroke 6 mm Line 250	1 kit	8421
Positioning tool anvil stroke 6 mm Line 325	1 kit	8422
Positioning tool anvil stroke 6 mm Line 400	1 kit	8424

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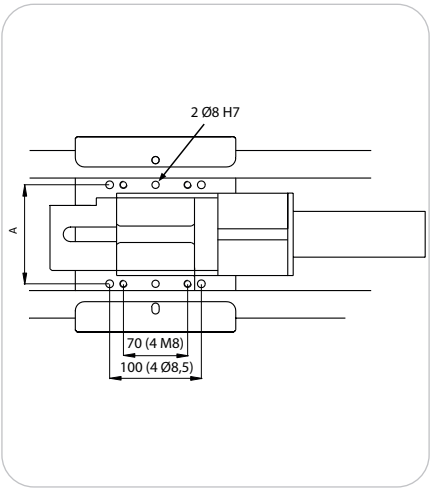
Setting of positioning tools Lines 175 to 400

Technical data

General setting for 100 Kg positioning tools **Lines 175 to 400.**



General setting for anvil positioning tools **Lines 175 to 400.**



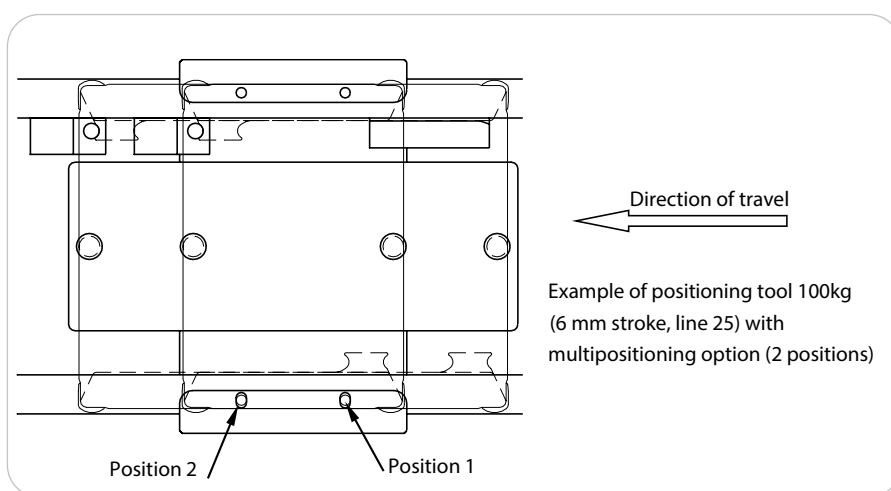
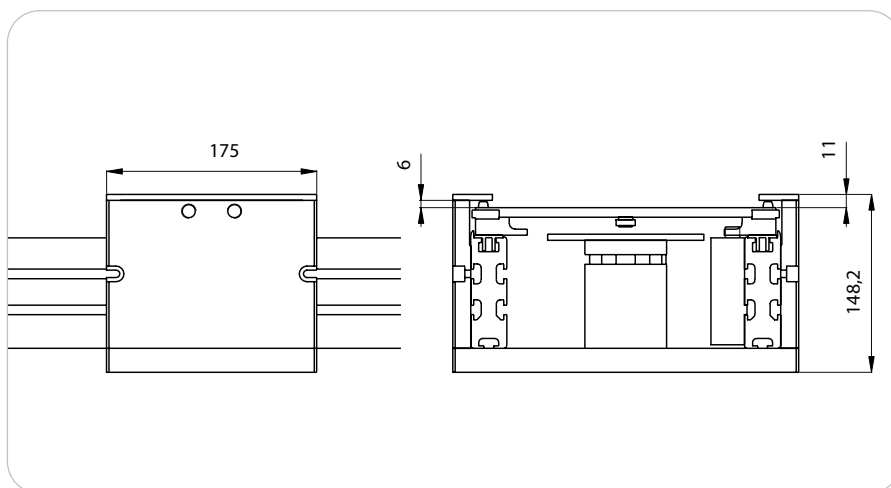
	A (mm)
Voie 175	108
Voie 250	170
Voie 325	
Voie 400	

Multipositioning tool

Technical data

In order to reduce cycle times and to repeat an operation on the same workpiece carrier, 100kg and anvil positioning tools may receive special steel jaws for multiple indexing (2 or 3 positions).

This option is not available for line 100 and is quite difficult to apply to line 175. For lines 250 to 400, it requires a specific study, depending on the number of positions, span and workpiece carrier lifting and sensing.



Technical data

Using the 90° static curve, it is possible to cross from one section perpendicular to another.

Two railwheels beneath the workpiece carriers ensure perfect guidance by fitting into a central 12x22 aluminium rail.

Specially designed claws allow the bed plates to be fitted easily.

In this configuration, accumulation of workpiece carriers is possible. The small content of mechanical elements and features within the 90° curve results in high reliability.

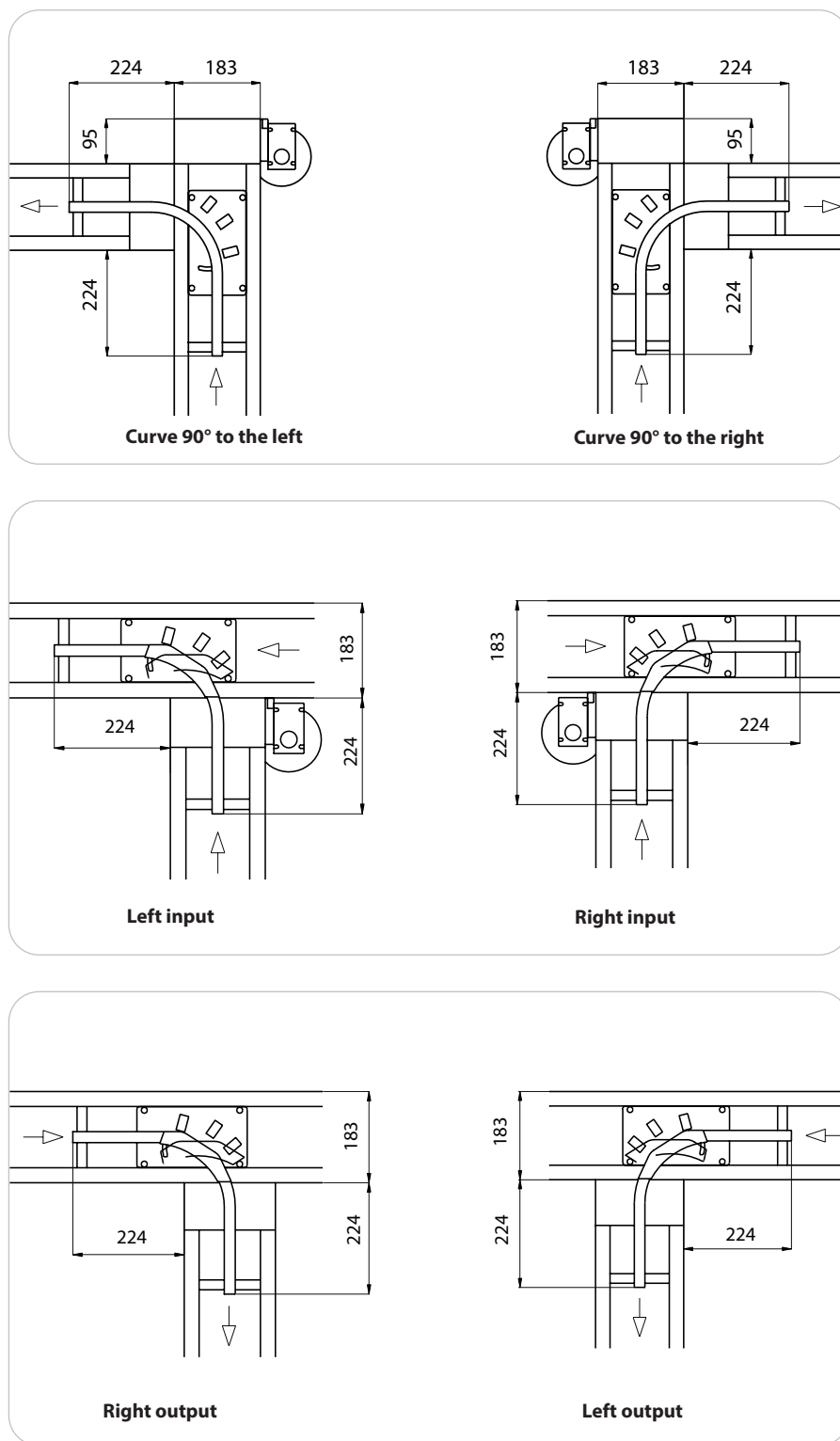
Curve 90° mobile allows workpiece carriers to be introduced from a secondary section to a main on (« input ») or from a main section to a secondary one (« output »). Two railwheels beneath the workpiece carriers ensure perfect guidance by fitting into a central 12x22 aluminium rail.

This function is « mobile » due to the swivel curved central rail.

The curve 90° mobile presents a reduced flow-stoppage rate requiring minimum automation.

Mobile rail cylinder:

- ✗ Ø 15 mm, double acting
- ✗ lubricated or not, cleaned air, 5 to 6 bars
- ✗ connectors for Ø4mm pipe (included)
- ✗ M8 sensors under mobile rail bearing (not included)

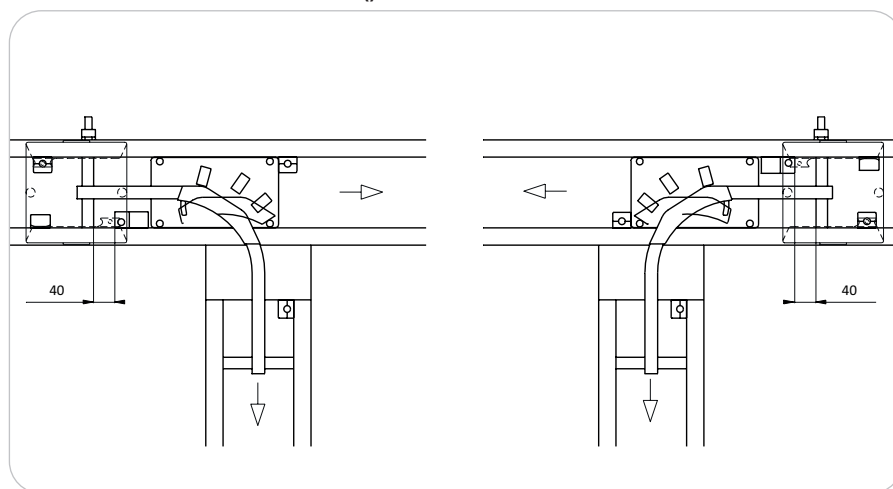
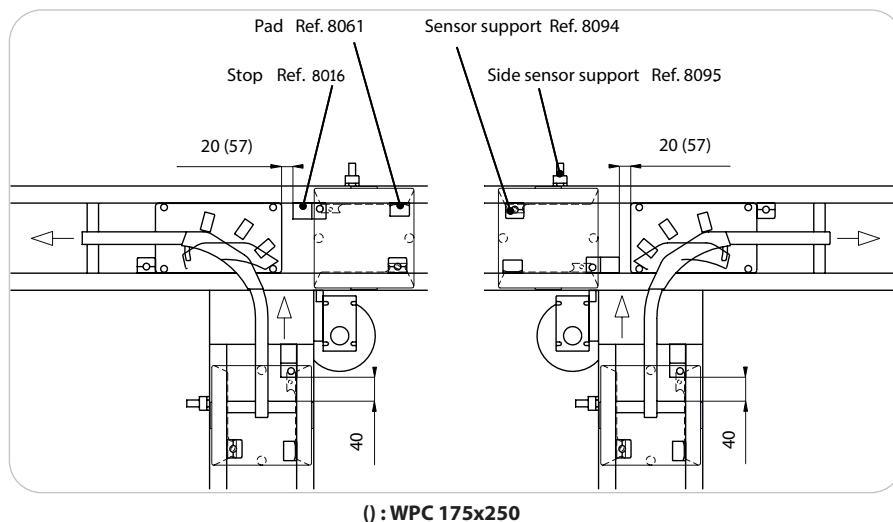


Designation / Dimensions	Order unit	Reference
Curve 90° static to the left Line 175	1 kit	4027
Curve 90° static to the right Line 175	1 kit	4026
Curve 90° mobile left input Line 175	1 kit	4033
Curve 90° mobile Right input Line 175	1 kit	4034
Curve 90° mobile Right output Line 175	1 kit	4033
Curve 90° mobile Left output Line 175	1 kit	4034

Technical data

The minimum distance at which the workpiece carriers may be stopped in relationship to the curve is shown in the drawings below. Both 175x175 and 175x250 workpiece carriers are concerned.

Similarly, to chain up 90° curves (static or mobile), it is compulsory to take care of minimal space as shown in page 261.



Curve 180° Line 175

Technical data

Using the 180° curve, it is possible to cross from one section in parallel to another operating in the opposite direction.

Four combinations cover all possible configurations.

This function is « mobile » due to the swivel curved central rail. In the « static/static » curve, accumulation of workpiece carriers is possible.

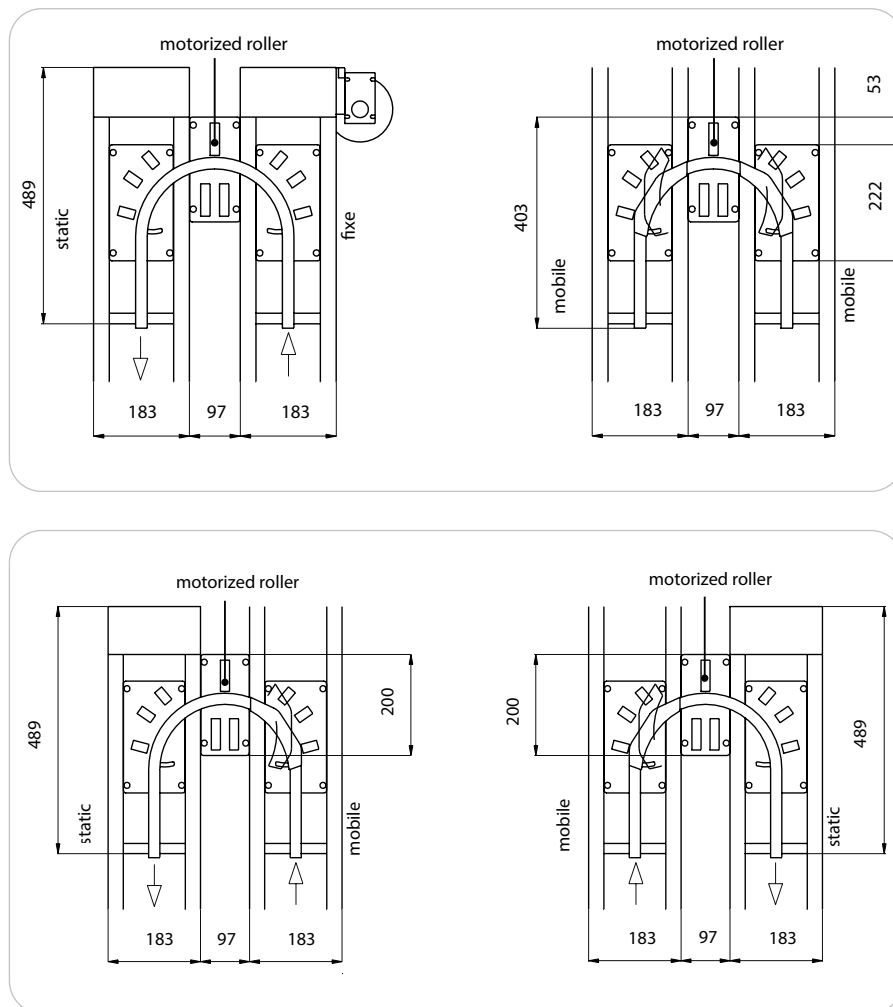
The bed plate between the sections (« middle bed plate ») is equipped with a motorized roller to aid workpiece carriers through the curve.

Mobile rail cylinder:

- ✗ Ø 15 mm, double acting
- ✗ lubricated or not, cleaned air, 5 to 6 bars
- ✗ connectors for Ø4mm pipe (included)
- ✗ M8 sensors under mobile rail bearing (not included)

Motorized roller motor:

- ✗ power: 6,3 W
- ✗ voltage: 220 V single-phase
- ✗ frequency: 50 Hz
- ✗ rated current: 73 mA

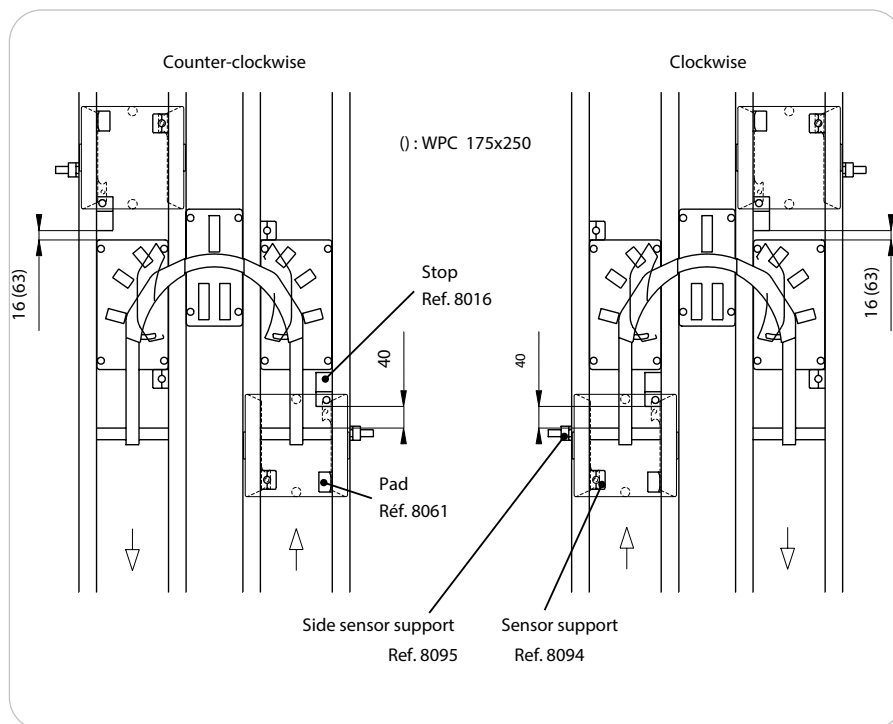


Designation / Dimensions	Order unit	Reference
Curve 180° Static/static Line 175	1 kit	4064
Curve 180° Static/mobile Line 175	1 kit	4067
Curve 180° Mobile/mobile Line 175	1 kit	4073
Curve 180° Mobile/static Line 175	1 kit	4068

Technical data

The minimum distance at which the workpiece carriers may be stopped in relationship to the curve is shown in the drawings below.

Both 175x175 and 175x250 workpiece carriers are concerned.



Combination input/output Line 175

Technical data

The function of the input/output combination is adapted to transfer workpiece carriers from one section to another operating in parallel and running in the same direction.

This function is « mobile » due to the swivel curved 12x22 rail. The bed plate between the sections (« middle bed plate ») is equipped with two motorized rollers (driven by only one motor) to aid workpiece carriers through the transfer sections.

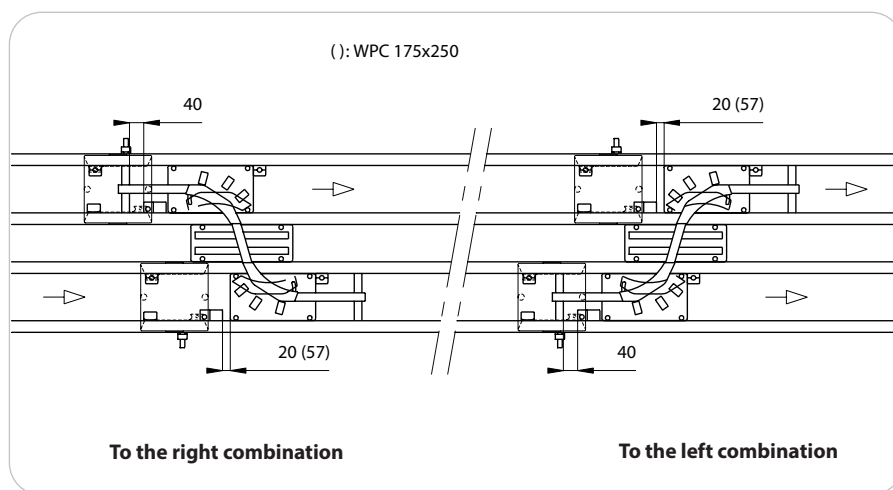
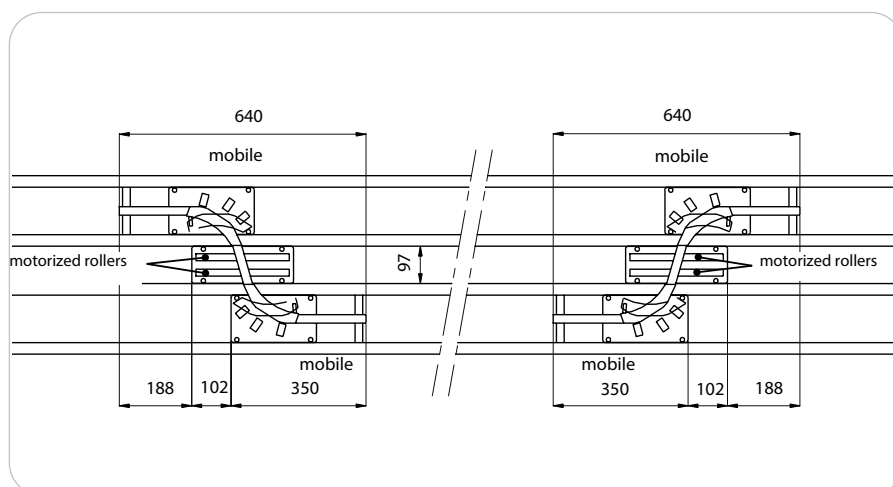
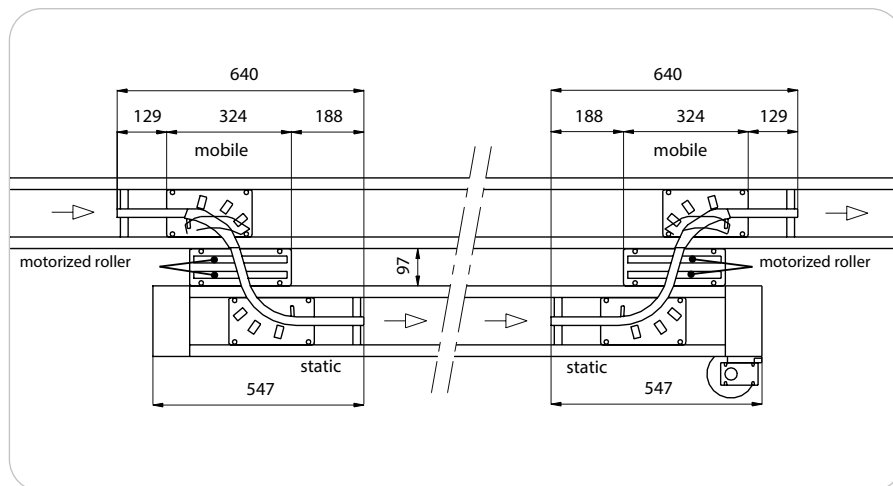
Mobile rail cylinder:

- ✗ Ø 15 mm, double acting
- ✗ lubricated or not, cleaned air, 5 to 6 bars
- ✗ connectors for Ø 4mm pipe (included)
- ✗ M8 sensors under mobile rail bearing (not included)

Motorized roller motor:

- ✗ power: 6,3 W
- ✗ voltage: 220 V single-phase
- ✗ frequency: 50 Hz
- ✗ rated current: 73 mA

The minimum distance at which the workpiece carriers may be stopped in relationship to the combination is shown in the drawings below.



Designation / Dimensions	Order unit	Reference
Combination right input/output, static/mobile Line 175	1 kit	4077
Combination left input/output, static/mobile Line 175	1 kit	4080
Combination right input/output, mobile/mobile Line 175	1 kit	4078
Combination left input/output, mobile/mobile Line 175	1 kit	4081

Technical data

Using the 90° static curve, it is possible to cross from one section perpendicular to another. Two railwheels beneath the workpiece carriers ensure perfect guidance by fitting into a central 12x22 aluminium rail.

Specially designed claws allow the bed plates to be fitted easily.

In this configuration, accumulation of workpiece carriers is possible.

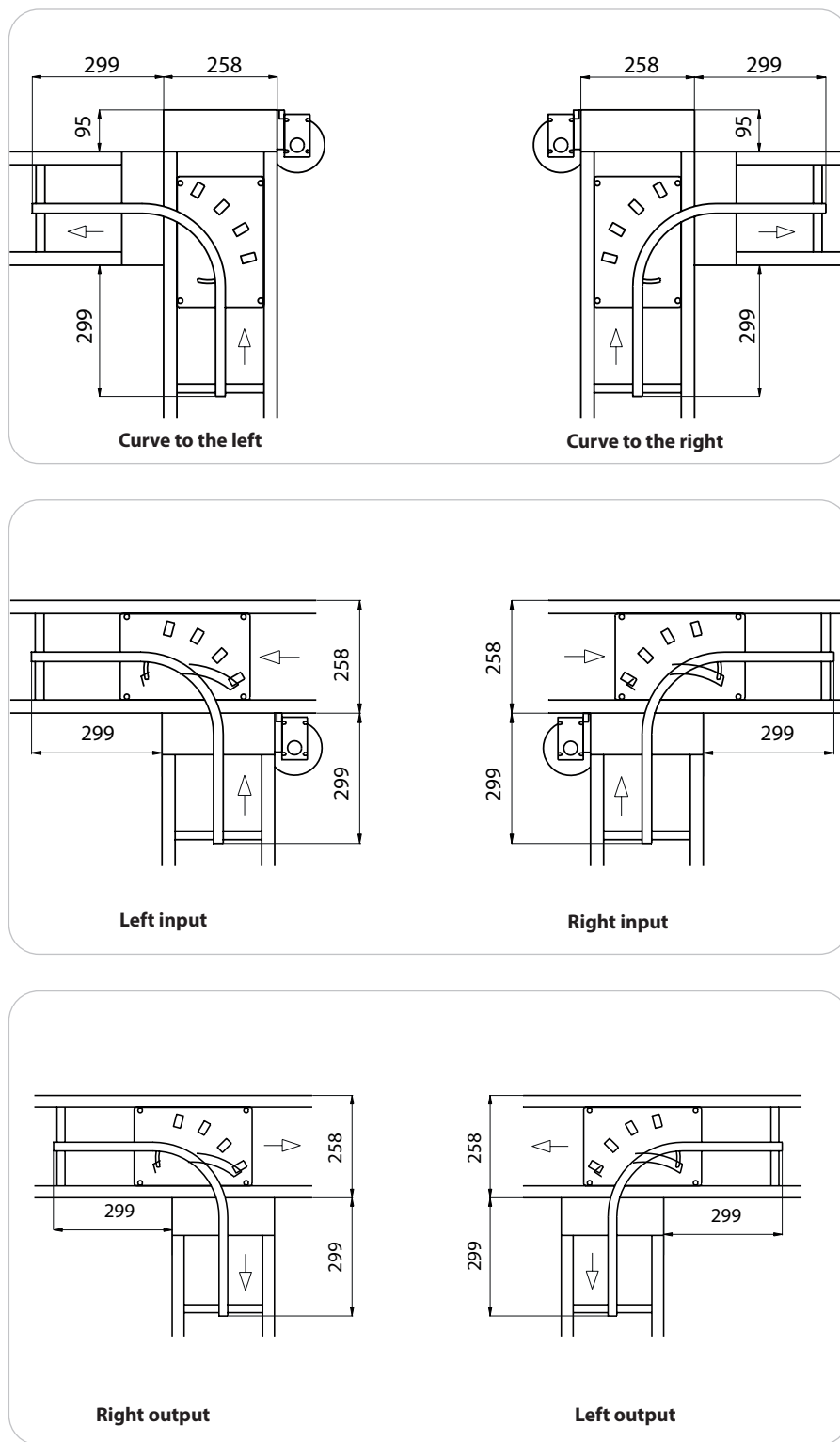
The small content of mechanical elements and features within the 90° curve results in high reliability.

Curve 90° mobile allows workpiece carriers to be introduced from a secondary section to a main one (« input ») or from a main section to a secondary one (« output »). Two railwheels beneath the workpiece carriers ensure perfect guidance by fitting into a central 12x22 aluminium rail.

This function is « mobile » due to the swivel curved central rail. The 90° curve mobile presents a reduced flow-stoppage rate requiring minimum automation.

Mobile rail cylinder:

- ✗ Ø 15 mm, double acting
- ✗ lubricated or not, cleaned air, 5 to 6 bars
- ✗ connectors for Ø 4mm pipe (included)
- ✗ M8 sensors under mobile rail bearing (not included)



Designation / Dimensions	Order unit	Reference
Curve 90° to the left, static Line 250	1 kit	4029M
Curve 90° to the right, static Line 250	1 kit	4028M
Curve 90° left input, mobile Line 250	1 kit	4035M
Curve 90° right input, mobile Line 250	1 kit	4036M
Curve 90° right output, mobile Line 250	1 kit	4035M
Curve 90° left output, mobile Line 250	1 kit	4036M

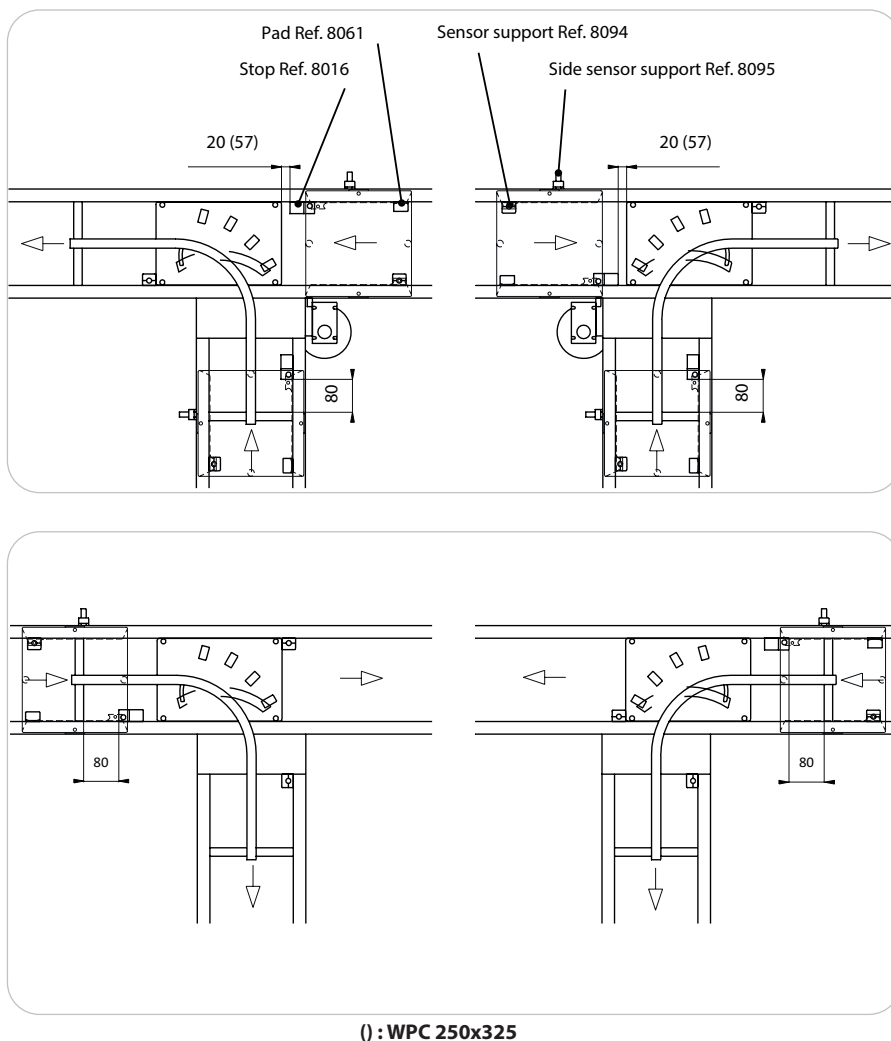
Curve 90° (gestion) Line 250

Technical data

The minimum distance at which the workpiece carriers may be stopped in relationship to the curve is shown in the drawings below.

Both 250x250 and 250x325 workpiece carriers are concerned.

Similarly, to chain up 90° curves (static or mobile), it is compulsory to take care of minimal space as shown in page 261.



Curve 180° Line 250

Technical data

Using the 180° curve, it is possible to cross from one section in parallel to another operating in the opposite direction.

Four combinations cover all possible configurations.

This function is « mobile » due to the swivel curved central rail. In the « static/static » curve, accumulation of workpiece carriers is possible.

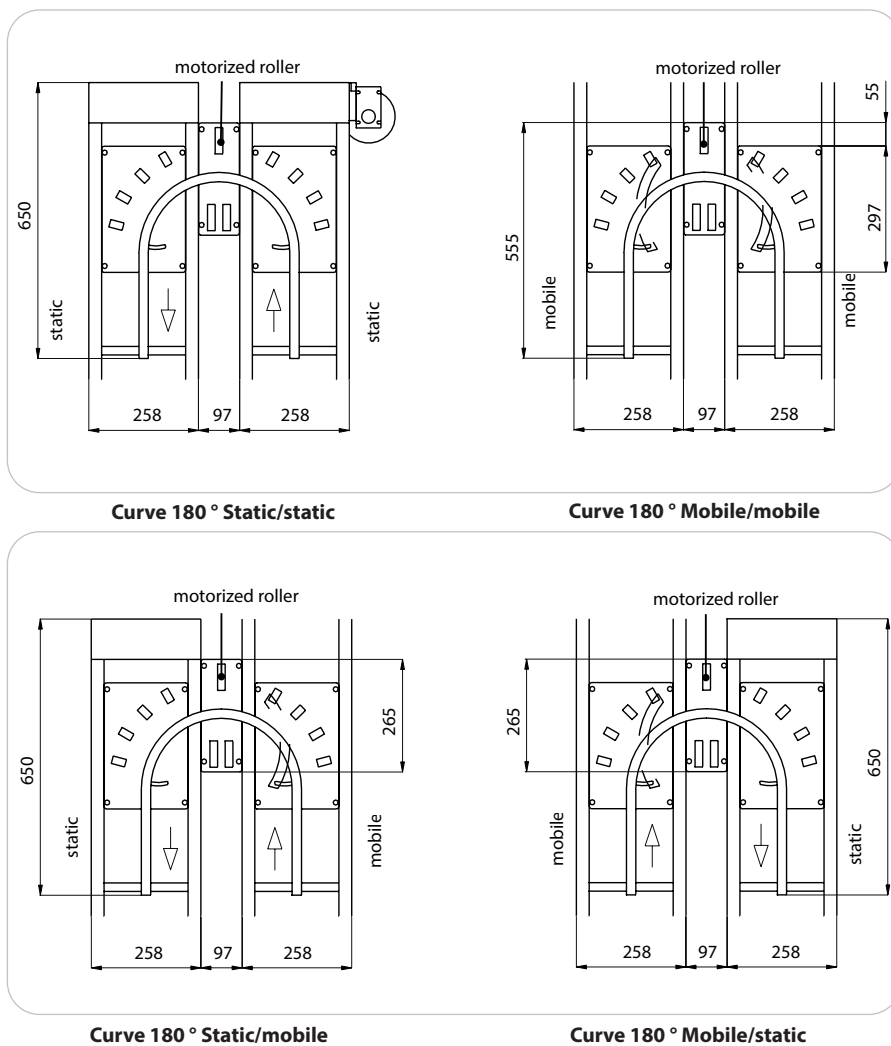
The bed plate between the sections, (« middle bed plate ») is equipped with a motorized roller to aid workpiece carriers through the curve.

Mobile rail cylinder:

- ✗ Ø 15 mm, double acting
- ✗ lubricated or not, cleaned air, 5 to 6 bars
- ✗ connectors for Ø4mm pipe (included)
- ✗ M8 sensors under mobile rail bearing (not included)

Motorized roller motor:

- ✗ power: 6,3 W
- ✗ voltage: 220 V single-phase
- ✗ frequency: 50 Hz
- ✗ rated current: 73 mA

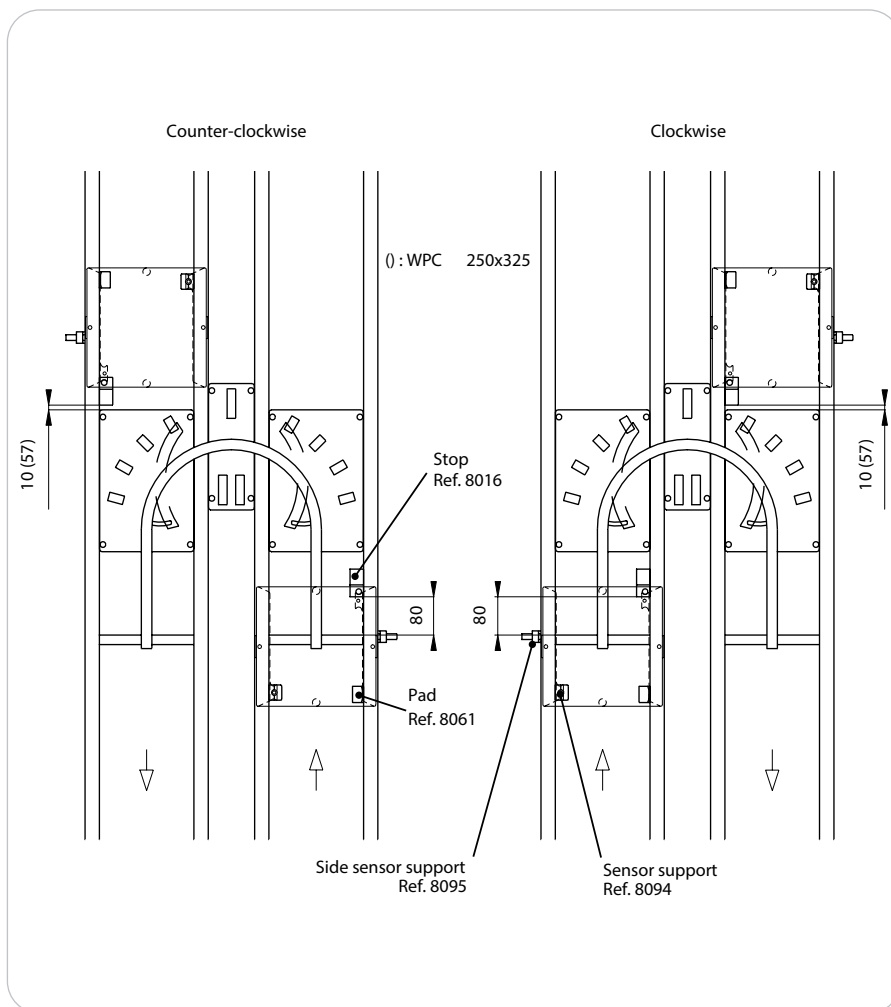


Designation / Dimensions	Order unit	Reference
Curve 180° static/static Line 250	1 kit	4065
Curve 180° static/mobile Line 250	1 kit	4069
Curve 180° mobile/mobile Line 250	1 kit	4074
Curve 180° mobile/static Line 250	1 kit	4070

Technical data

The minimum distance at which the workpiece carriers may be stopped in relationship to the curve is shown in the drawings below.

Both 250x250 and 250x325 workpiece carriers are concerned.



TR

Technical data

Using the 90° static curve, it is possible to cross from one section perpendicular to another. Two railwheels beneath the workpiece carriers ensure perfect guidance by fitting into a central 12x22 aluminium rail. Specially designed claws allow the bed plates to be fitted easily.

The bed plate is equipped with a motorized roller to aid workpiece carrier through the curve. In this configuration, accumulation of workpiece carriers is possible. The small content of mechanical elements and features within the 90° curve results in high reliability.

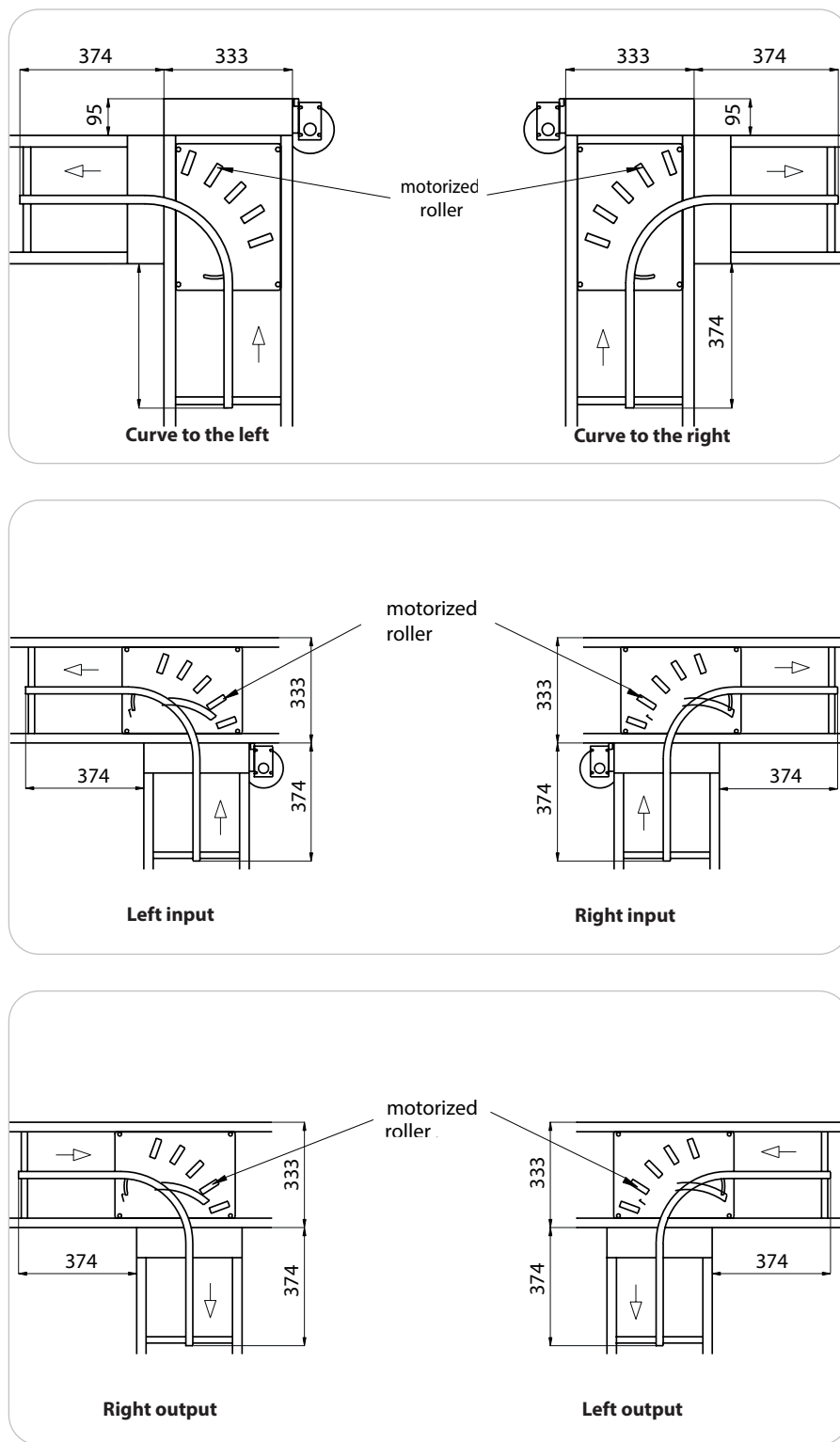
The curve 90° mobile allows workpiece carriers to be introduced from a secondary section to a main one (« input ») or from a main section to a secondary one (« output »). Two railwheels beneath the workpiece carriers ensure perfect guidance by fitting into a central 12x22 aluminium rail. The bed plate is equipped with a motorized roller to aid workpiece carrier through the curve. This function is « mobile » due to the swivel curved central rail. The 90° curve mobile presents a reduced flow-stoppage rate requiring minimum automation.

Mobile rail cylinder:

- ✗ Ø 15 mm, double acting
- ✗ lubricated or not, cleaned air, 5 to 6 bars
- ✗ connectors for Ø 4mm pipe (included)
- ✗ M8 sensors under mobile rail bearing (not included)

Motorized roller motor:

- ✗ power: 6,3 W
- ✗ voltage: 220 V single-phase
- ✗ frequency: 50 Hz
- ✗ rated current: 73 mA

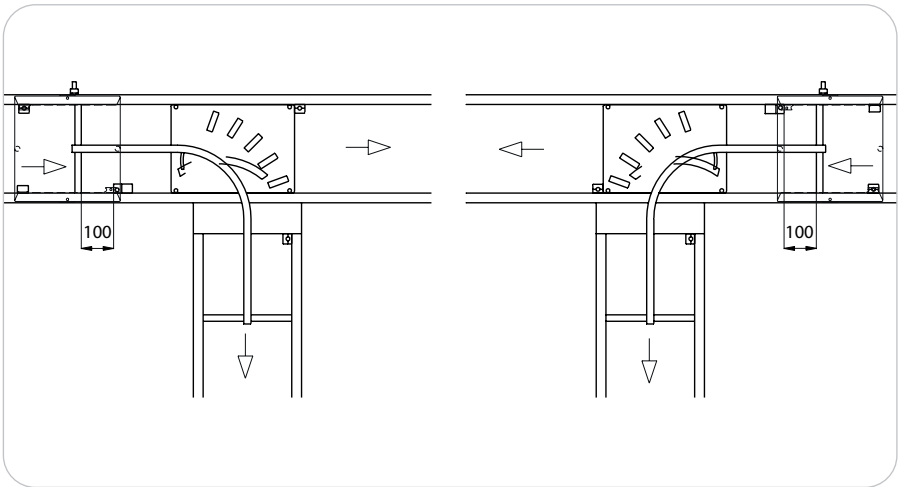
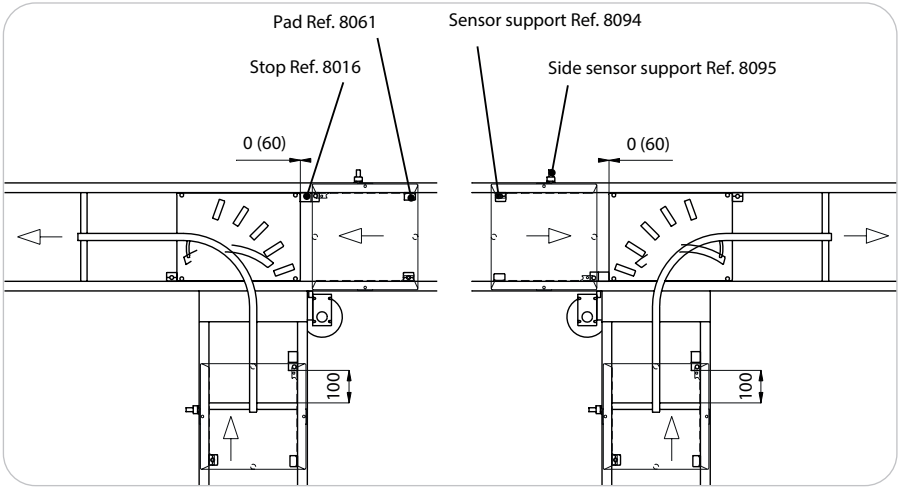


Designation / Dimensions	Order unit	Reference
Curve 90° to the left, static Line 325	1 kit	4031
Curve 90° to the right, static Line 325	1 kit	4030
Curve 90° left input, mobile Line 325	1 kit	4037
Curve 90° right input, mobile Line 325	1 kit	4038
Curve 90° right output, mobile Line 325	1 kit	4037
Curve 90° left output, mobile Line 325	1 kit	4038

Technical data

The minimum distance at which the workpiece carriers may be stopped in relationship to the curve is shown in the drawings below. Both 325x325 and 325x475 workpiece carriers are concerned.

Similarly, to chain up 90° curves (static or mobile), it is compulsory to take care of minimal space as shown in page 261.



() : WPC 325x475

Curve 180° Line 325

Technical data

Using the 180° curve, it is possible to cross from one section in parallel to another operating in the opposite direction.

Four combinations cover all possible configurations.

This function is « mobile » due to the swivel curved central rail. In the « static/static » curve, accumulation of workpiece carriers is possible.

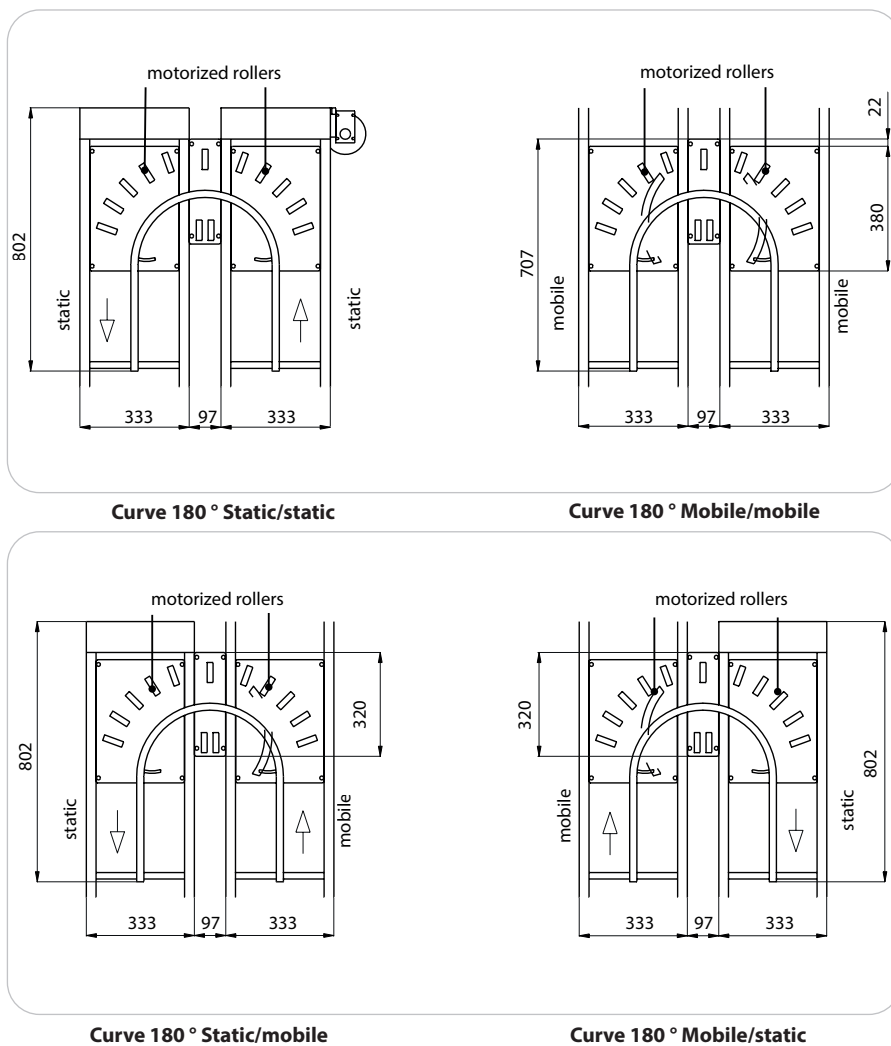
Each input and output bed plate is equipped with a motorized roller to aid workpiece carriers through the curve.

Mobile rail cylinder:

- ✗ Ø 15 mm, double acting
- ✗ lubricated or not, cleaned air, 5 to 6 bars
- ✗ connectors for Ø 4 mm pipe (included)
- ✗ M8 sensors under mobile rail bearing (not included)

Motorized roller motor:

- ✗ power: 6,3 W
- ✗ voltage: 220 V single-phase
- ✗ frequency: 50 Hz
- ✗ rated current: 73 mA

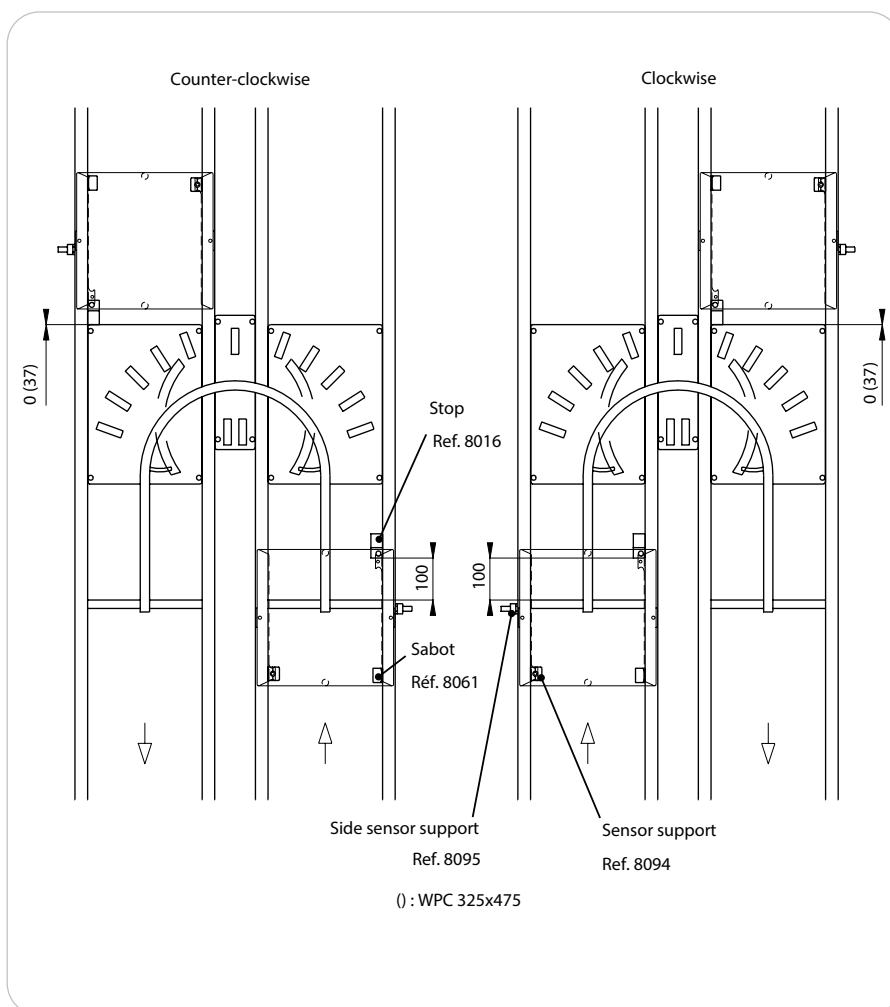


Designation / Dimensions	Order unit	Reference
Curve 180° Static/static Line 325	1 kit	4066
Curve 180° Static/mobile Line 325	1 kit	4071
Curve 180° Mobile/mobile Line 325	1 kit	4075
Curve 180° Mobile/static Line 325	1 kit	4072

Technical data

The minimum distance at which the workpiece carriers may be stopped in relationship to the curve is shown in the drawings below.

Both 325x325 and 325x475 workpiece carriers are concerned.



Technical data

The function of the input/output combination is adapted to transfer workpiece carriers from one section to another operating in parallel and running in the same direction.

This function is « mobile » due to the swivel curved 12x22 rail. Each input and output bed plate is equipped with a motorized roller to aid workpiece carriers through the curve.

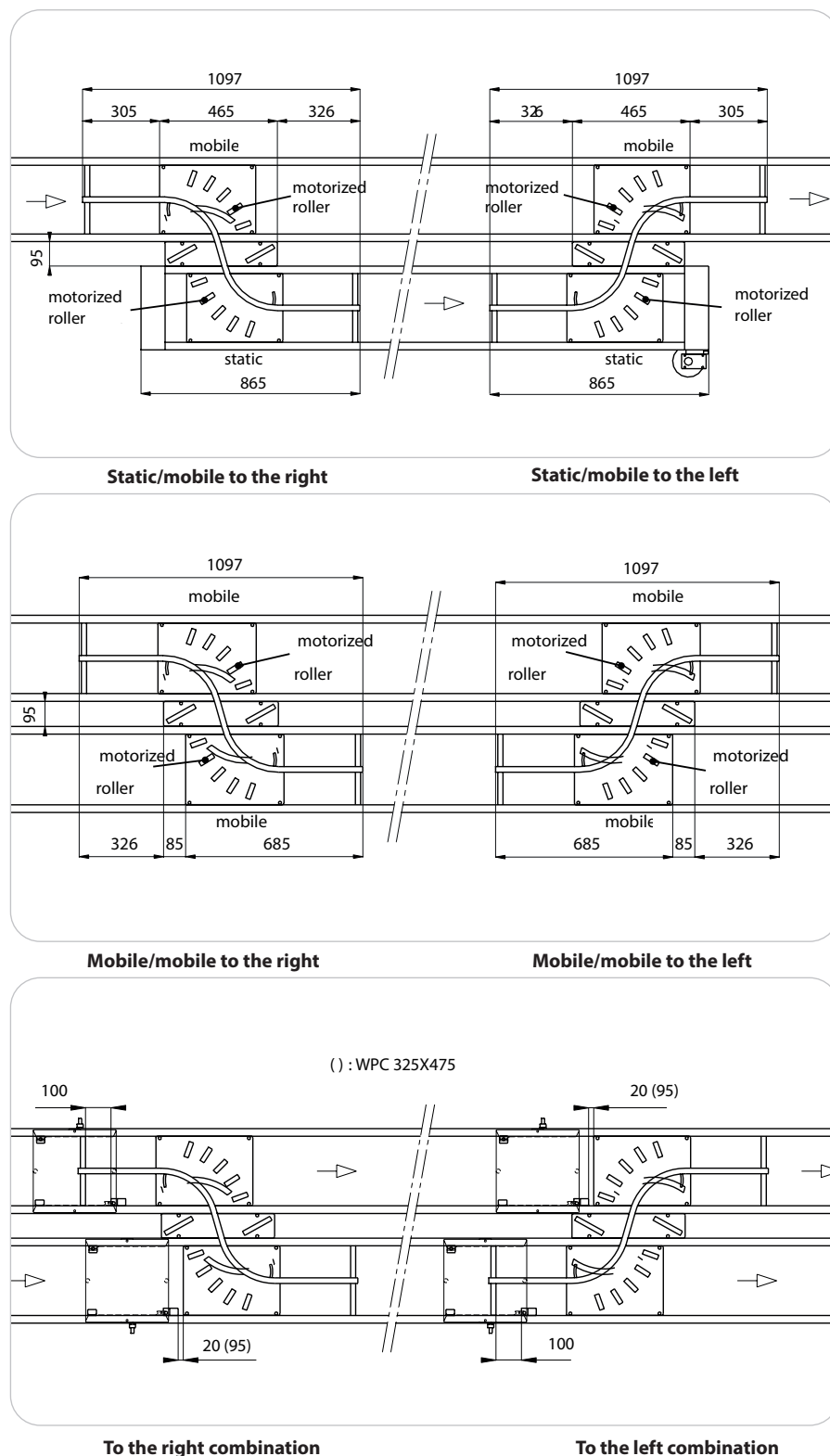
Mobile rail cylinder:

- ✗ Ø 15 mm, double acting
- ✗ lubricated or not, cleaned air, 5 to 6 bars
- ✗ connectors for Ø 4 mm pipe (included)
- ✗ M8 sensors under mobile rail bearing (not included)

Motorized roller motor:

- ✗ power: 6,3 W
- ✗ voltage: 220 V single-phase
- ✗ frequency: 50 Hz
- ✗ rated current: 73 mA

The minimum distance at which the workpiece carriers may be stopped in relationship to the combination is shown in the drawings below.



Designation / Dimensions	Order unit	Reference
Combination right input/output, static/mobile Line 325	1 kit	4089
Combination left input/output, static/mobile Line 325	1 kit	4092
Combination right input/output, mobile/mobile Line 325	1 kit	4090
Combination left input/output, mobile/mobile Line 325	1 kit	4093

Technical data

Using the 90° static curve, it is possible to cross from one section perpendicular to another. Two railwheels beneath the workpiece carriers ensure perfect guidance by fitting into a central 12x22 aluminium rail. Specially designed claws allow the bed plates to be fitted easily. The bed plate is equipped with a motorized roller to aid workpiece carrier through the curve. In this configuration, accumulation of workpiece carriers is possible. The small content of mechanical elements and features within the 90° curve results in high reliability.

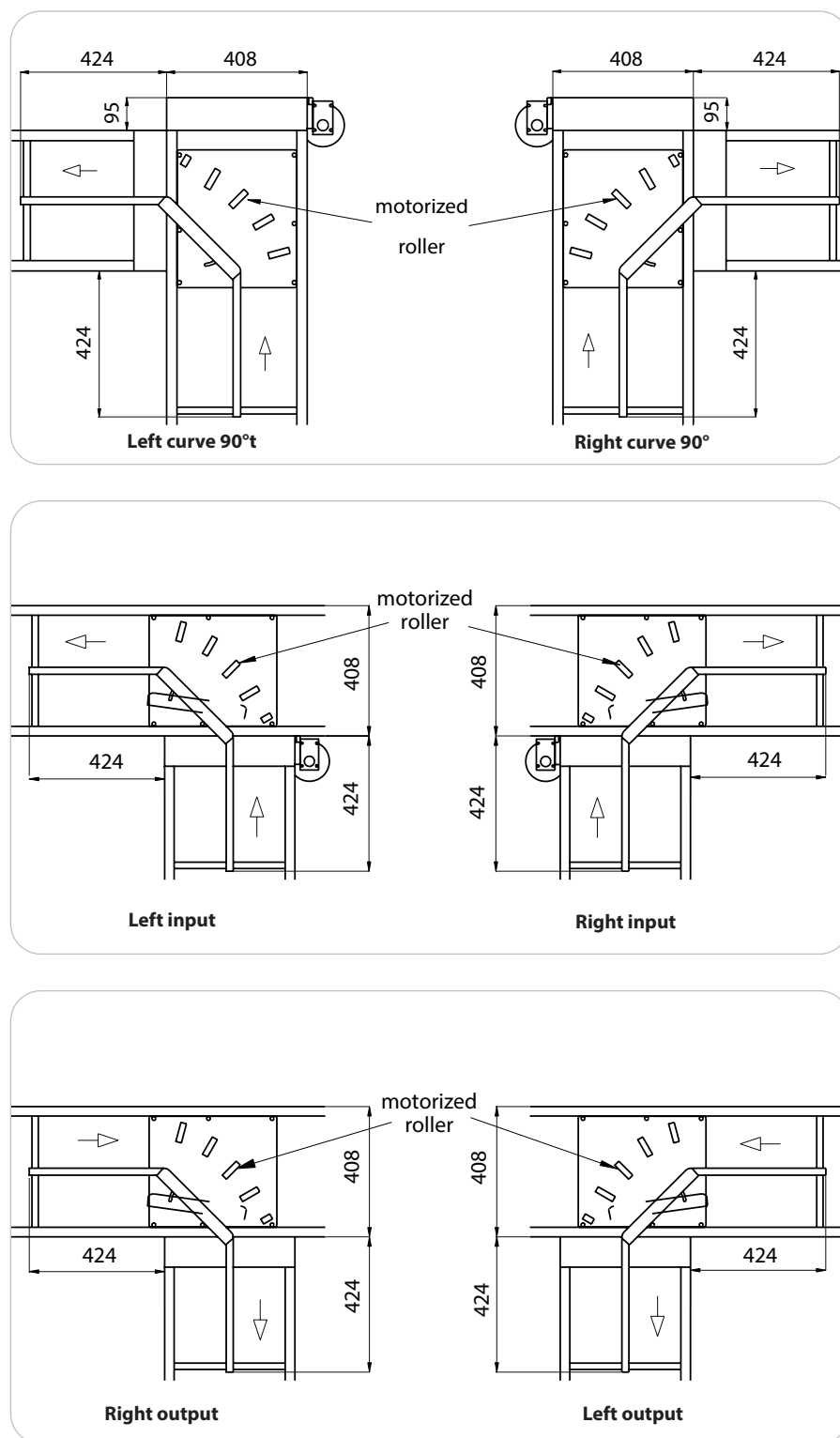
Curve 90° mobile allow workpiece carriers to be introduced from a secondary section to a main one (« input ») or from a main section to a secondary one (« output »). Two railwheels beneath the workpiece carriers ensure perfect guidance by fitting into a central 12x22 aluminium rail. The bed plate is equipped with a motorized roller to aid workpiece carrier through the curve. This function is « mobile » due to the swivel curved central rail. The 90° curve mobile presents a reduced flow-stoppage rate requiring minimum automation.

Mobile rail cylinder:

- ✗ Ø 15 mm, double acting
- ✗ lubricated or not, cleaned air, 5 to 6 bars
- ✗ connectors for Ø 4 mm pipe (included)
- ✗ M8 sensors under mobile rail bearing (not included)

Motorized roller motor:

- ✗ power: 6,3 W
- ✗ voltage: 220 V single-phase
- ✗ frequency: 50 Hz
- ✗ rated current: 73 mA



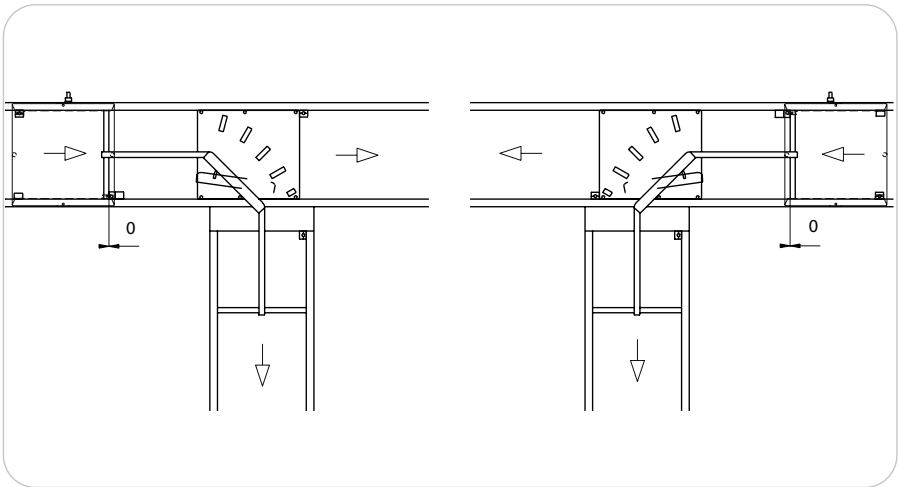
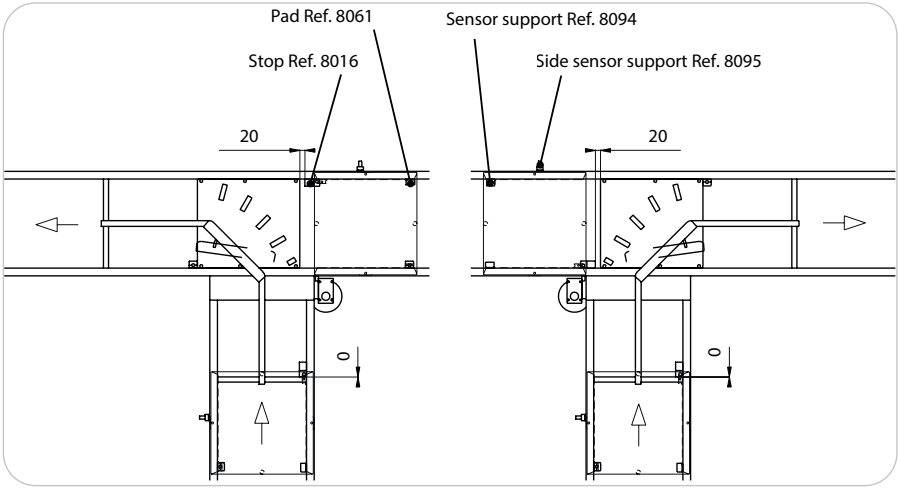
Designation / Dimensions	Order unit	Reference
Curve 90° to the left, static Line 325	1 kit	4111
Curve 90° to the right, static Line 325	1 kit	4110
Curve 90° left input, mobile Line 325	1 kit	4112
Curve 90° right input, mobile Line 325	1 kit	4113
Curve 90° right output, mobile Line 325	1 kit	4112
Curve 90° left output, mobile Line 325	1 kit	4113

Curve 90° (gestion) Line 400

Technical data

The minimum distance at which the workpiece carriers may be stopped in relationship to the curve is shown in the drawings below. 400x400 workpiece carriers are concerned.

Similarly, to chain up 90° curves (static or mobile), it is compulsory to take care of minimal space as shown in page 261.



() : WPC 325x475

Combination input/output Line 400

Technical data

The function of the input/output combination is adapted to transfer workpiece carriers from one section to another operating in parallel and running in the same direction.

This function is « mobile » due to the swivel 12x22 rail. Each input and output bed plate is equipped with a motorized roller to aid workpiece carriers through the curve.

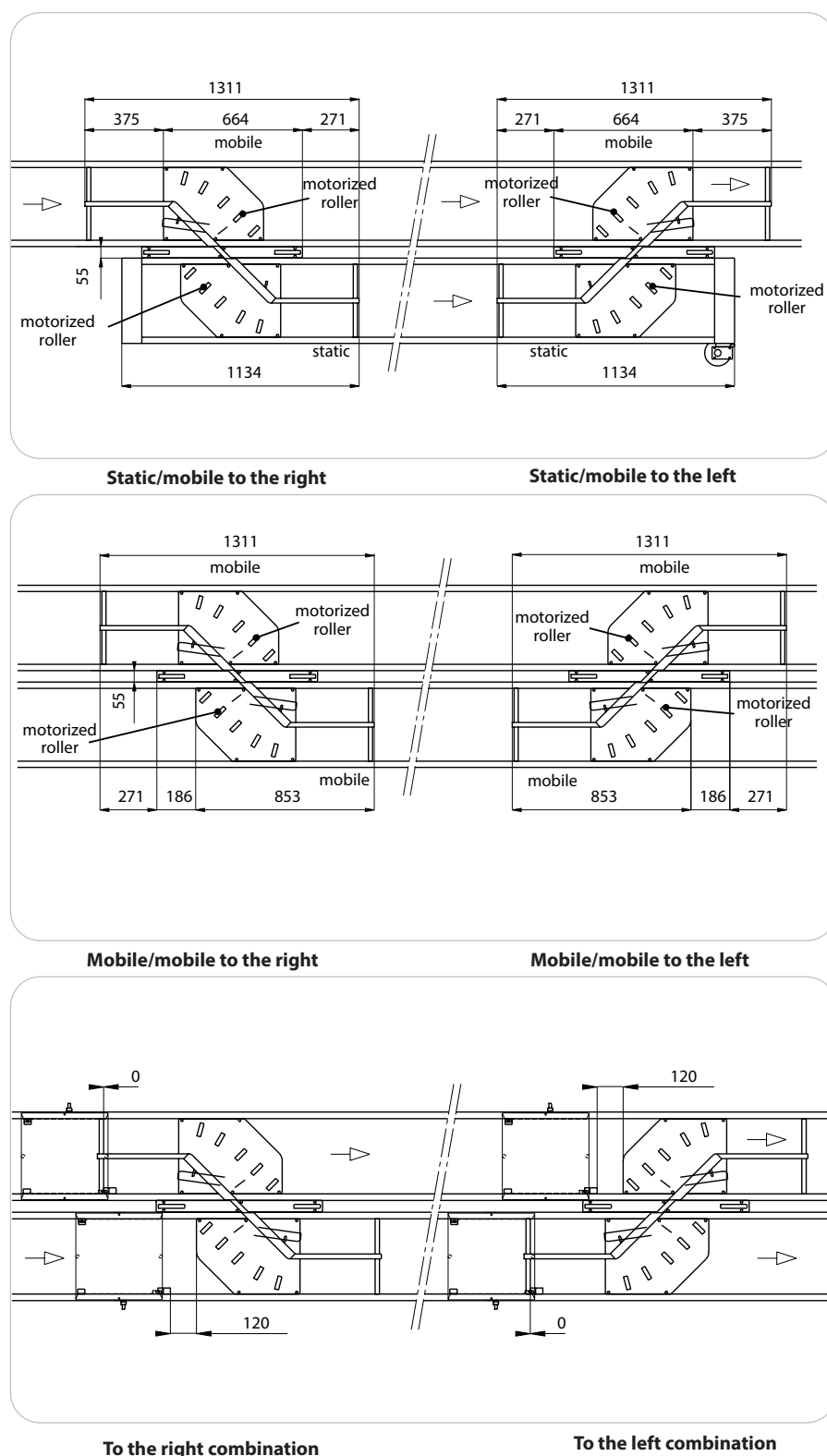
Mobile rail cylinder:

- ✗ Ø 15 mm, double acting
- ✗ lubricated or not, cleaned air, 5 to 6 bars
- ✗ connectors for Ø 4 mm pipe (included)
- ✗ M8 sensors under mobile rail bearing (not included)

Motorized roller motor:

- ✗ power: 6,3 W
- ✗ voltage: 220 V single-phase
- ✗ frequency: 50 Hz
- ✗ rated current: 73 mA

The minimum distance at which the workpiece carriers may be stopped in relationship to the combination is shown in the drawings below.



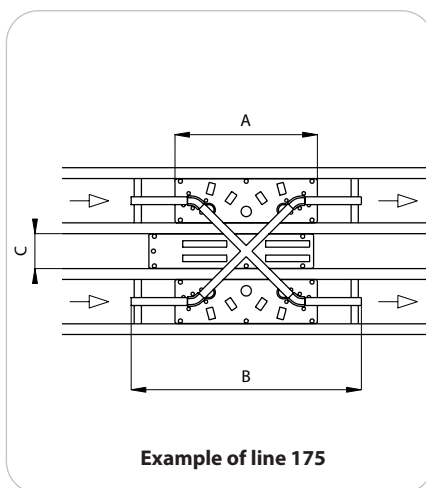
Designation / Dimensions	Order unit	Reference
Combination right input/output, static/mobile Line 400	1 kit	4114
Combination left input/output, static/mobile Line 400	1 kit	4115
Combination right Input/output, mobile/mobile Line 400	1 kit	4117
Combination left input/output, mobile/mobile Line 400	1 kit	4119

Cross combination

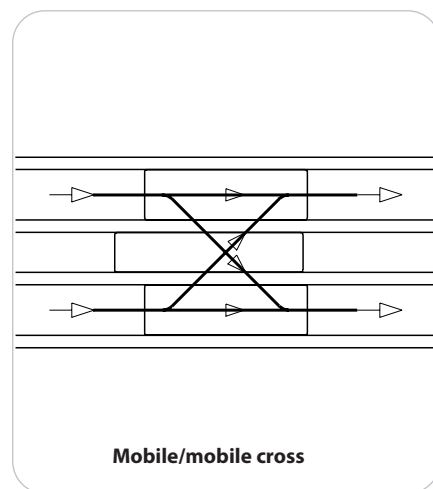
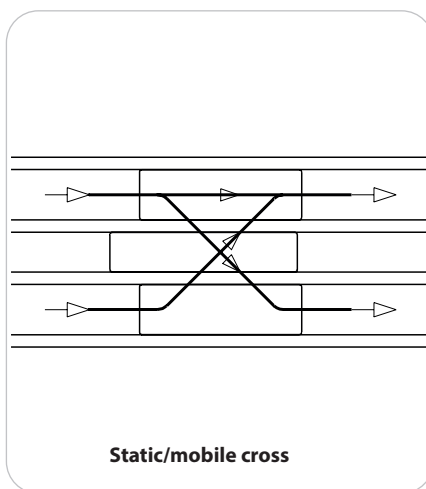
Technical data

The cross combination function may replace two following input/output combination in order to make the transfer system more compact.

This function is available on special request and may be chosen « static/mobile » or « mobile/mobile ».



	A (mm)	B (mm)	C (mm)
Line 175	395	639	97
Line 250	470	864	97
Line 325	545	1089	97
Line 400	578	1272	55

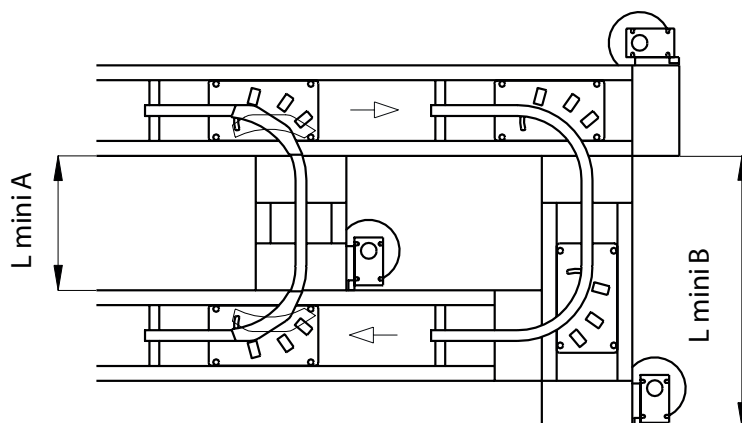


Designation / Dimensions	Order unit	Reference
Cross static/mobile Line 175	1 kit	4183
Cross static/mobile Line 250	1 kit	4181
Cross static/mobile Line 325	1 kit	4185
Cross static/mobile Line 400	1 kit	4187
Cross mobile/mobile Line 175	1 kit	4184
Cross mobile/mobile Line 250	1 kit	4182
Cross mobile/mobile Line 325	1 kit	4186
Cross mobile/mobile Line 400	1 kit	4188

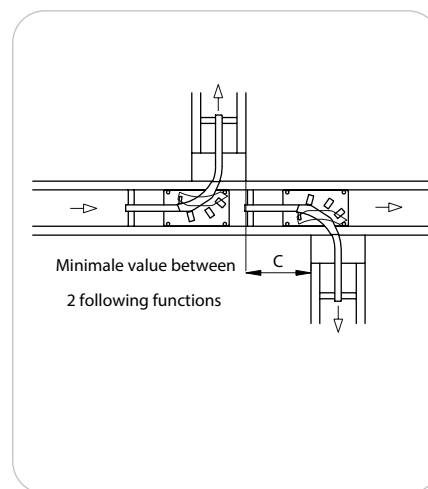
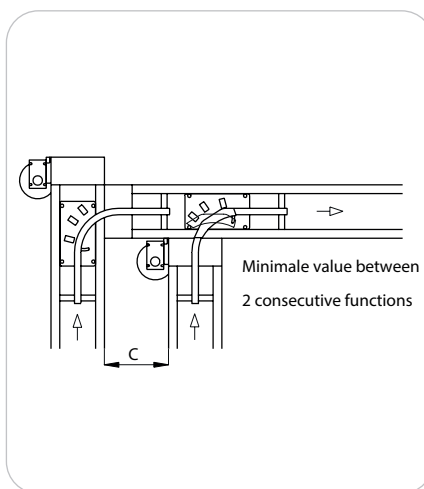
Linking of functions

Technical data

To chain up curves of 90° (static or mobile), it is compulsory to take care of minimal space as shown below.



	Length A (mini, mm)	Length B (mini, mm)
Line 100	330	507
Line 175	272	550
Line 250	347	700
Line 325	422	850
Line 400	447	950



	Cote C (mini, mm)
Line 175	225
Line 250	300
Line 325	375
Line 400	425

Data processing

Technical data

The mechanic data processing system provides accurate means of identification for the status of the products, components or pieces.

Two rockers 7046 can be inserted (on request) in the workpiece carrier pas, which allow four combinations.

A « write » block 6125, equipped with a micro-cylinder, can move a rocker. A « read » block 6124 allows its sensing (M8 sensor not included).

Blocks 6124 and 6125 can be included to provide multiple combinations.

Maximal available number of rockers for each workpiece carrier :

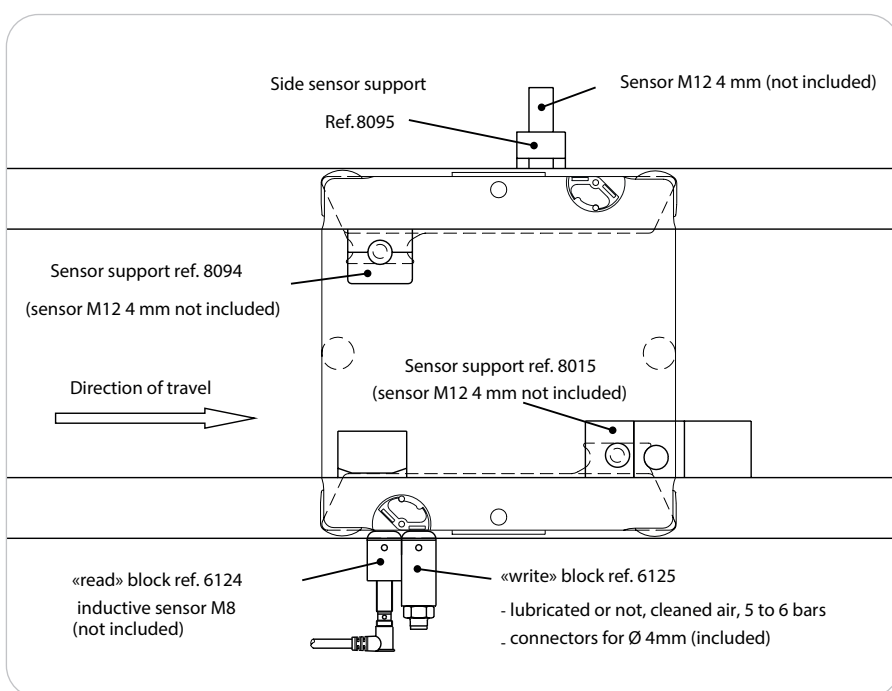
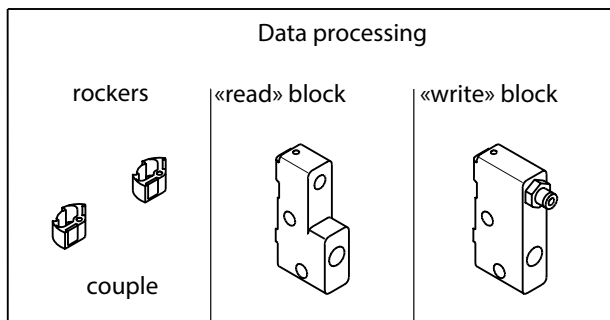
Line 100 : 2 couples

Line 175 : 2 couples

Line 250 : 4 couples

Line 325 : 6 couples

Line 400 : 8 couples



Example with a 175x175 WPC

Miscellaneous, maintenance, accessories

Technical data

Lubrication

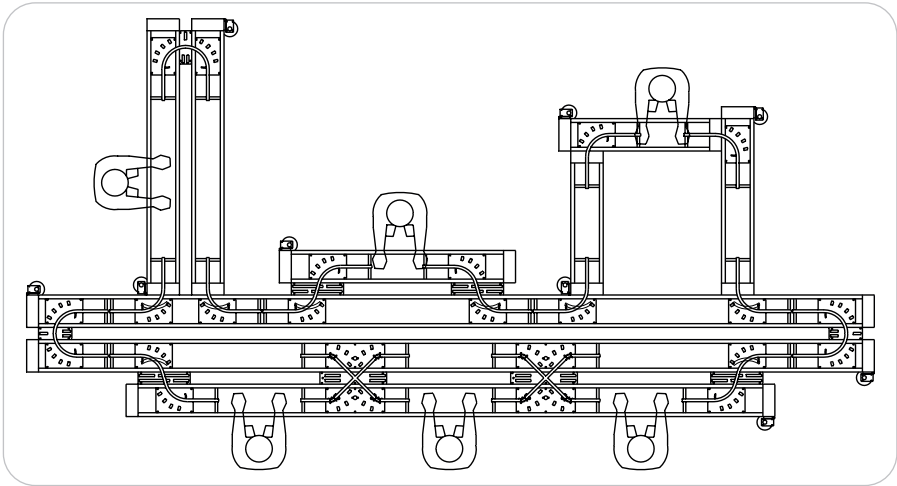
Lubricate every 5 000 h with special ELCOM spray lubricant, to be applied at the rear of each straight section.

Maintenance set

Change snapped-pads, ELCOM special spray lubricant, transmission protectors (cover caps), spare sprockets, chain tools.

Data base

ELCOM modularity allows miscellaneous configurations.
A data base of every function in this catalogue is available through AUTOCAD files TM and gives you the ability to design and choice a lot of implants. Encoded draws ensure too the reliability of the required bill of components.



Designation / Dimensions	Order unit	Reference
Maintenance case	1 kit	7123