

# POSITIONER

## TPS-60



Technical Offer Positioner TPS-60 Rev B

## 1 - USE

This positioner is designed for a manual welding of circular pieces with a maximum weight of 60kg. It allows the rotation with the possibility of overlap, but also with some internal cycles with the pneumatic torch support. It's specially adapted for MIG applications, but also for TIG thanks to the HF protection.

This product allows the positioning of pieces with various shapes, in order to make easy the operations thanks to the best position for the work line.

### **MAXIMUM LOAD**

Load in all positions :	60 kg
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### **TILTING**

Tilting torque :	5 m.kg
Manual tilting :	130°
Distance tilting axis / plate :	71 mm

### **ROTATION**

Maximum rotation torque :	5 m.kg
Rotation speed :	0.66 to 6.6 rpm
Plate diameter :	Ø 300mm with slots
Central hole :	6mm

### **SUPPLY**

Electrical supply :	230 V
Maximum absorbed intensity :	0.5 A
Power :	40 W
Frequency :	50 / 60 Hz
Earth connection :	500 A

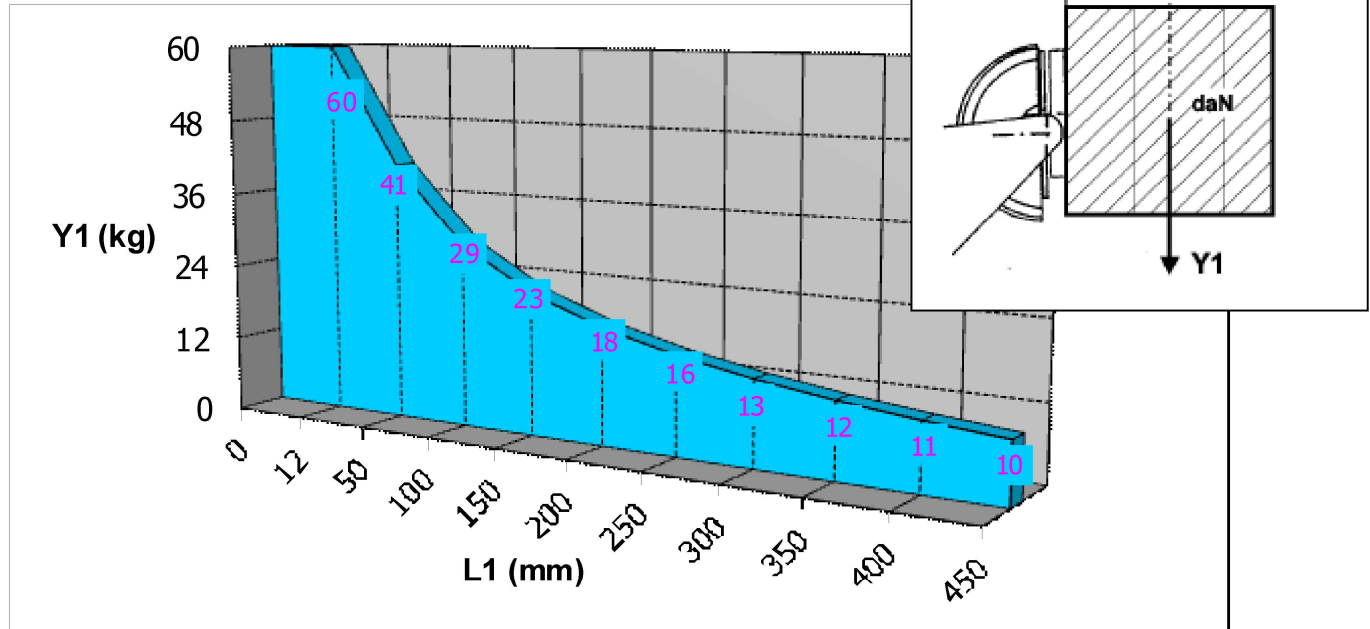
Plate height :	900mm
Control pedal :	YES
Total weight :	55 kg

## 2 – DIAGRAMS

### TILTING TORQUE

Maximum Load Y1 ( in kg ) =  $5 / ( 0.071 + ( L1 / 1000 ) )$

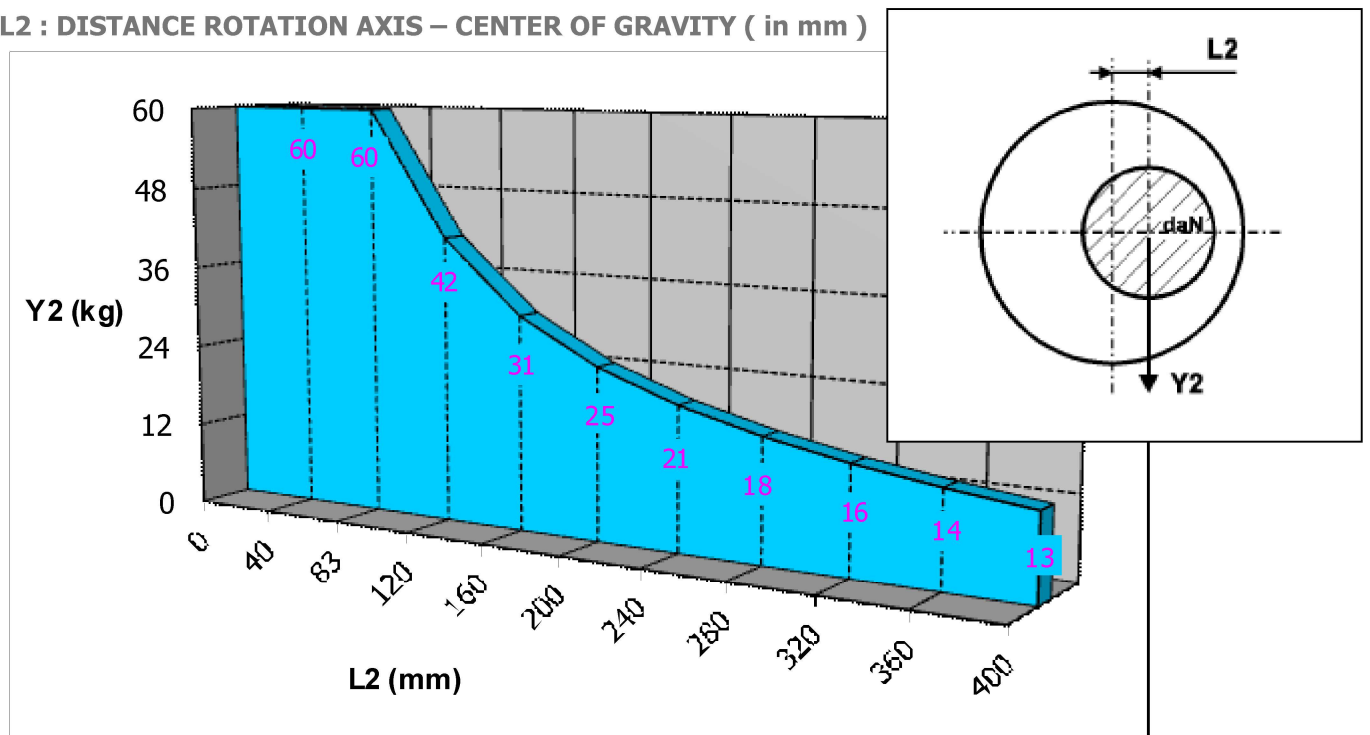
L1 : DISTANCE PLATE – CENTER OF GRAVITY ( in mm )



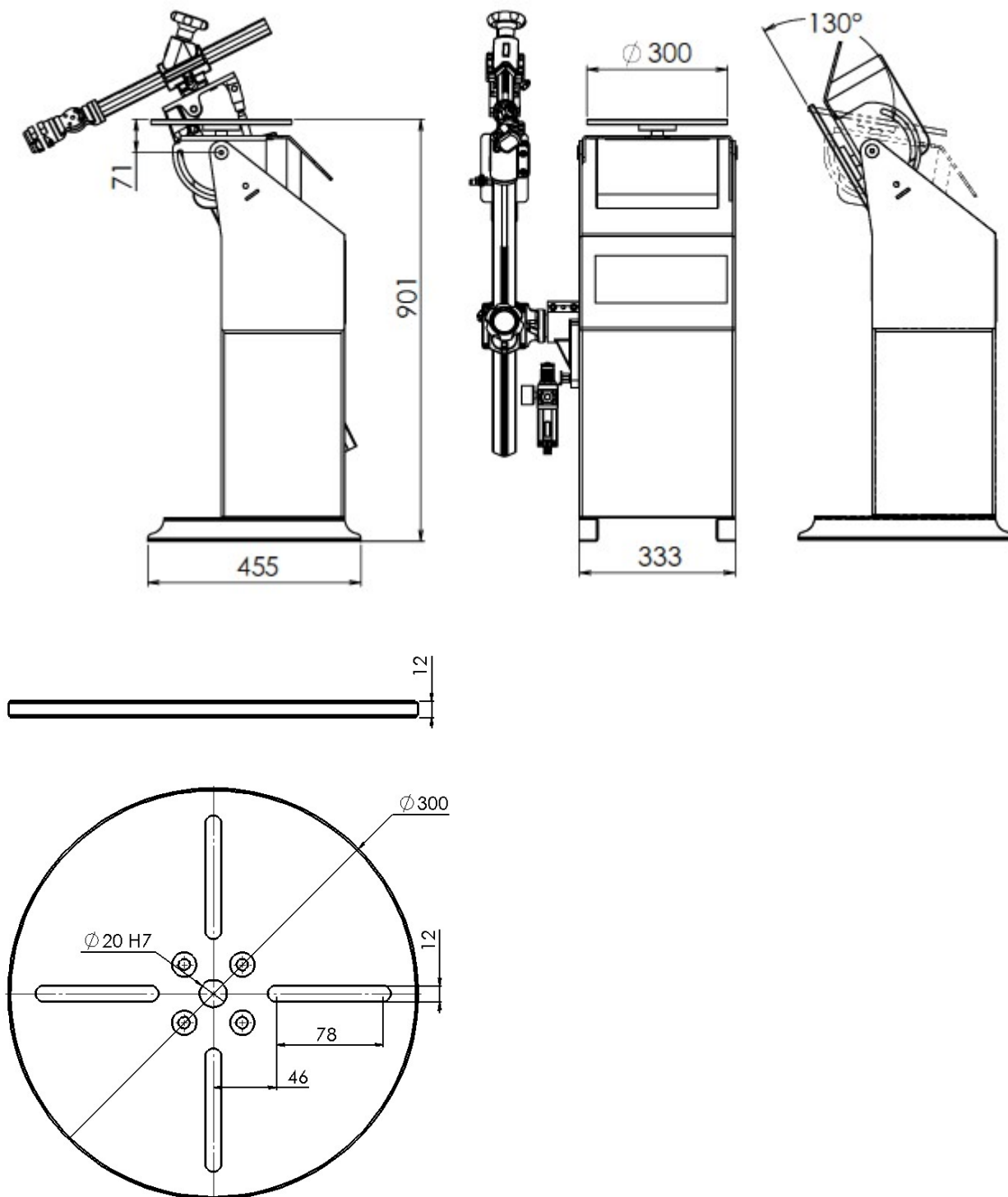
### ROTATION TORQUE

Maximum Load Y2 ( in kg ) =  $5 / ( L2 / 1000 )$

L2 : DISTANCE ROTATION AXIS – CENTER OF GRAVITY ( in mm )



### 3 – DIMENSIONAL CHARACTERISTICS



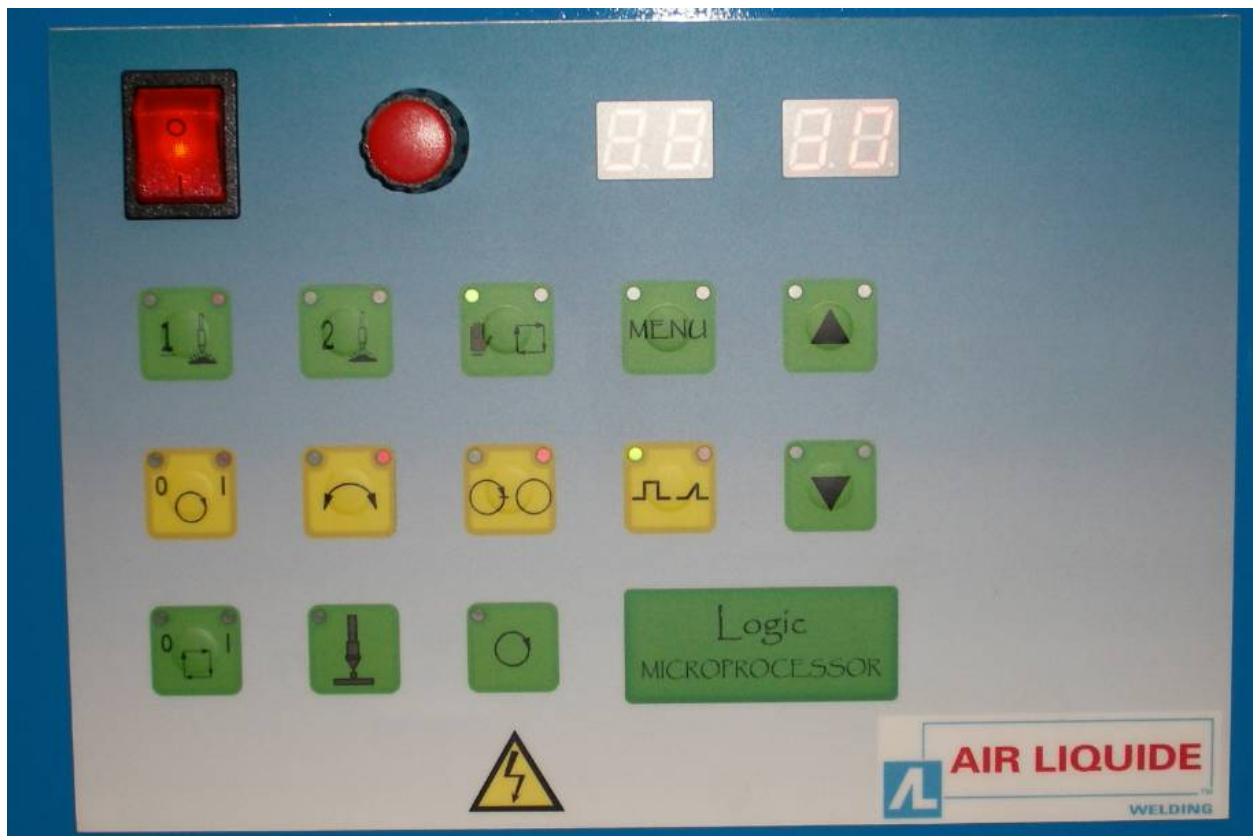
**Indicatives dimensions, no contractual data**

## 4 – FUNCTIONALITIES

### Functionalities :

- Rotation speed display
- Rotation direction right and left
- Welding with 1 or 2 torches
- Manual or automatic cycle
- 1 turn + overlap
- Start delay
- End welding management
- Selection mode 2T / 4T
- Torch movement control (if option)

### Control panel :



## 5 – OPTIONS

### **Torch Arm Support – BST :**

Possibility to have a pneumatic torch support (BST) – W000382334 for the MIG or TIG applications.

This torch support has to be mechanically mounted and electrically connected inside the positioner.



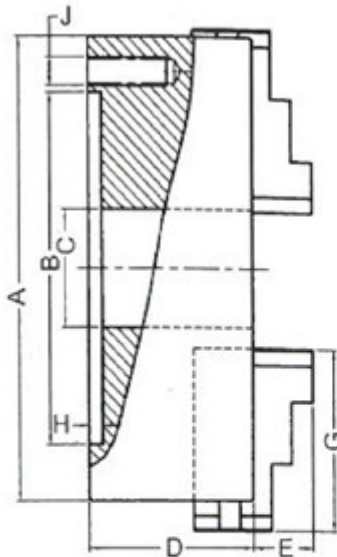


## Mandrel :

The positioner can be equipped with a mandrel. A fixation plate and the screws are supplied.

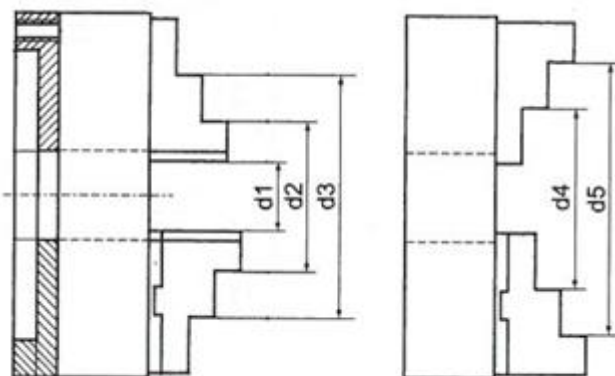
We have 2 possible mandrels diameter 125 and diameter 250mm.

## Dimensions :



A	B H7	C	D	E	G	H	J
125	95	30	56	20	51	5	M8
250	206	80	85	34	105	6	M12

Min and maxi diameter of tightening :



	D1	D2	D3	D4	D5
125	3-50	34-74	72-115	39-83	80-125
250	5-118	62-174	145-256	77-188	160-250

### **Potentiometric foot pedal :**

In order to control the rotation speed during the manual welding, it's possible to use a potentiometric foot pedal.

This pedal connected on the positioner, allows the control of the speed by the foot pressure.



### **Different rotation speed :**

It's possible to adapt the range of the rotation speed of the positioner. This change consists on the replacement of the reducer, which will have an influence on the rotation torque.

The available rotation speed :

- 0.18 to 1.8 rpm
- 0.3 to 3 rpm
- 0.5 to 5 rpm
- 0.9 to 9 rpm
- 1.3 to 13 rpm
- 1.8 to 18 rpm

Option mounted, only in factory

### **Intermittent welding :**

It's possible to have an intermittent welding. A cam with a limit switch allows the control of the welding equipment.

A selector allows the activation of this function.

The supplied cam has to be machined according the customer needs.



## 4 – PRICES AND DELIVERY

### PRICE EXW

### CODE PRICE

- **Positioner TPS60 - W000382332** **W000382332**
  - 1 display on the positioner
  - 1 Control pedal
  - 1 Supply harness length L =5m.
  - 1 technical documentation.
  - 1 Packaging
- **OPTION : BST – W000382334** **W000382334**
- **OPTION : Mandrel Diam 125mm + fixation plate** **M125-TPS60**
- **OPTION : Mandrel Diam 250mm + fixation plate** **M250-TPS60**
- **OPTION : Potentiometric foot pedal** **RHEOPEDAL**
- **OPTION on request :**
  - Rotation speed modification (in factory)
    - 0.18 to 1.8 rpm **SPEED1.8-TPS**
    - 0.3 to 3 rpm **SPEED3-TPS**
    - 0.5 to 5 rpm **SPEED5-TPS**
    - 0.9 to 9 rpm **SPEED9-TPS**
    - 1.3 to 13 rpm **SPEED13-TPS**
    - 1.8 to 18 rpm **SPEED18-TPS**
  - Intermittent welding (to mount by the customer) **DISCO-TPS60**

### DELIVERY

In stock (to be confirm at the order)