



KTS-550/850/1550/2550 CNC co-ordinate type tables with servomotor drive

The KTS-550/850/1550/2550 CNC SOYER co-ordinate type tables with servomotor drive are high-quality new developments incorporating a solid design with long-term quality and precision. They enable fully automatic welding of studs and pins from 3-10 mm in diameter and up to 40 mm in length. The working range in the X-axis and Y-axis comprises 490 mm - 485 mm (KTS-550 CNC) and 1300 mm - 2550 mm (KTS-2550 CNC). On request the co-ordinate type tables can also be delivered without casing.



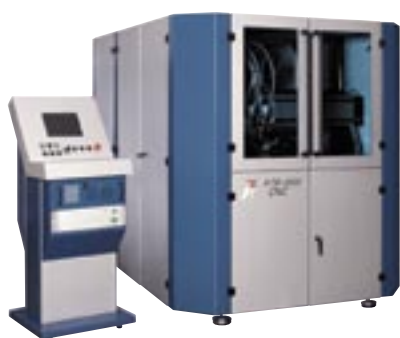
KTS-550 CNC co-ordinate type table

Clamping surface T-slot board:	940 mm x 725 mm
Working range X-axis:	490 mm
Working range Y-axis:	485 mm
Loading capacity of table:	100 kg
Headroom:	200 mm
Travel:	X = 500 mm, Y = 500 mm
Operating accuracy:	+/- 0.15 mm
Repeating accuracy:	+/- 0.05 mm
Positioning speed:	24 m/min max.
Dimensions:	1 280 mm x 1 880 mm x 1 400 mm (w x h x d, without control system)



KTS-850 CNC co-ordinate type table

Clamping surface T-slot board:	1 240 mm x 1 000 mm
Working range X-axis:	800 mm without casing (750 mm including casing)
Working range Y-axis:	750 mm
Loading capacity of table:	100 kg
Headroom:	200 mm
Travel:	X = 800 mm, Y = 750 mm
Operating accuracy:	+/- 0.15 mm
Repeating accuracy:	+/- 0.05 mm
Positioning speed:	22 m/min max.
Dimensions:	1 480 mm x 2 050 mm x 1 675 mm (w x h x d, without control system)



KTS-1550 CNC co-ordinate type table

Clamping surface T-slot board:	2 080 mm x 1 300 mm
Working range X-axis:	1 100 mm without casing (1 050 mm including casing)
Working range Y-axis:	1 500 mm
Loading capacity of table:	100 kg
Headroom:	200 mm
Travel:	X = 1 100 mm, Y = 1 530 mm
Operating accuracy:	+/- 0.15 mm
Repeating accuracy:	+/- 0.05 mm
Positioning speed:	20 m/min max.
Dimensions:	1 780 mm x 2 050 mm x 2 575 mm (w x h x d, without control system)



KTS-2550 CNC co-ordinate type table

Clamping surface T-slot board:	3 100 mm x 1 600 mm
Working range X-axis:	1 400 mm without casing (1 300 mm including casing)
Working range Y-axis:	2 550 mm
Loading capacity of table:	100 kg
Headroom:	200 mm
Travel:	X = 1 400 mm, Y = 2 550 mm
Operating accuracy:	+/- 0.2 mm
Repeating accuracy:	+/- 0.05 mm
Positioning speed:	18 m/min max.
Dimensions:	1 900 mm x 2 050 mm x 3 200 mm (w x h x d, without control system)

KTS-550/850/1550/2550 CNC co-ordinate-type tables with servomotor drive module

KTS-2550 CNC coordinate-drive tables with outstanding quality and performance features open new dimensions in the field of stud welding technology. The X and Y motional axes are driven by high-quality, precise and backlash-free recirculating ballscrews. The linear rail guides have a very high loading capacity in all directions, are of a rigid, compact design and are free from backlash. The Z-axes are equipped with a pneumatic slide and a precision crank handle slide. Servomotor-driven Z-axes are optionally available. It is optionally possible to connect several welding heads or machining components such as milling heads or drilling heads. A well-thought-out concept enables a simple operation of the machine's control. Previous knowledge of program languages is not necessary.

Development and production fulfil all prescribed safety targets such as

- the latest safety and accident prevention regulations (Act on the Safety of Technical Working Equipment)
- European regulations (EU Directives on Machinery)
- electromagnetic compatibility (EMC Act)
- GS/CE emblem for verified safety provided the machine is supplied with the optional full casing in accordance with EU Directive on Machinery 98/37/EC being installed in our factory.

Standard equipment:

1 BMS-10N energy source (other stud welders such as BMS-10P, BMK-10LC etc. are optionally available)



1 SK-5AP welding head with digital display



1 UVR-300 universal feeder for standard studs with flange

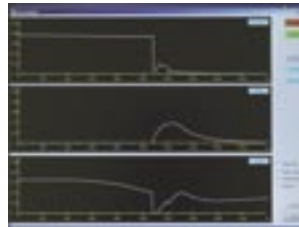


CNC-Steuerung MA-400S mit grafischem Programmiersystem:

The MA-400 S machine control unit with graphical programming system allows the entry of all welding parameters for controlling the CNC coordinate-type tables via a data terminal. This simplifies the whole welding procedure making individual operation of the stud welders unnecessary.



The program software already in use is an in-house SOYER development and has proved very successful in practical application. The software offers numerous outstanding performance features for CNC controlled coordinate-type tables with servomotor drive and its current version has been considerably improved with regard to quality assurance measures.



All important measurable variables such as welding current, welding voltage, travel, time and speed are displayed, monitored and evaluated on the monitor of the machine control unit. For the first time it has become possible to record important mechanical motional sequences such as travel path in mm, drop time in milli-seconds and positioning speed in mm/sec. and to integrate these into the total evaluation.

The „mechanical sluggishness“ of welding heads can be immediately recognized, thus ruling out faulty welds involving high reworking costs from the outset.

Performance characteristics:

- ▶ Programming according to DIN 66025
- ▶ Manual and automatic operation
- ▶ Manual entry of the positions
- ▶ Selectable park position
- ▶ Free selectable change position (welding head change)
- ▶ Real time simulation with graphical display
- ▶ Cycle times are changeable during program flow
- ▶ Positioning speed is selectable during program flow
- ▶ Zero point correction for each welding head
- ▶ Automatic follow-up impulse in case of missing studs
- ▶ Shiftable graphic and numeric position display
- ▶ Remote maintenance and remote diagnosis via ISDN/modem (option)
- ▶ Web cam for optical remote diagnosis via ISDN/modem (option)
- ▶ Programming in a matter of seconds through importing DXF files

SOYER top-of-the-range products awarded the following prizes for



Production



Quality



Technology



Design



Quality Management



International Approval



Safety



EC Conformity