

Electro-Permanent-Magnet-Clamping-Plate

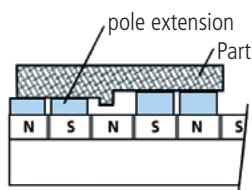


The electro permanent magnet clamping plate, type 1110V, with increased holding force is particularly suited for the milling of thick workpieces. The integrated and reinforced permanent magnetic clamping system generates a high depth effect to bridge air gaps in case of workpieces with uneven and rough surfaces.

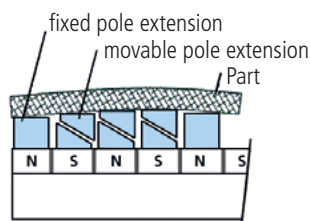
The main fields of application of this magnetic clamping technology are heavy machining, mould construction and HSC machining. The integration in changing

pallets, multiple clamping cubes and zero-point clamping systems is possible without any problems.

The permanent magnet clamping system is magnetized by using a current pulse. During the machining process, no further current is supplied, so that no heat is generated if the magnet is activated. This eliminates any inaccuracies resulting from temperature deviations.



Fixed pole extensions, e.g. for bridging of part contours.



The movable pole extensions adapt to the shape of the part and are fixed magnetically.

Scope of delivery:

- lowerable stop bar on side
- transport holes on the sides
- fixed mounted junction box with 3.0 m connecting cable
- Through-holes with clamping jaws for fixing on the machine table
- Tapped holes in each pole for fixing of pole shoes

Options:

- movable pole extensions for uneven part clamping surface with fixed three-point support
- fixed pole extensions for release of parts and integration of special designs
- Electrical connection via plug-type connector

Design:

- Protection class: IP 65
- Magnet operating time: 100 %

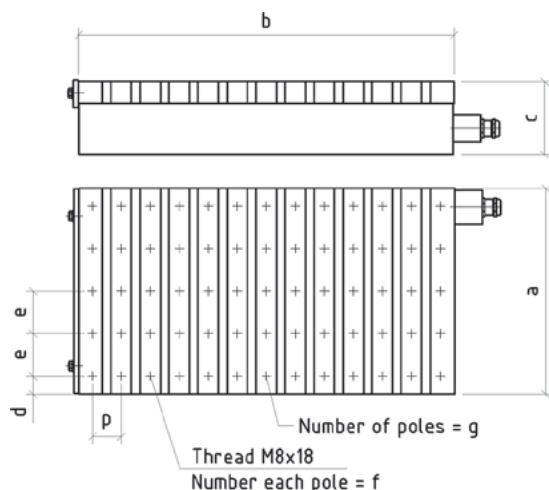
Electrical connection via:

Electronic type 754, 755 and 756 pole-reversal control units.

These devices, designed especially for controlling clamping magnets, function to facilitate the power supply and simultaneously as demagnetisation devices. A microprocessor controls and monitors all functions and offers optimal switching comfort with numerous control and monitoring functions. The adhesive force is adjustable in up to 16 stages. In addition, these pole-reversal control units also allow additional configuration of parameters and optimised settings. All device types offer particularly impressive shifting dynamics.

For individual details, please see brochures 754, 755 and 756.

The movable pole extensions with three support points are used to clamp uneven parts. When applying a part and switching on the magnet, the pole extensions adapt to the uneven clamping surface and thus optimize the magnetic flow.



Electro-Permanent-Magnet-Clamping-Plates

Type 1110V

with continuous pole spacing

Characteristics:

Highest level of precision -
Activated magnet remains cold.

Highest level of safety -
Holding force even after power failure.

Energy-conscious -
Power used only for short pulses.

For highest demands, in particular for the use on milling machines, our magnets of type 1110V are used.

Dimensions and technical data:

Type	Width a [mm]	Length b [mm]	Height c [mm]	d [mm]	e [mm]	f [mm]	g [mm]	Pole space p [mm]	Weight [kg]	Connection value Pole-reversal control unit [V/A]
1110V-30/55-61	302	552	107	26	62,5	5	9	61	125	360/30
1110V-30/78-61	302	782	107	26	62,5	5	13	61	177	360/30
1110V-30/102-61	302	1022	107	26	62,5	5	17	61	231	360/60
1110V-30/127-61	302	1272	107	26	62,5	5	21	61	288	360/60
1110V-30/151-61	302	1512	107	26	62,5	5	25	61	342	360/60
1110V-40/55-61	402	552	107	36	55	7	9	61	166	360/30
1110V-40/78-61	402	782	107	36	55	7	13	61	235	360/60
1110V-40/102-61	402	1022	107	36	55	7	17	61	308	360/60
1110V-40/127-61	402	1272	107	36	55	7	21	61	383	360/60x2
1110V-40/151-61	402	1512	107	36	55	7	25	61	455	360/60x2
1110V-50/78-61	502	782	107	31	55	9	13	61	294	360/60
1110V-50/102-61	502	1022	107	31	55	9	17	61	384	360/60x2
1110V-50/151-61	502	1512	107	31	55	9	25	61	569	360/60x2
1110V-50/200-61	502	2002	107	31	55	9	33	61	753	360/60x3 *
1110V-60/78-61	602	782	107	31	60	10	13	61	353	360/60
1110V-60/102-61	602	1022	107	31	60	10	17	61	461	360/60x2
1110V-60/151-61	602	1512	107	31	60	10	25	61	682	360/60x2
1110V-60/200-61	602	2002	107	31	60	10	33	61	903	360/60x4 *
1110V-70/102-61	702	1022	107	32	58	12	17	61	537	360/60x2
1110V-70/151-61	702	1512	107	32	58	12	25	61	795	360/60x3 *
1110V-70/200-61	702	2002	107	32	58	12	33	61	1053	360/60x4 *
1110V-80/102-61	802	1022	107	37	56	14	17	61	614	360/60x2
1110V-80/151-61	802	1512	107	37	56	14	25	61	908	360/60x3 *
1110V-80/200-61	802	2002	107	37	56	14	33	61	1203	360/60x4 *

other dimensions possible upon request

* from connected loads of EP360/60x3 and EP360/60x4, two cable inputs are provided



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