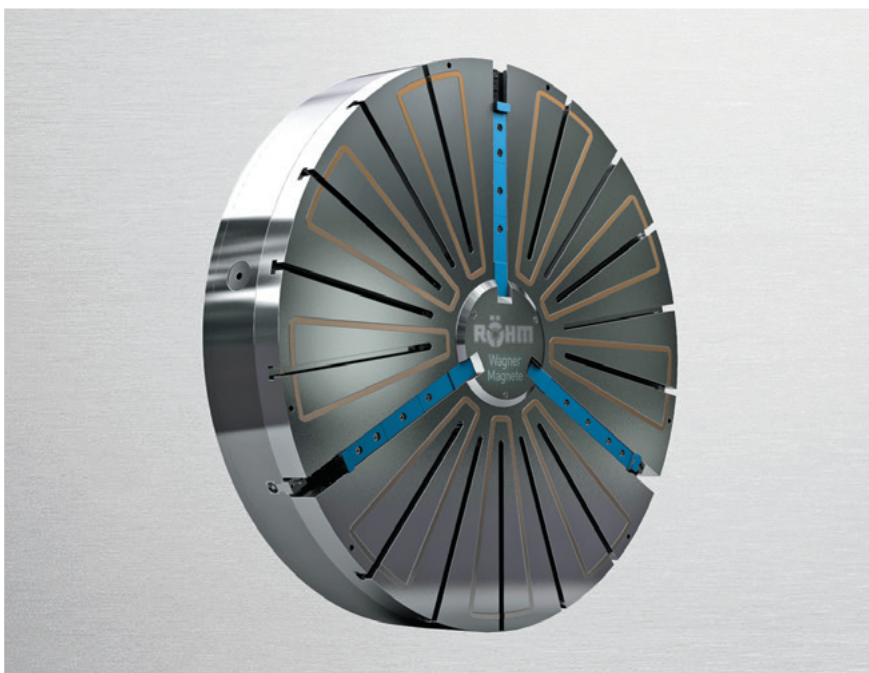


Hybrid-Clamping-Chuck



The Hybrid-Clamping-Chuck, type 1210H a joint product of company Röhme and Wagner company, combines the best of the two companies. Consisting of 3 or 6 clamping chucks and one electro permanent magnet clamping chuck the device efficiently and flexibly complies with today's requirements for quick and economic clamping devices.

Bearing rings and other easily deformable, ring shaped parts are safely centered and clamped in a matter of seconds. The magnetic holding force can easily be adjusted in 16 steps to prevent deformations of the part. The clampings can be removed after the centering to enable 3-side machining.

Advantages:

- individually adjustable thanks to the modular design
- Set-up times reduced by up to 80% thanks to accurate clamping in seconds
- machine down times reduced to a minimum
- 3-side machining for turned parts and workpieces
- 16 individually adjustable holding force levels
- uniform and distortion-free clamping force
- combined magnet and center chucks clamping force possible
- high process reliability for efficient series production
- rapid return on investment
- available in diameter sizes from 200 to 5000 mm

Holding force control:

If necessary, the adhesive force can be controlled via pole reversal control unit using a coding switch. This prevents deforming of uneven workpieces.

Versions:

- T-slots in the pole plate for screwing on pole shoes or stops
- Threaded holes in the pole plate for fastening pole strips or add-on pole plates
- Pluggable socket on the outer surface
- Power transmission via flat or flanged slip rings
- Mechanical centering function on the outer surface or power-operated in the centre

Design:

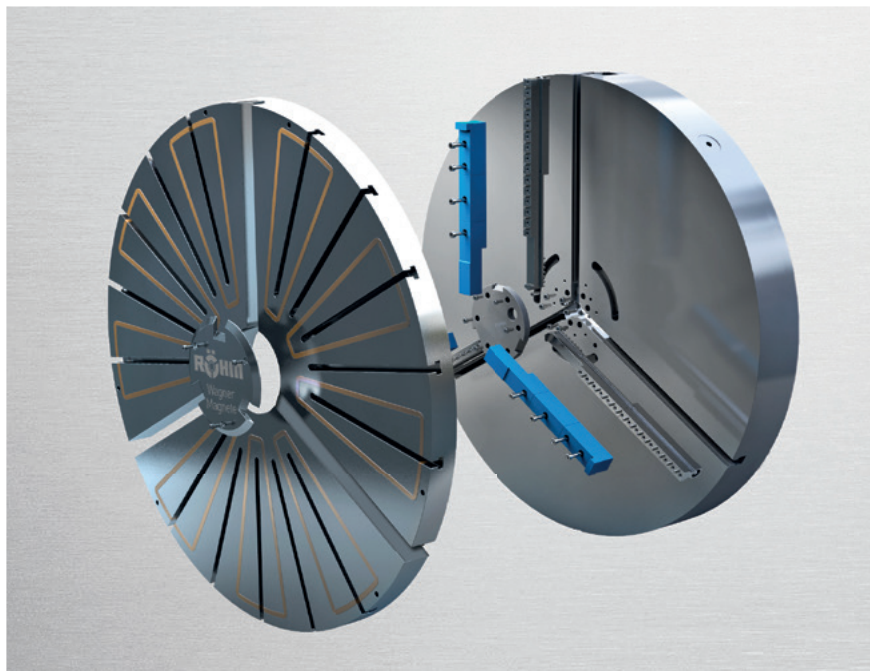
- Protection class IP 67 (except electrical connection)
- Magnet operating time: 100 %

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.



Hybrid-Clamping-Chuck Type 1210H

The perfect combination
of magnetic and
mechanic clamping forces

Dimensions and technical data:

Type	Diameter [mm]	No. of pole pairs [mm]	Overall height [mm]	magnetic zone [mm]	Weight [kg]	Connection value pole-reversal control unit [V/A]*
1210H-20	200**	3	150	20 - 170	33	210/10
1210H-25	250**	3	150	20 - 220	51	210/30
1210H-30	300**	6	150	70 - 270	75	210/30
1210H-40	400**	6	150	70 - 360	132	360/30
1210H-50	500	6	120	220 - 440	165	360/30
1210H-60	600	9	120	220 - 540	240	360/30
1210H-70	700	9	120	220 - 640	324	360/30
1210H-80	800	9	135	220 - 740	475	360/30
1210H-90	900	9	135	220 - 840	594	360/60
1210H-100	1000	12	145	280 - 940	790	360/60
1210H-110	1100	12	145	280 - 1040	965	360/60
1210H-120	1200	12	170	300 - 1140	1345	360/60
1210H-130	1300	12	170	350 - 1240	1575	360/60x2
1210H-140	1400	12	170	350 - 1340	1825	360/60x2
1210H-150	1500	15	170	400 - 1440	2100	360/60x2
1210H-160	1600	15	170	400 - 1540	2390	360/60x2
1210H-180	1800	15	180	600 - 1740	3200	360/60x2
1210H-200	2000	15	180	600 - 1940	3950	360/60x2

Other dimensions and number of pole pairs are available upon request

* 210 V D.C. variants are also available with 360 V D.C. nominal voltage

** Outer diameter of magnet chuck plus 60 mm with overlapping jaws



wagner
magnete

Wagner Magnete GmbH & Co. KG
Obere Straße 15
D-87751 Heimertingen
Phone: (08335) 980-0
Fax: (08335) 980-270
www.wagner-magnete.de
e-mail: info@wagner-magnete.de

**Technology
Full of
Attraction**