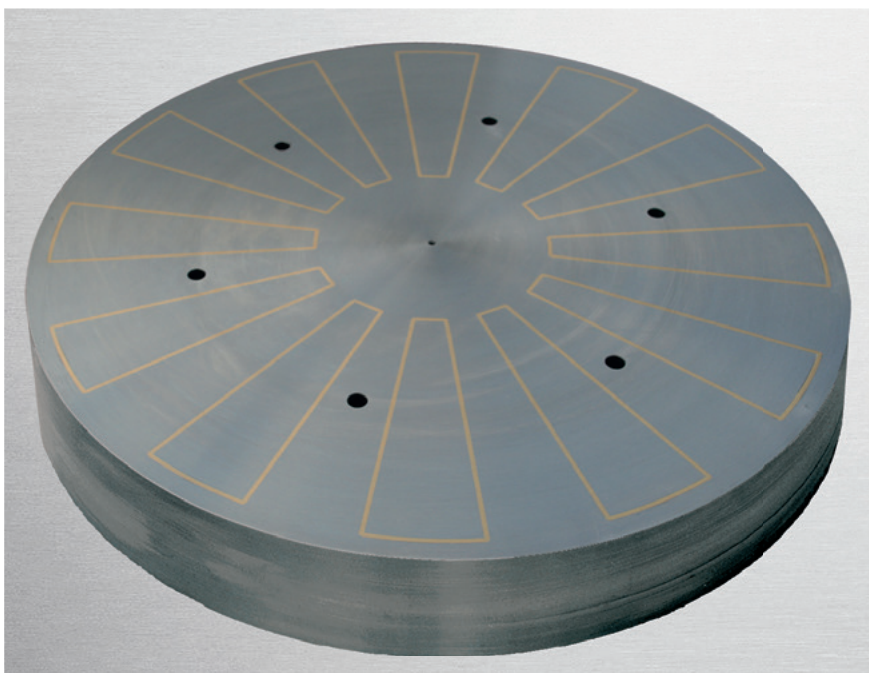


Electro-Permanent-Magnet-Clamping-Chuck



Electro-Permanent-Magnet-Clamping-Chucks, Type 1210, with radial pole spacing if several workpieces are clamped asymmetrically, they must cover at least two poles.

Electro permanent magnet clamping chucks are mainly used on turntables and circular grinding machines. Careful dimensioning of the magnetic system and practical pole spacings ensure clamping of the workpieces at even holding force.

If several workpieces are clamped asymmetrically, they must cover at least two poles.

By energy-conscious magnetizing of the clamping chuck through a definite power pulse highest level of precision is achieved. Then the magnet is disconnected from power and therefore particularly suited for machining tasks within the μm -range.

The big advantage of radial pole spacing is that the workpieces can be separated using pole shoes. This separation is used as run-out range for the grinding wheel in the inside and outside area. Thus the workpiece can be machined on all three sides with optimal form and position tolerances using only one chucking.

The pole shoes can be shifted in the T-slots and thus adapted to the existing workpiece diameter.

Holding force control:

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

Versions:

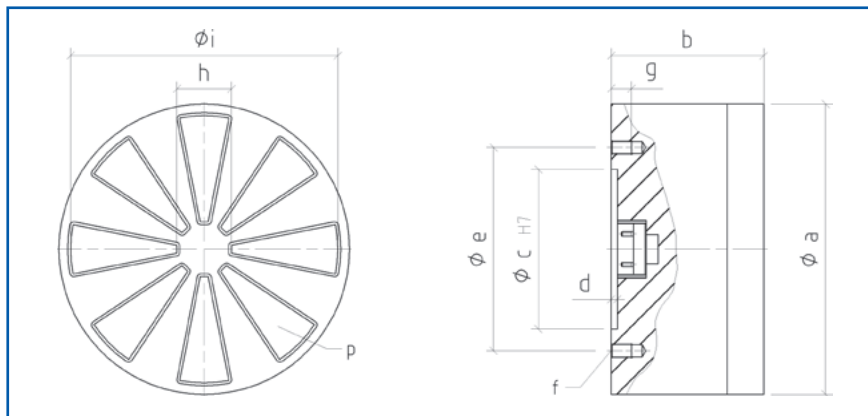
- T-slots in the pole plate for screwing on pole shoes or stops
- Threaded holes in the pole plate for fastening pole strips or top plates
- Central locating hole in the pole surface for centering flanges
- Pluggable socket on the outer surface
- Power transmission via flat or flanged slip rings

Design:

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

Electrical connection via:

Electronic 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.



Electro-Permanent-Magnet-Clamping-Chuck

Type 1210

with radial 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.

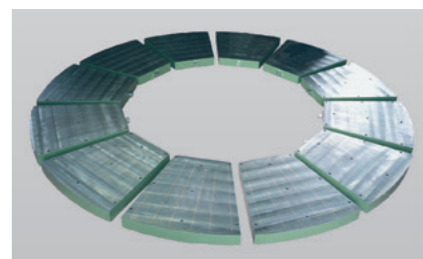
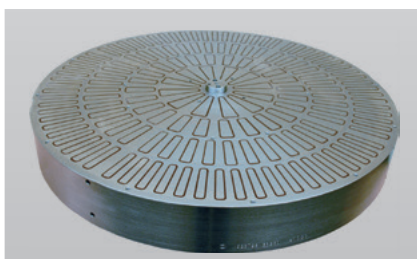
Dimensions and technical data:

Type	p No. of pole pairs	a [mm]	b [mm]	c [mm]	d [mm]	e [mm]	f Thread	g [mm]	h non-magn. zone [mm]	i [mm]	Weight [kg]	Connection value Pole-reversal control unit [V/A]*
1210-20	6	200	100	110	3	140	4xM10	14	20	178	22	210/10
1210-30	8	300	100	160	3	190	4xM12	16	58	270	50	210/30
1210-40	8	400	110	210	4	250	6xM12	16	80	350	97	360/30
1210-50	8	500	110	280	4	320	6xM12	16	113	452	151	360/30
1210-60	8	600	120	350	4	390	6xM16	18	113	552	238	360/30
1210-70	8	700	127	400	4	450	6xM16	18	113	648	342	360/30
1210-80	12	800	132	450	4	500	6xM16	18	216	751	465	360/30
1210-90	12	900	137	500	4	560	8xM16	18	216	848	610	360/60
1210-100	12	1000	137	550	4	620	8xM16	18	216	944	753	360/60
1210-110	12	1100	147				Backside as agreed		300	1050	830	360/60
1210-120	12	1200	147				Backside as agreed		300	1150	990	360/60
1210-125	14	1250	147				Backside as agreed		300	1250	1390	360/60
1210-140	16	1400	157				Backside as agreed		300	1350	1610	360/60x2
1210-150	16	1500	152				Backside as agreed		400	1450	1850	360/60x2
1210-160	16	1600	152				Backside as agreed		500	1550	2110	360/60x2
1210-180	16	1800	162				Backside as agreed		500	1750	3020	360/60x2
1210-200	16	2000	162				Backside as agreed		500	1950	3730	360/60x2
1210-230	16	2300	187				Backside as agreed		500	2150	4780	360/60x2

Other dimensions and number of pole pairs are available upon request

Special Solutions:

- magnet clamping chuck with separately switchable clamping area
- magnet clamping chuck in segment design



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**