

## Vibration Welding Machine "M-824 L": Technical Data

<b>Mechanical</b>		
Overall Dimensions (H x W x D, external Hydraulics not included)	2,900 x 3,080 x 1,810	mm
Dimensions with open Doors (H x W x D)	2,900 x 3,880 x 2,610	mm
Upper Fixture (oscillating Head, W x D)	920 x 540	mm
Lower Fixture (stroking Table, W x D x Level above Floor)	1,500 x 600 x 600	mm
Hole in the Table (W x D)	(none)	mm
Clearance between the Column Supports	1,530	mm
Clearance between the Table and the Head	1,230 / 1,280 / .. (+50) .. / 1,630	mm
Table Stroke	0 - 900	mm
Min. Tooling Height	340 / 390 / .. (+50) .. / 740	mm
Weight	approx. 7,500	kg
<b>Oscillating Head</b>		
Type, Kinematics	100 kg (PPL), linear Vibration	
Frequency (nominal, depending on the Tooling Weight)	approx. 100	Hz
Amplitude	0.9 - 2.0	mm
Tooling Weight Range	65 - 135	kg
Performance (max. Weld Area, depending on the Material)	500	cm <sup>2</sup>
Positioning Accuracy	+/- 0.05	mm
Hole in the Driverbox (W x D)	(none)	mm
<b>Drive System</b>		
Type	VCB 460-060	
Power Consumption	30	kW
<b>Machine Controls</b>		
PLC Type (standard, alternative: see Spec.)	Siemens S7-300	
OP Type (standard, alternative: see Spec.)	Lauer PCS 950Q.M	
Table Position Control	full Stroke	
Penetration Control	closed Loop	
<b>Hydraulics</b>		
Type (standard, alternative: see Spec.)	Vickers	
Overall Dimensions (H x W x D, Oil Pan included)	1,120 x 680 x 1,050	mm
Clamp Force	max. 25,000	N
Oil (required Capacity for Setup, Specification)	100 l, 32c St/40°C (H-LP32)	
Stroke Speed of the Table	max. 250	mm/s
<b>Pneumatics</b>		
Type (standard, alternative: see Spec.)	Festo	
Input Air Pressure	6 - 10	bar
Functions (standard, alternative: see Spec.)	4	
<b>Sound Enclosure</b>		
Type (standard, alternative: see Spec.)	normal	
Noise Emission (DIN 45635)	< 80	dBA
Front Door (H x W x Level above Floor)	1,200 x 1,700 x 800	mm
Maintenance Door (double Door, inside Opening, H x W)	1,940 x 1,550	mm
Color (standard, alternative: see Spec.)	RAL 7035 (light grey)	
<b>Connections (standard, alternative: see Spec.)</b>		
Pneumatical	1/2"	
Electrical	3 x 400 V, N, PE, 50 Hz	
Power Consumption	32	kVA
Max. Current (main Fuse)	43 (50)	A
Main Plug	63 A, CEE, 5 x 16 mm <sup>2</sup>	
Data Interface	serial Printer Port	
<b>Ambient Conditions</b>		
Temperature	+15 - +40	°C
Humidity (no Condensation)	30 - 95	%
Altitude (above Sea Level)	1,000	m