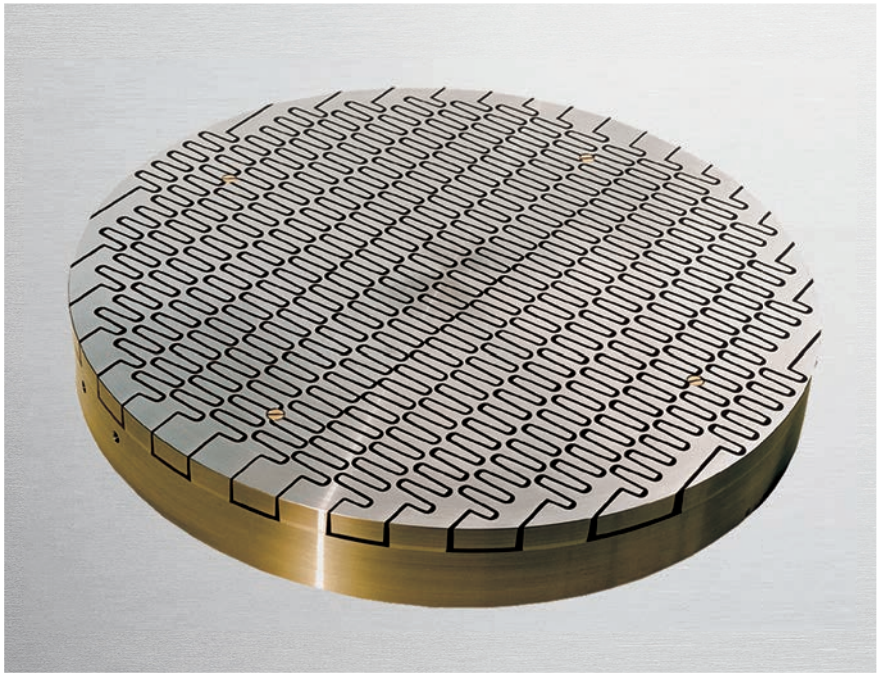
wagner magnete

1250

Electro-Permanent-Magnet-Clamping-Chuck



Electro-Permanent-Magnet-Clamping-Chuck Type 1250 have a high adhesive force due to the pendular pole pitch.

Alternating north and south poles are arranged along the complete clamping range. Due to this design there is no non-magnetic zone in the center of the magnet clamping chuck. This ensures an uniform holding force over the complete clamping surface.

This pole spacing is particularly suited for clamping mass-produced parts or thin workpieces like saw blades.The object can be centered using the locating hole in the center of the clamping surface.

Depending on the workpiece used you can select pole spacings of 11, 14, 18 and 22 mm.The pole plate can be reworked until the wear limit is reached, then it has to be replaced.

Electro permanent magnet clamping chucks are magnetized and demagnetized through power pulses. During the machining process any power supply is disconnected. This ensures that no heat is generated when the magnet is activated. This also prevents inaccuracies resulting from variations in temperature. The magnet clamping chuck provides all the preconditions for precision, operational safety and ease of use.

By default, power is fed via machine spindle with integrated slip ring and carbon brush holder.

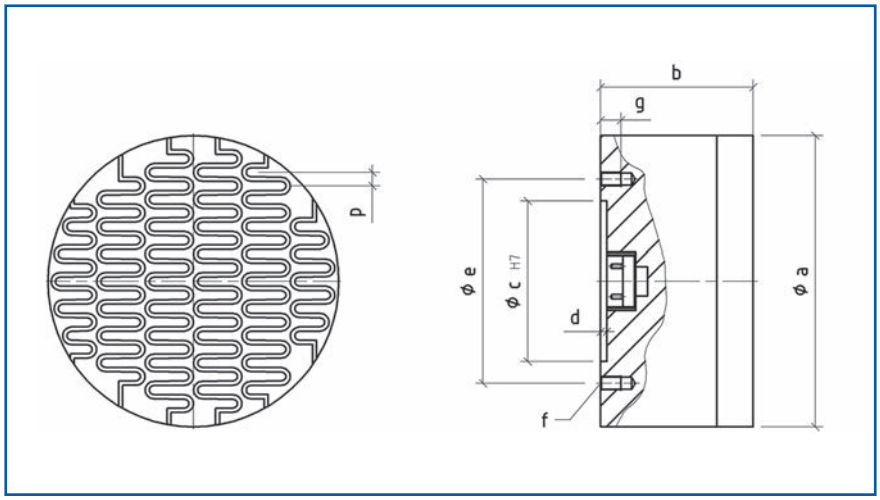
With its optional plug-in unit on the outer surface the magnet clamping chuck can be used variably on pallet changers. Any changeover between different electro-permanent-magnet-clamping-chucks or mechanical clamping systems can be done very quickly and flexibly.

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 1250
with sinusoidal 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 pole space [mm]	a [mm]	b [mm]	c [mm]	d [mm]	e [mm]	f Thread	g [mm]	Weight [kg]	Connection value Pole-reversal control unit [V/A]*
1250-30	11-14-18	300	90	160	3	190	4xM12	16	45	210/10
1250-40	11-14-18	400	90	210	4	250	6xM12	16	79	210/10
1250-50	11-14-18	500	90	280	4	320	6xM12	16	124	210/10
1250-60	11-14-18	600	100	350	4	390	6xM16	18	198	360/30
1250-70	11-14-18	700	100	400	4	450	6xM16	18	269	360/30
1250-80	14-18-25	800	100	450	4	500	6xM16	18	352	360/30
1250-90	14-18-25	900	110	500	4	560	6xM16	18	490	360/30
1250-100	14-18-25	1000	110	550	4	620	6xM16	18	605	360/30
1250-110	14-18-25	1100	110	Backside as agreed					732	360/30
1250-120	14-18-25	1200	110	Backside as agreed					871	360/30
1250-130	14-18-25	1300	135	Backside as agreed					1254	360/30
1250-140	14-18-25	1400	135	Backside as agreed					1455	360/30
1250-150	14-18-25	1500	135	Backside as agreed					1670	360/30
1250-160	14-18-25	1600	135	Backside as agreed					1900	360/60

Other dimensions and pole spacings are available upon request
* 210 V D.C. variants are also available with 360 V D.C. nominal voltage.

Special Solutions:

- Removable pole plates with workpiece dependent inserts
- magnet clamping chuck with plug-in unit on the outer surface