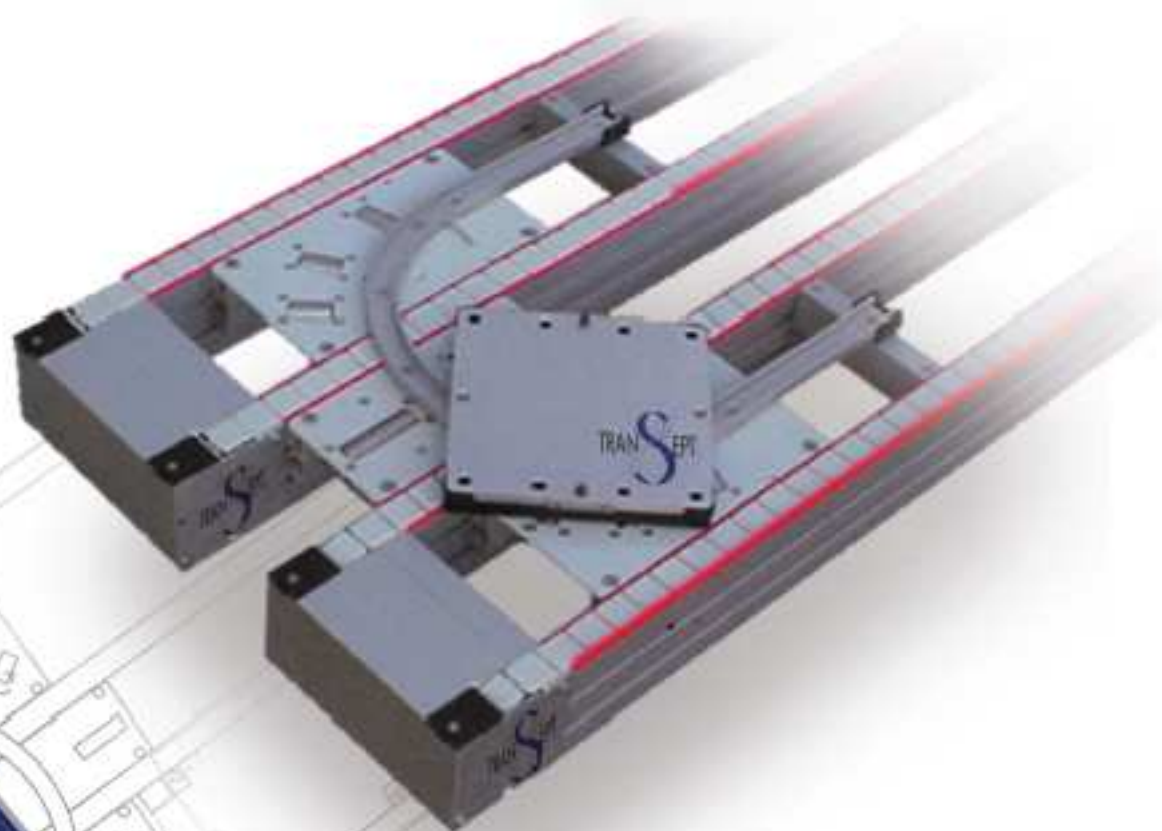


ASSEMBLY LINE TRANSFER

TR SERIES



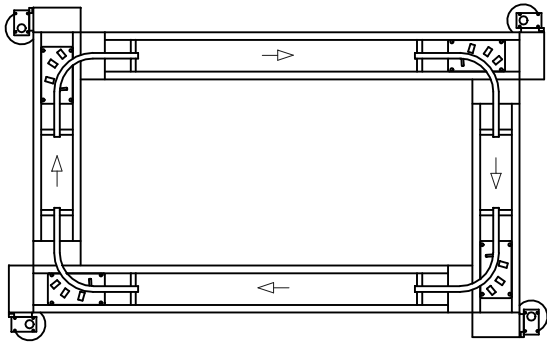
TRAN  EPT

The advantages of a good design

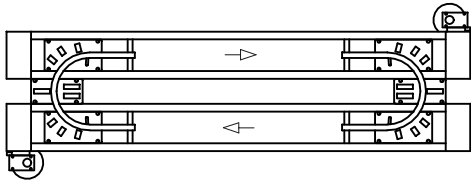
Contents

<u>Items</u>	<u>Page</u>
Description (modules).....	2
Description (structure).....	3
Description (drive)	4
Straight section.....	5
Lengths max/min and continuities.....	6
Leg sets and links	7
Workpiece carrier Line 100	9
Stop / Pad / Anti-backslash / Anti-lift / Sensing Line 100.....	10
40 kg positioning tool (6mm stroke) Line 100	11
40kg positioning tool (50/100mm stroke) Line 100.....	12
160kg positioning tool (6mm stroke) Line 100.....	13
90° curve (static) Line 100.....	14
90° curve (mobile) Line 100.....	15
180° curve Line 100	16
Input/output combination Line 100	18
Workpiece carriers Line 175	20
Workpiece carriers Line 250.....	22
Workpiece carriers Line 325.....	24
Workpiece carriers Line 400.....	26
Stop / Pad / Anti-lift / Sensing Lines 175 to 400	28
100kg positioning tool (6mm stroke) Lines 175 to 400.....	29
100kg positioning tool (50/100mm stroke) Lines 175 to 400	30
Anvil positioning tool (6mm stroke) Lines 175 to 400	31
Setting of positioning tools Lines 175 to 400.....	32
Multipositioning tool	33
90° curve (static and mobile) Line 175	34
180° curve Line 175.....	36
Input/output combination Line 175	38
90° curve (static and mobile) Line 250.....	40
180° curve Line 250	42
Input/output combination Line 250.....	44
90° curve (static and mobile) Line 325.....	46
180° curve Line 325	48
Input/output combination Line 325.....	50
90° curve (static and mobile) Line 400.....	52
Input/output combination Line 400.....	54
Cross combination.....	56
Linking of functions.....	57
Data processing.....	58
Miscellaneous, maintenance, accessories	59
Other products by Transept	60

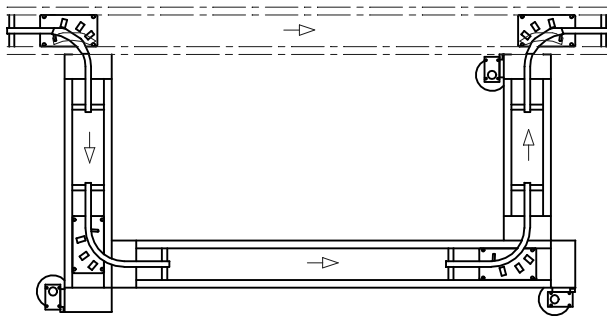
Description (modules)



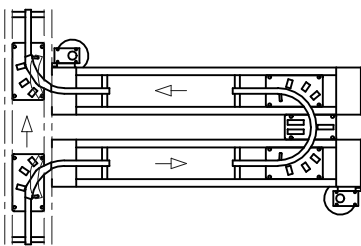
Rectangular basis



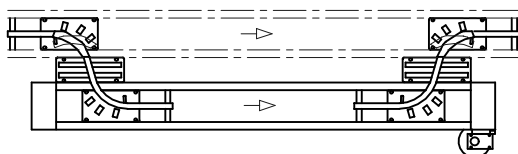
Hippodrome basis



Shunt



Spur track

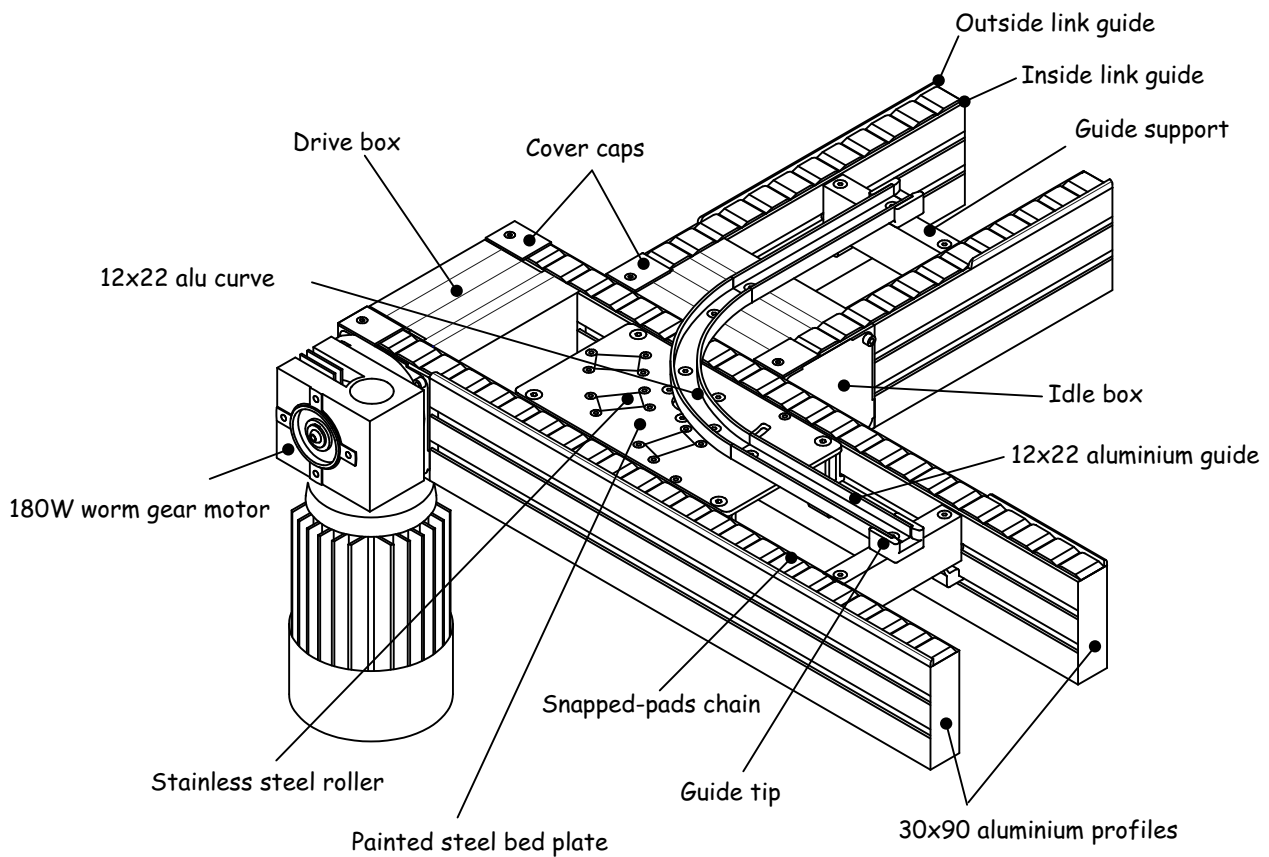


Diversion

Description (structure)

The design and configuration of the TRANSEPT system is based on the use of high quality materials such as stainless steel, anodised aluminium extrusion and polyamid or acetal.

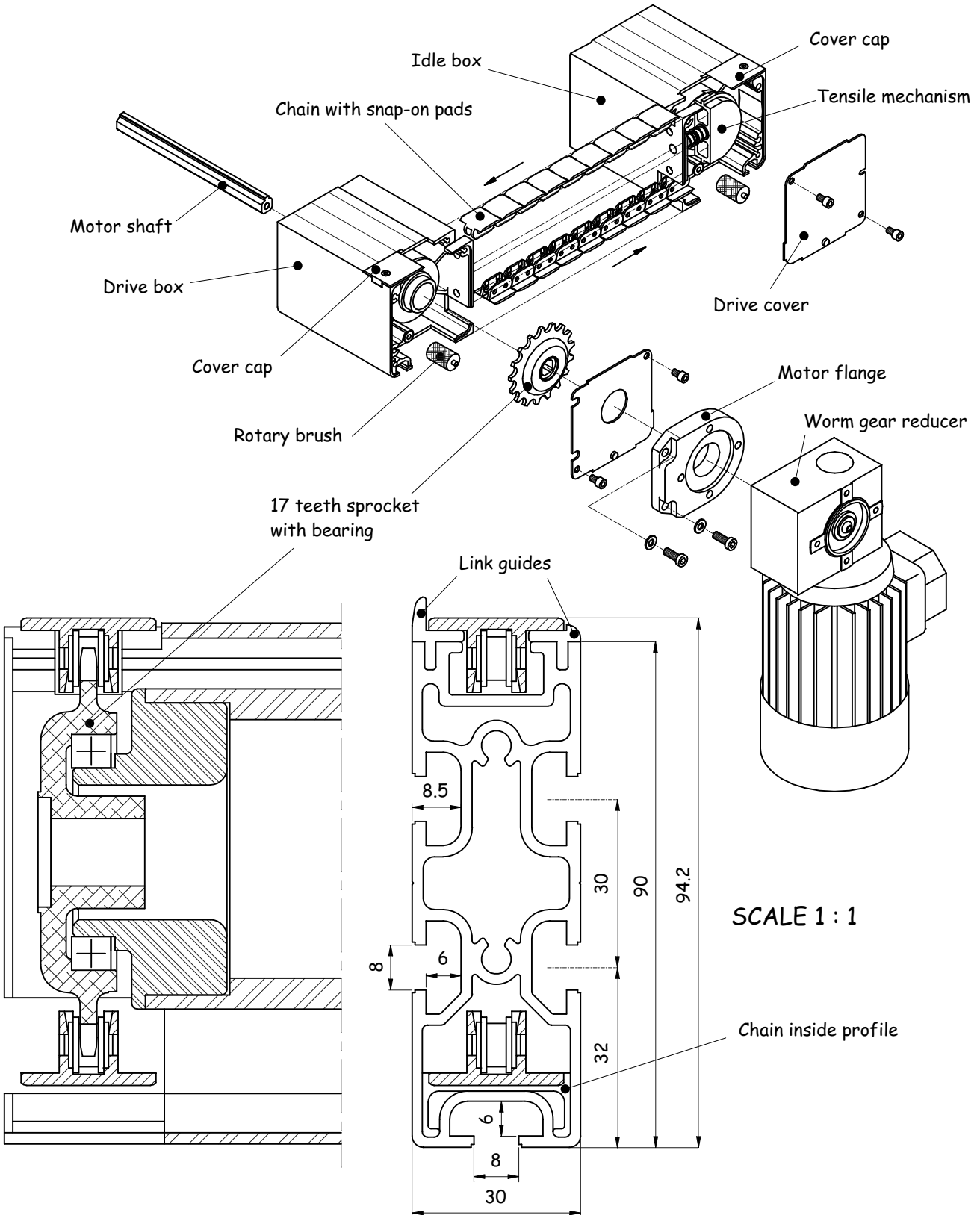
Its modularity ensures that installation of a system is quick and easy. Fixture modifications and expansion of lines is also made simple due to its architecture.



Example : 90° curve, line 175

Description (drive)

Workpiece carriers run freely upon the drive chains snap-on pads and with minimum maintenance (recommended lubrication every 5000h, one link removal every 10000h). Chain life duration is in excess of 30000h. Shafts of chain are chromized in order to reinforce their hardness while reducing considerably the risk of wear.

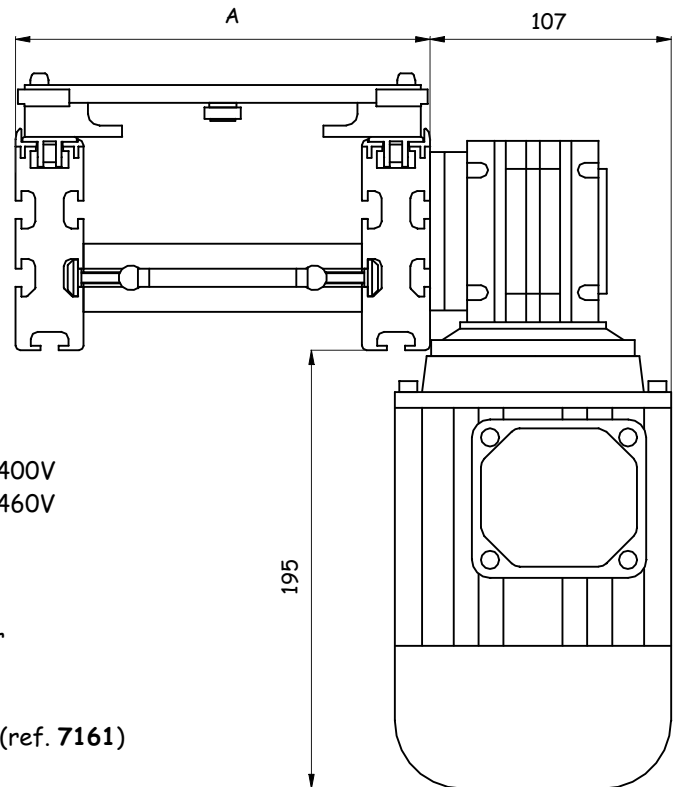


Straight section

Each straight section incorporates two 30mmx90mm aluminium profiles sections equipped with lateral guides (fuchsia coloured guides) for the guidance of the workpiece carriers.

The maximum loading for each straight section used in **accumulation** of workpiece carriers is up to **75kg** (however, should the transfer speed exceed 15m/min, this value should be decreased to 50kg).

Line	A (en mm)
100	112
175	183
250	258
325	333
400	408



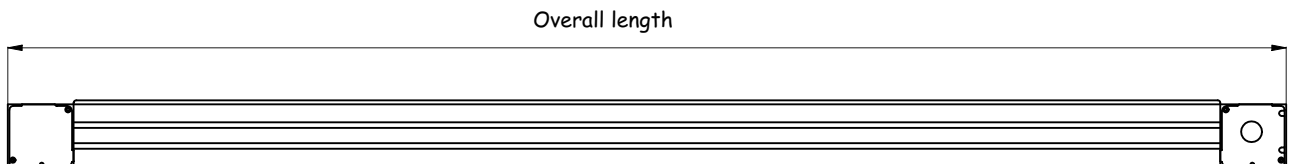
Worm gear motorreducer, size 30mm

Three-phase motor 180W 63 B14 50Hz 230/400V
 60Hz 230/460V

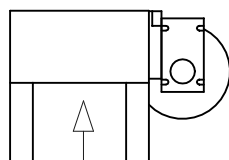
Standard speed (input 50Hz) : 14.6m/min

Other speeds : - use frequency inverter
 (from 30Hz to 70Hz)

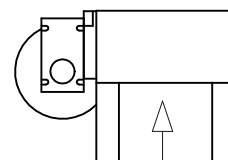
and/or - other worm gear ratio (ref. 7161)



Right side
motor mount



Left side
motor mount



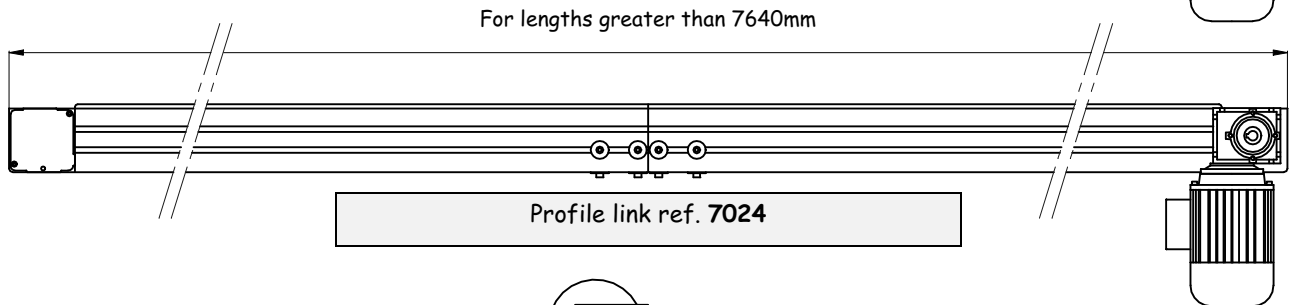
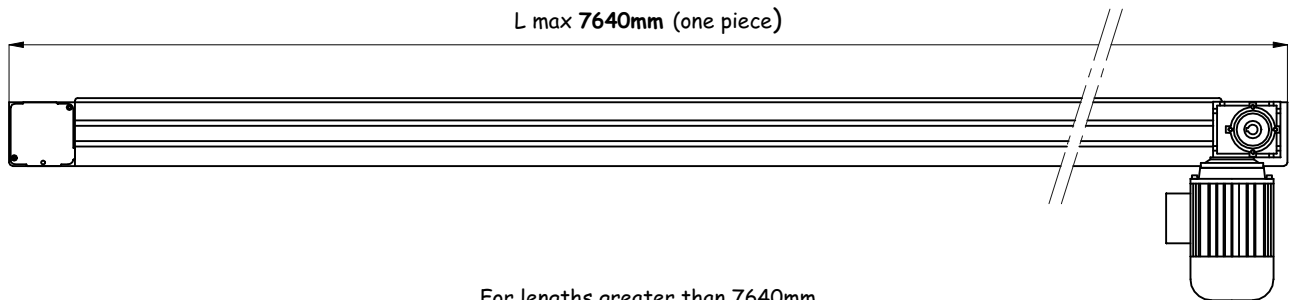
Line	Reference
100	4140
175	6141
250	6144
325	6147
400	6150

Reference	Line
4141	100
6142	175
6145	250
6148	325
6151	400

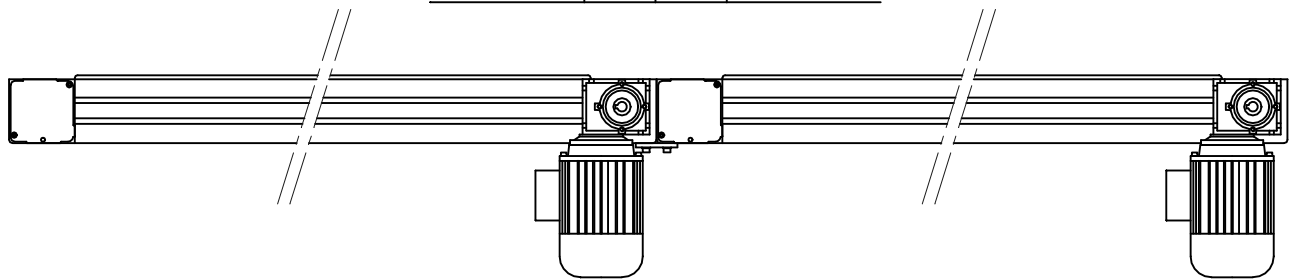
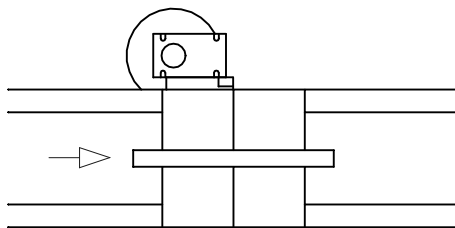
How to order : Ref. 6141-3500

Example straight section line 175, overall length of which is 3500mm, with right side motor mount

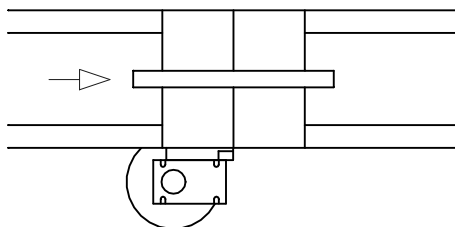
Lengths max/min and continuities



Continuity Lines 175 to 400
Left side motor mount

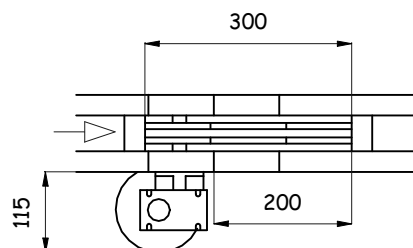


Continuity Lines 175 to 400
Right side motor mount



Line	Reference of continuity	
	Right side motor mount	Left side motor mount
175	4156	
250		
325		
400		

Continuity Line 100
Right side motor mount

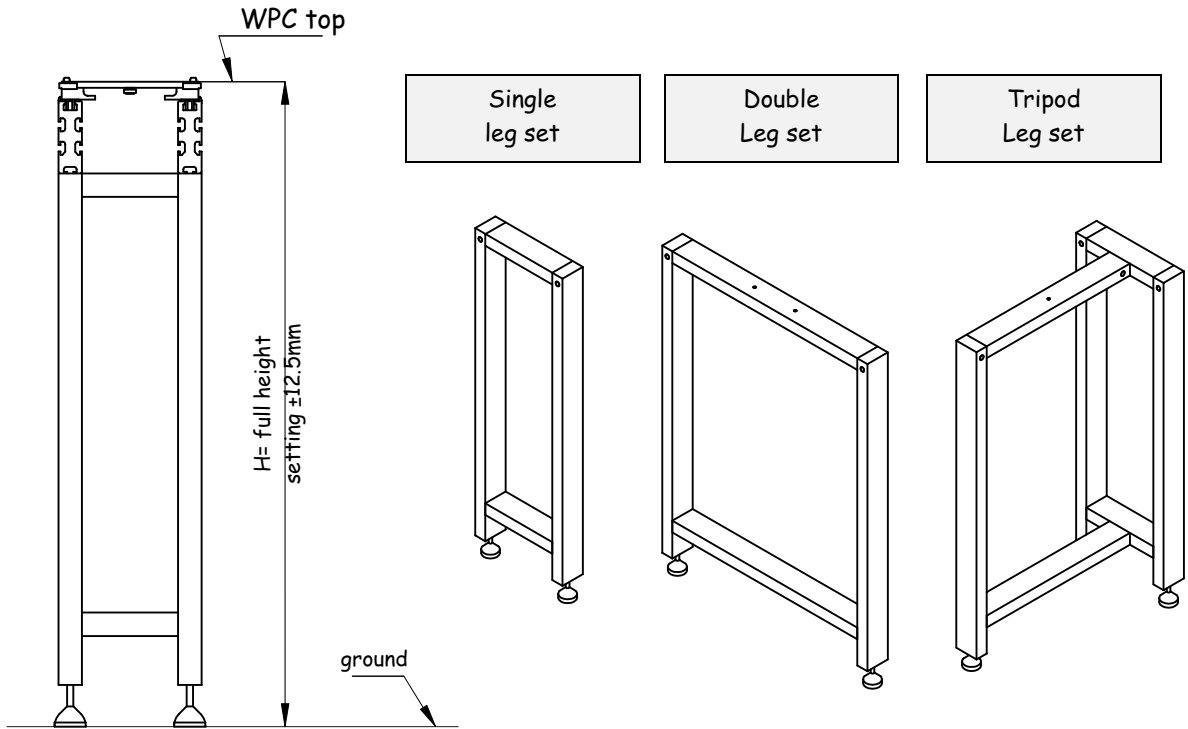


Line	Reference of continuity	
	Right side motor mount	Left side motor mount
100	4061	4062

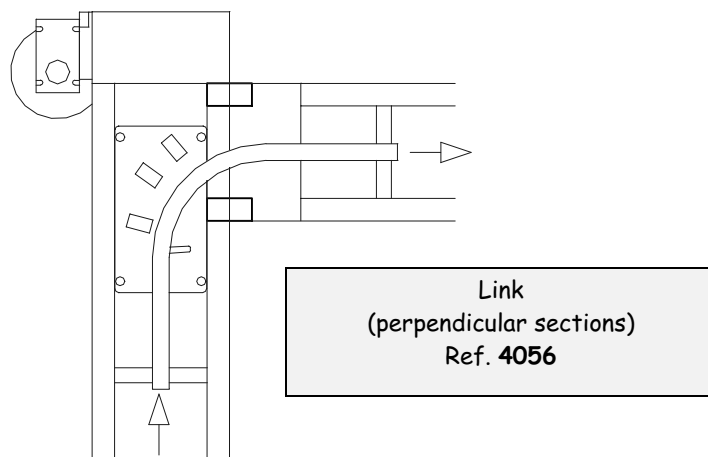
Leg sets and links

Leg sets are used to support the transfer sections. It is recommended that leg sets are spaced at 2 meters intervals. Leg sets are generally made of standard profile (30x60) or another one if required. They are delivered and equipped with adjustable feet and fixing accessories (ground fasteners not included). Tripod leg set fits very well with perpendicular straight sections.

Link 4056 (perpendicular sections) and fixing 4156 (aligned sections, see page 6) ensure reliable geometry when assembling the transfer system.



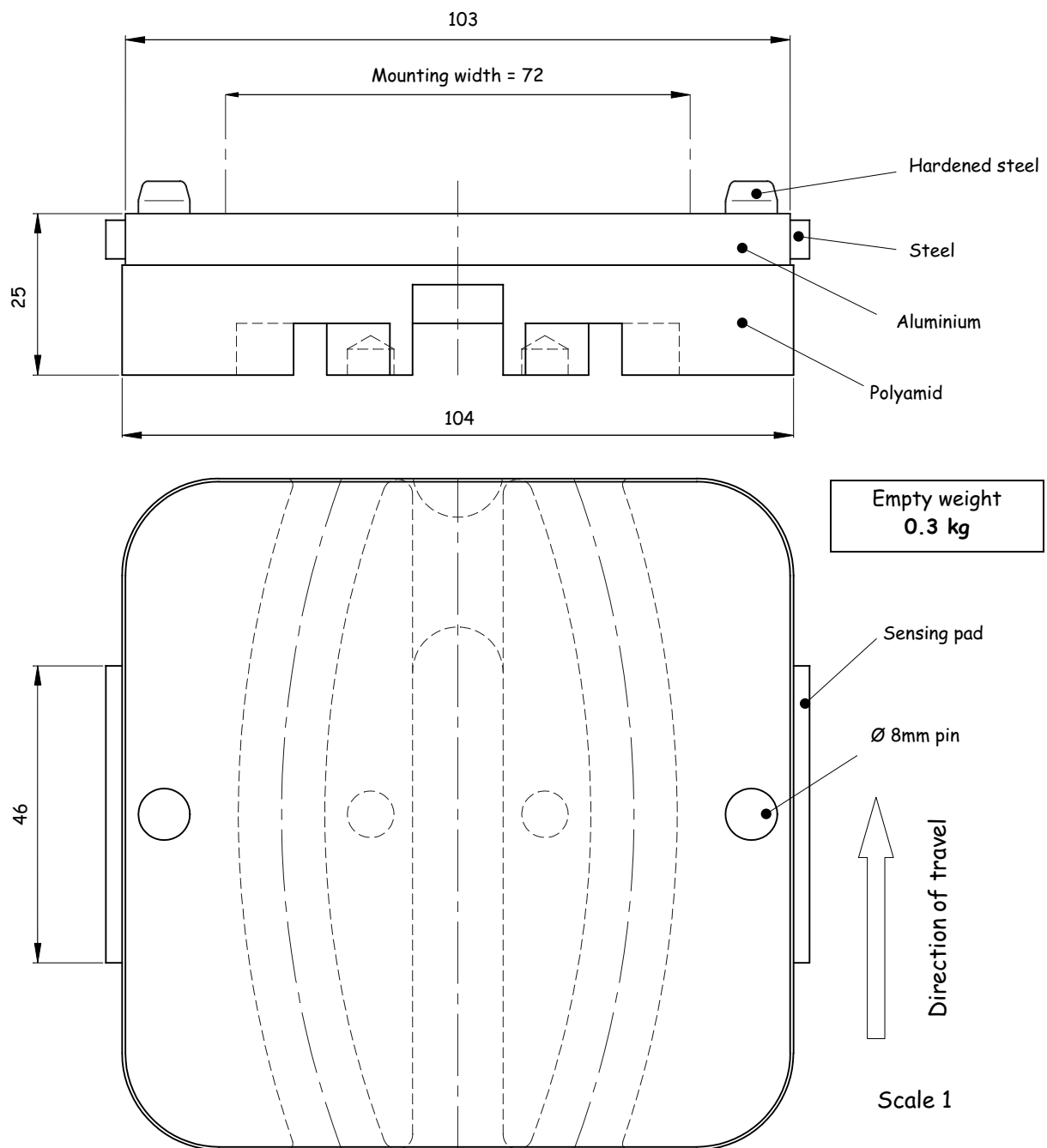
Line	Single leg set	Double leg set	Tripod leg set
100	Ref. 6049	Ref. 6063 (180° curve)	impossible
		Ref. 6065 (I/O combination)	
175	Ref. 6050	Ref. 6053	Ref. 8056
250	Ref. 6051	Ref. 6054	Ref. 8057
325	Ref. 6052	Ref. 6055	Ref. 8058
400	Ref. 8055	Ref. 8054 (I/O combination)	Ref. 8059



Workpiece carriers (WPC) are used to locate and transfer parts during the whole production and assembly cycle. Line 100 WPC is made of aluminium plate and polyamid pad and is equipped with grooves to ensure perfect guidance through curves and other functions.

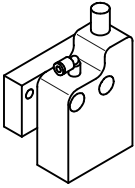

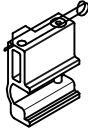
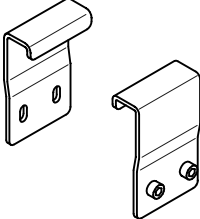
For indexing, \varnothing 8mm pins are provided and allow precise positioning in X, Y and Z axis within a +/- 0.03mm repeatability. Special contour features within the WPC pad ensures total immobilization at a stop position. Steel pads on either side allow sensing with conventional inductive sensors. Mechanical data processing can be provided as described in page 58.

Line 100 workpiece carrier (reference 8006) can accommodate payloads up to **5kg**.

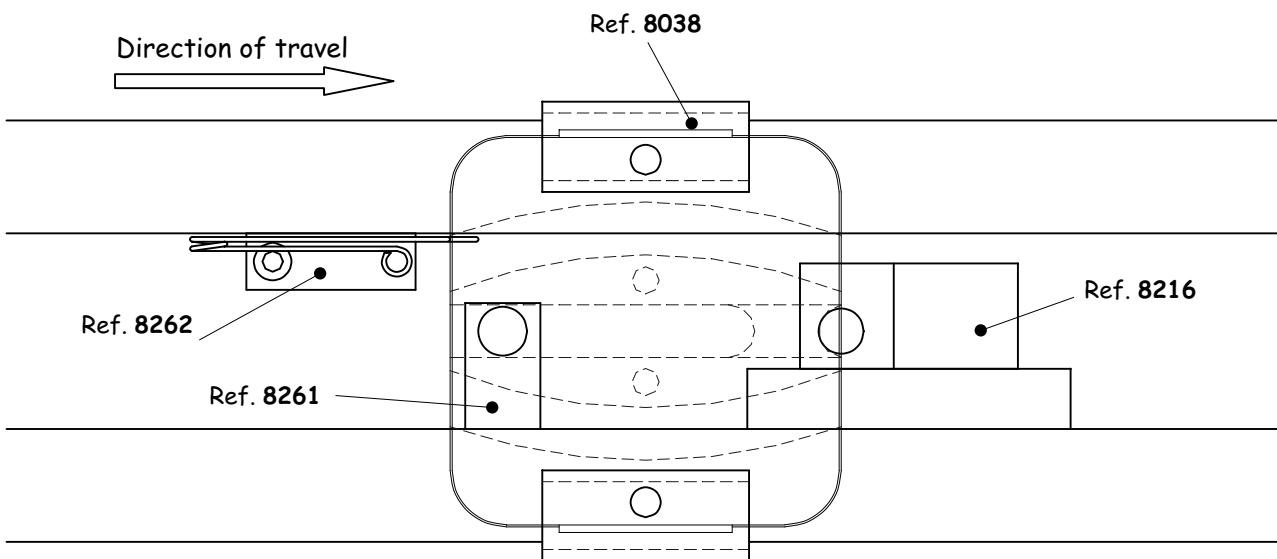


The stop unit 8216 provides a simple stop facility when precise positioning of the workpiece carrier is not necessary. The stop may also be used for flow control and prioritisation of workpiece carriers prior to and after « mobile » functions and precise station stops.

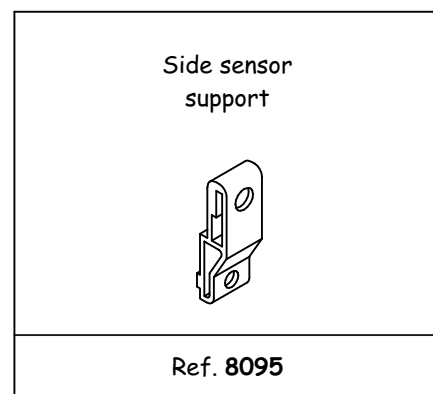
The pad 8261 improves the stop precision and the anti-backslash kit 8262 reduces the WPC bounce, providing better cycle times. When unloading pieces at manual workstations, the anti-lift kit 8038 prevents the operator from lifting of the WPC from the transfer line.

Stop	Pad	Anti-backslash	Anti-lift
			
Ref. 8216	Ref. 8261	Ref. 8262	Ref. 8038

- Stop**
- stop capability 75kg
 - stop accuracy +/-0.3mm (with pad 8261)
 - cylinder Ø 25mm, single-acting
 - lubricated or not, cleaned air, 5 to 6 bars
 - connector for Ø 4mm pipe (provided)
 - acetal body, stainless steel plunger
 - sensing up/down positions : on request ref. 8014 (M8 sensors not included)

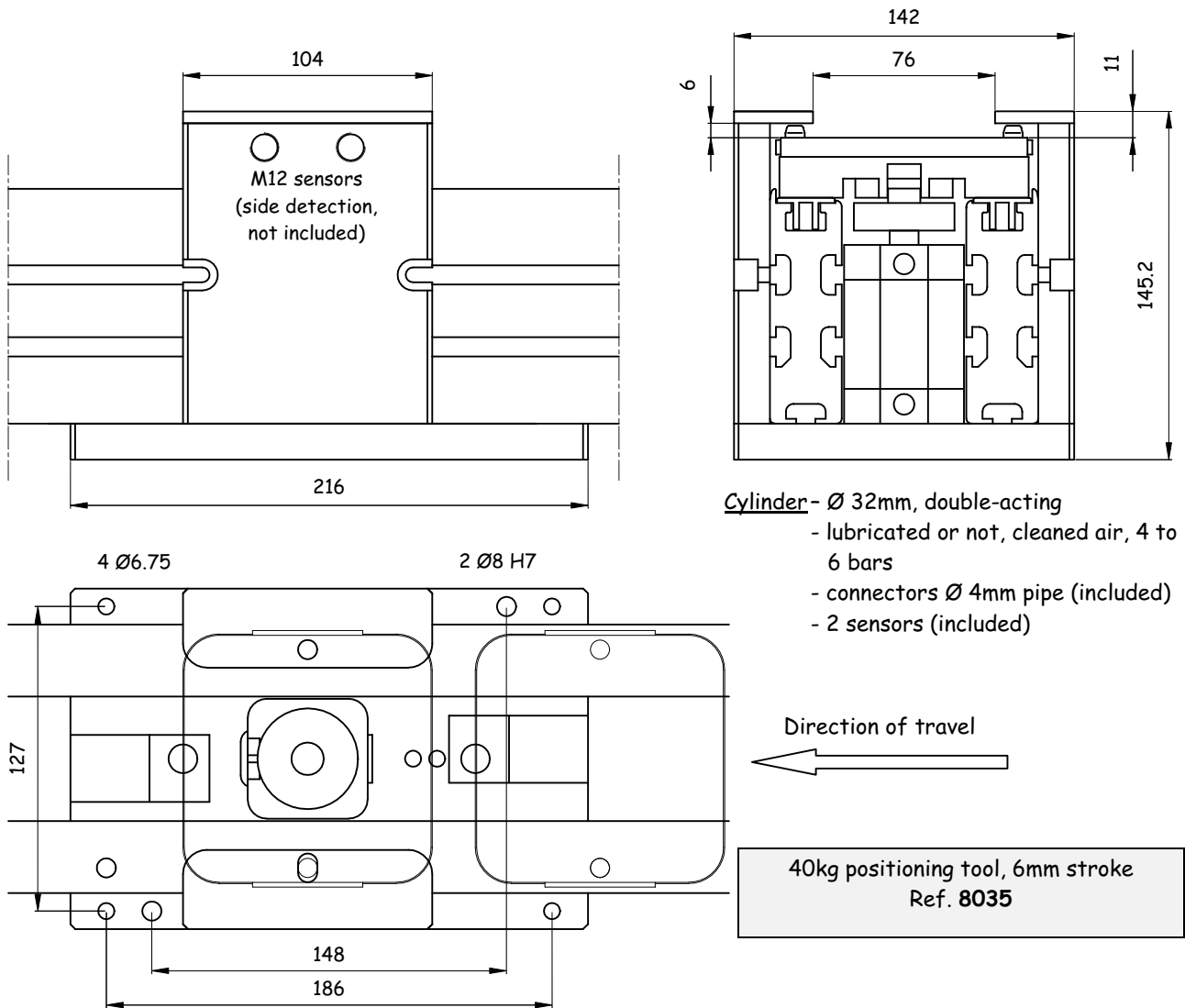


When stopping within a workstation, workpiece carriers may be detected using inductive sensors M12 (recommended span 4mm), with or without connectors, fitted to supports 8095. These sensors also ensure flow and priority control.



When a process requires precise positioning for the workpiece carriers, the 40kg positioning tool (6mm stroke) ensures a +/- 0.03mm XYZ repeatability. The positioning tool is manufactured from high grade aluminium. A double-acting pneumatic cylinder lifts and secures the workpiece carrier in hardened steel jaws. Two sensors fitted on the cylinder body ensure detection of up/down positions. Threads in the side of the positioning tool allow the use of M12 sensors (not included).

The 40kg positioning tool (6mm stroke) is delivered with 2 stops 8016, pre-fitted on its base. These stops must be ordered separately.



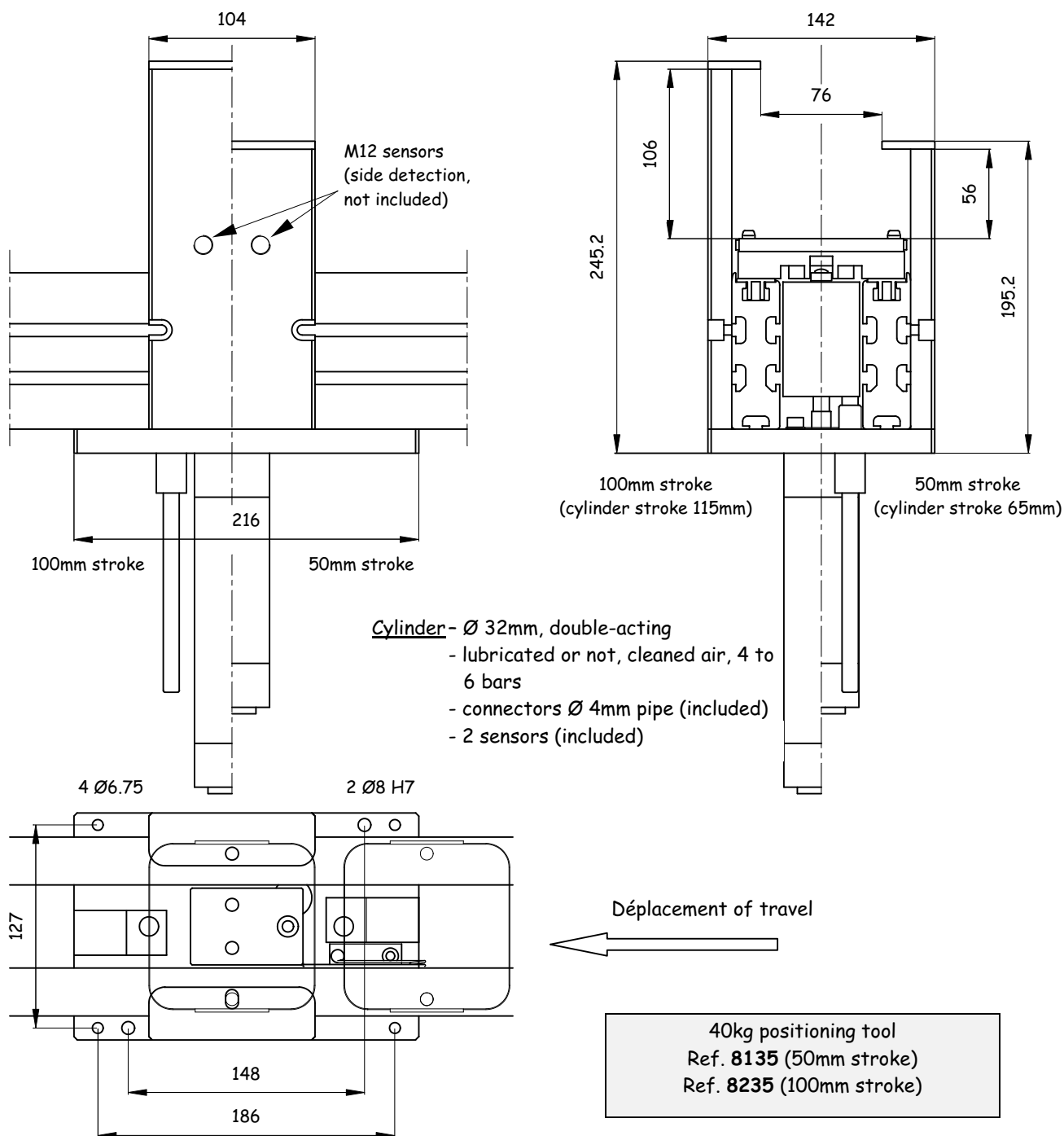
- Cylinder - Ø 32mm, double-acting
- lubricated or not, cleaned air, 4 to 6 bars
 - connectors Ø 4mm pipe (included)
 - 2 sensors (included)

IMPORTANT

1. The positioning tool must be fitted to a stable and robust structure in order to ensure the accuracy of this function.
2. The positioning tool must be fully guarded once fitted.

The 50mm or 100mm stroke version of the 40kg positioning tool ensures a +/- 0.03mm XYZ repeatability. The positioning tool is manufactured from high grade aluminium. A double-acting pneumatic cylinder lifts and secures the workpiece carrier in hardened steel jaws. Two sensors fitted on the cylinder body ensure detection of up/down positions. Threads in the side of the positioning tool allow the use of M12 sensors (not included).

The 40kg positioning tool (50/100mm stroke) is delivered with 2 stops 8016, pre-fitted on its base. These stops must be ordered separately.

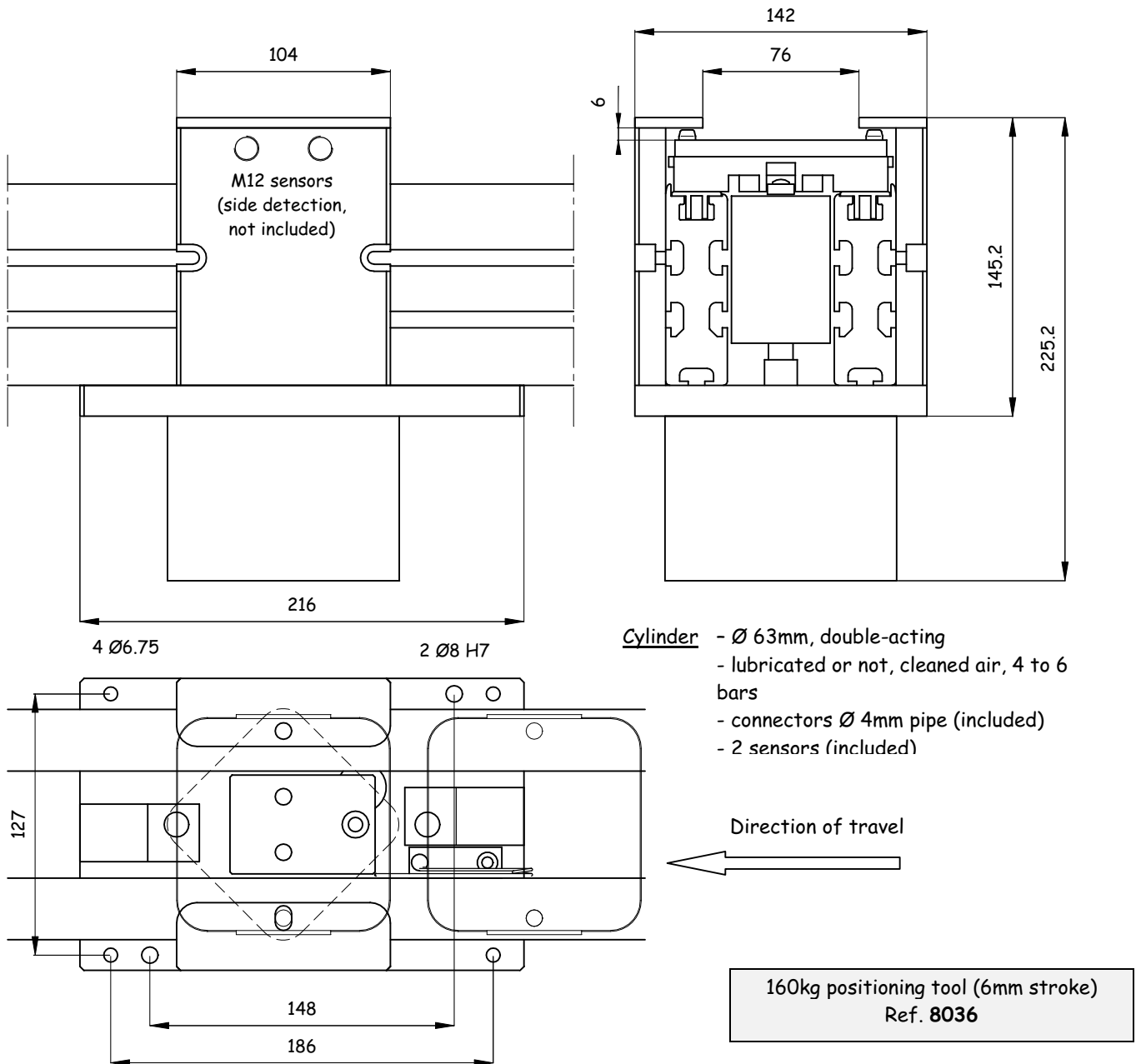


IMPORTANT

1. The positioning tool must be fitted to a stable and robust structure in order to ensure the accuracy of this function.
2. The positioning tool must be fully guarded once fitted.

When a process requires precise positioning under strong efforts, the 160kg positioning tool (6mm stroke) ensures a +/- 0.03mm XYZ repeatability. The positioning tool is manufactured from high grade aluminium. A double-acting pneumatic cylinder lifts and secures the workpiece carrier in hardened steel jaws. Two sensors fitted on the cylinder body ensure detection of up/down positions. Threads in the side of the positioning tool allow the use of M12 sensors (not included).

The 160kg positioning tool (6mm stroke) is delivered with 2 stops 8016, pre-fitted on its base. These stops must be ordered separately.

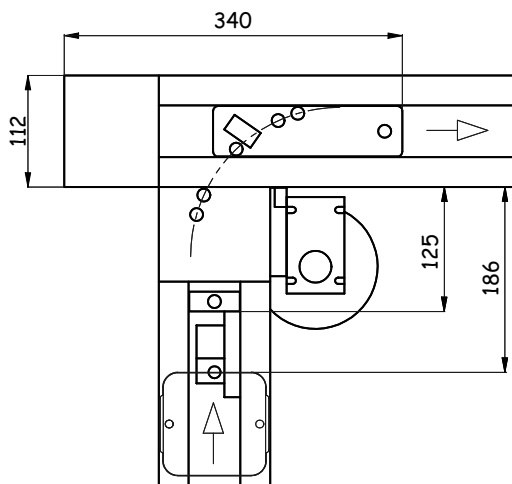


IMPORTANT

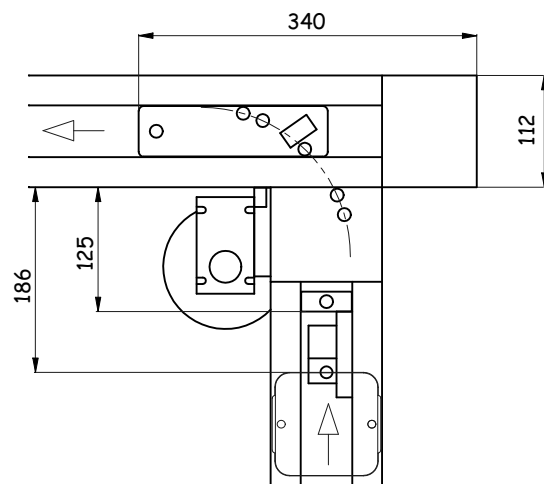
1. The positioning tool must be fitted to a stable and robust structure in order to ensure the accuracy of this function.
2. The positioning tool must be fully guarded once fitted.

Using the 90° curve, it is possible to cross from one section perpendicular to another. Grooves under the workpiece carriers ensure perfect guidance on ball bearings fixed upon the bed plates. Specially designed claws allow the bed plates to be fitted easily.

In this configuration, accumulation of workpiece carriers is possible. The small content of mechanical elements and features within the 90° curve results in high reliability.

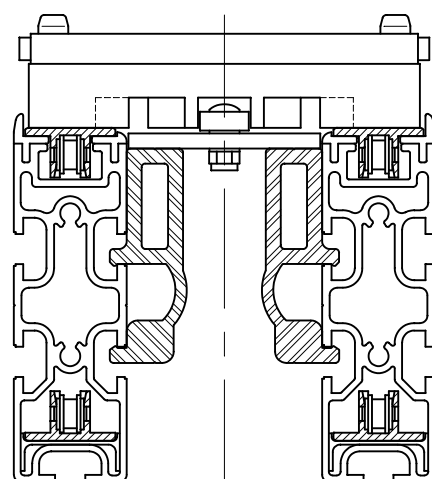


90° right curve
Ref. 4022



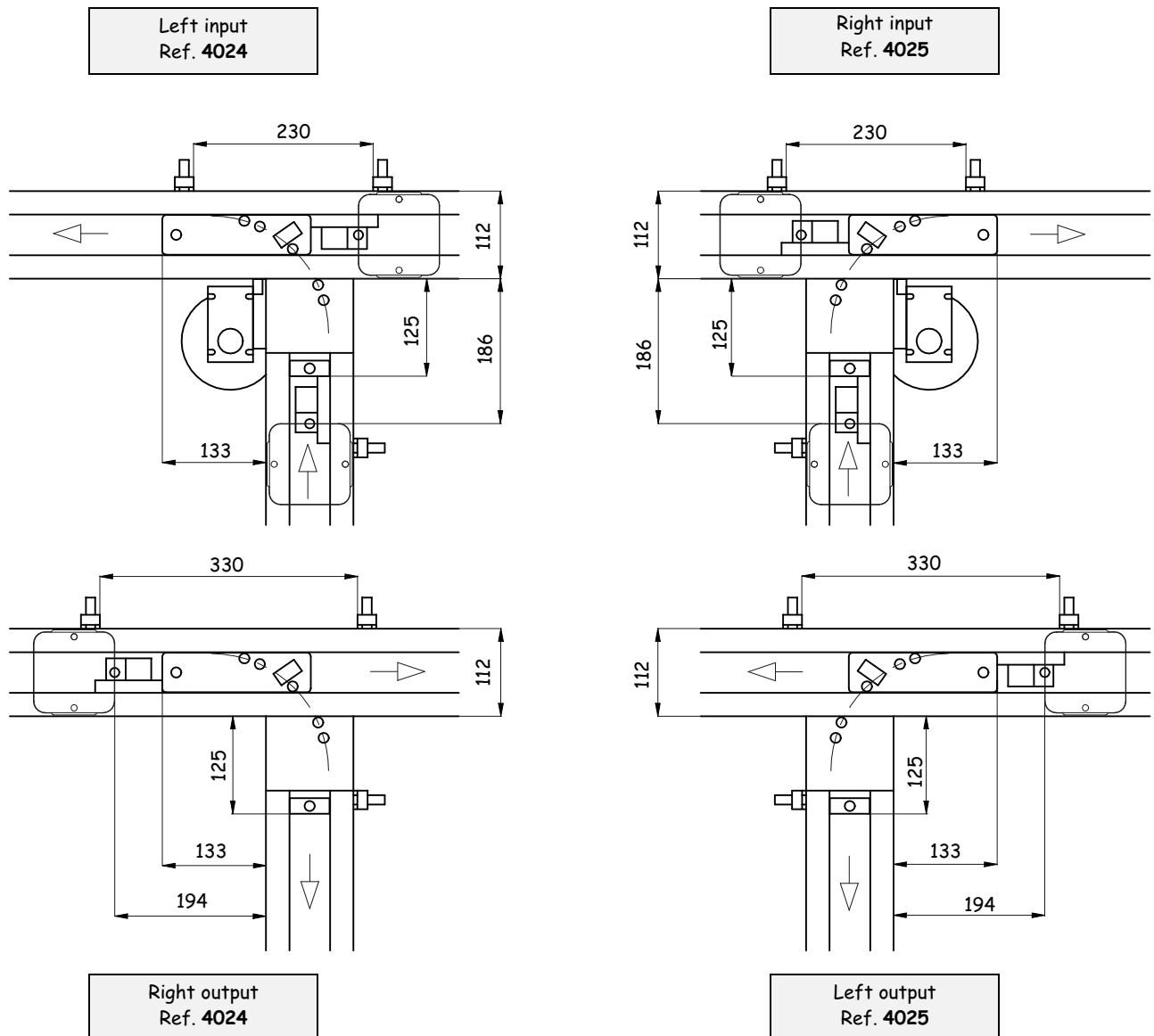
90° left curve
Ref. 4023

The minimum distance at which the workpiece carriers may be stopped in relationship to the curve is shown in the drawings above.



The 90° curve « mobile » allows workpiece carriers to be introduced from a secondary section to a main one (« input ») or from a main section to a secondary one (« output »). Grooves under the workpiece carriers ensure perfect guidance on ball bearings fixed upon the bed plates.

This function is « mobile » due to the retractable main bed plate. The 90° curve « mobile » presents a reduced flow-stoppage rate requiring minimum automation.

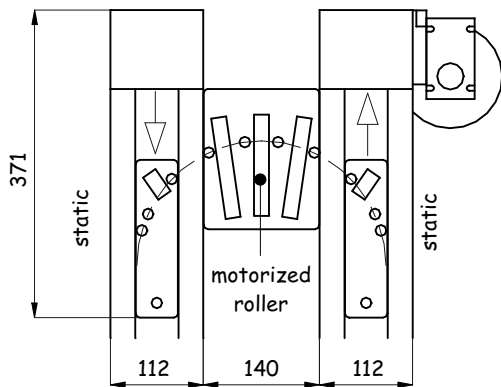


- Retractable bed plate cylinder**
- Ø 16mm, double-acting
 - lubricated or not, cleaned air, 5 to 6 bars
 - connectors for Ø 4mm pipe (included)
 - sensors on cylinder body (not included)

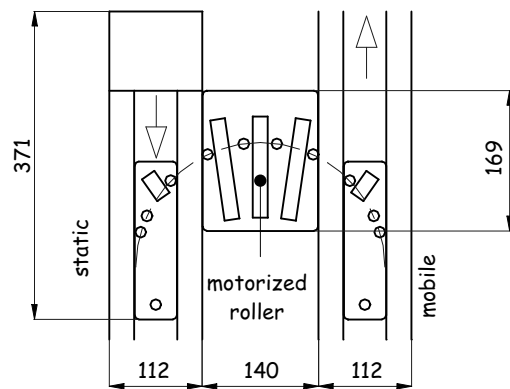
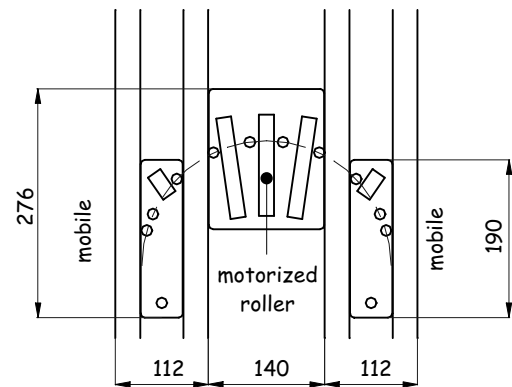
Using the 180° curve, it is possible to cross from one section in parallel to another operating in the opposite direction. Four combinations cover all possible configurations.

This function is « mobile » due to the retractable bed plate. In the « static/static » curve, accumulation of workpiece carriers is possible. The bed plate between the sections (« middle bed plate ») is equipped with a motorized roller to aid workpiece carriers through the curve.

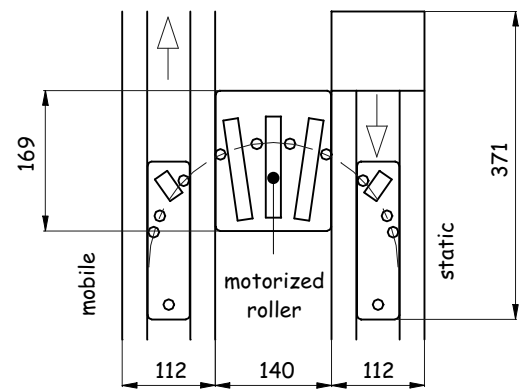
Ref. 4012 (static/static)



Ref. 4015 (mobile/mobile)



Ref. 4013 (static/mobile)



Ref. 4014 (mobile/static)

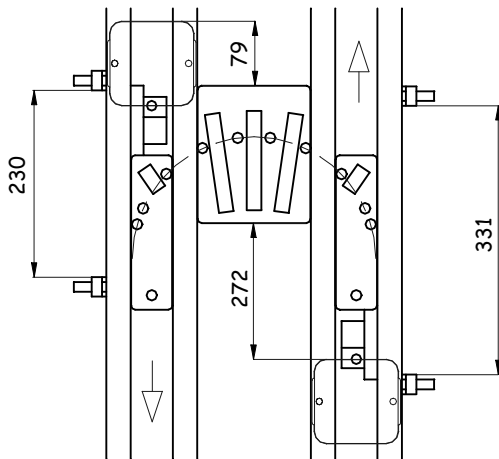
Retractable bed plate cylinder

- Ø 16mm, double-acting
- lubricated or not, cleaned air, 5 to 6 bars
- connectors for Ø 4mm pipe (included)
- sensors on cylinder body (not included)

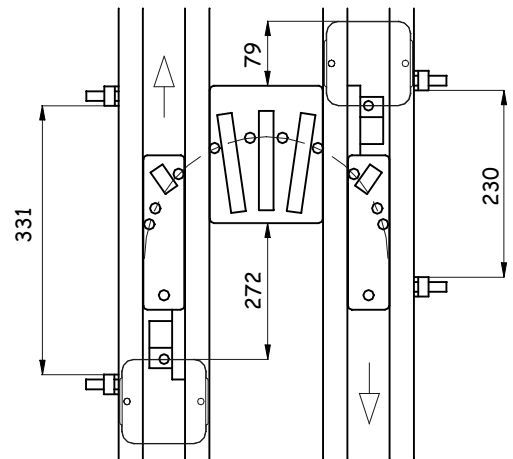
Intermediate motorized roller

- power 6.3W
- voltage 220V single-phase
- frequency 50Hz
- rated current 73mA

The minimum distance at which the workpiece carriers may be stopped in relationship to the curve is shown in the drawings below.



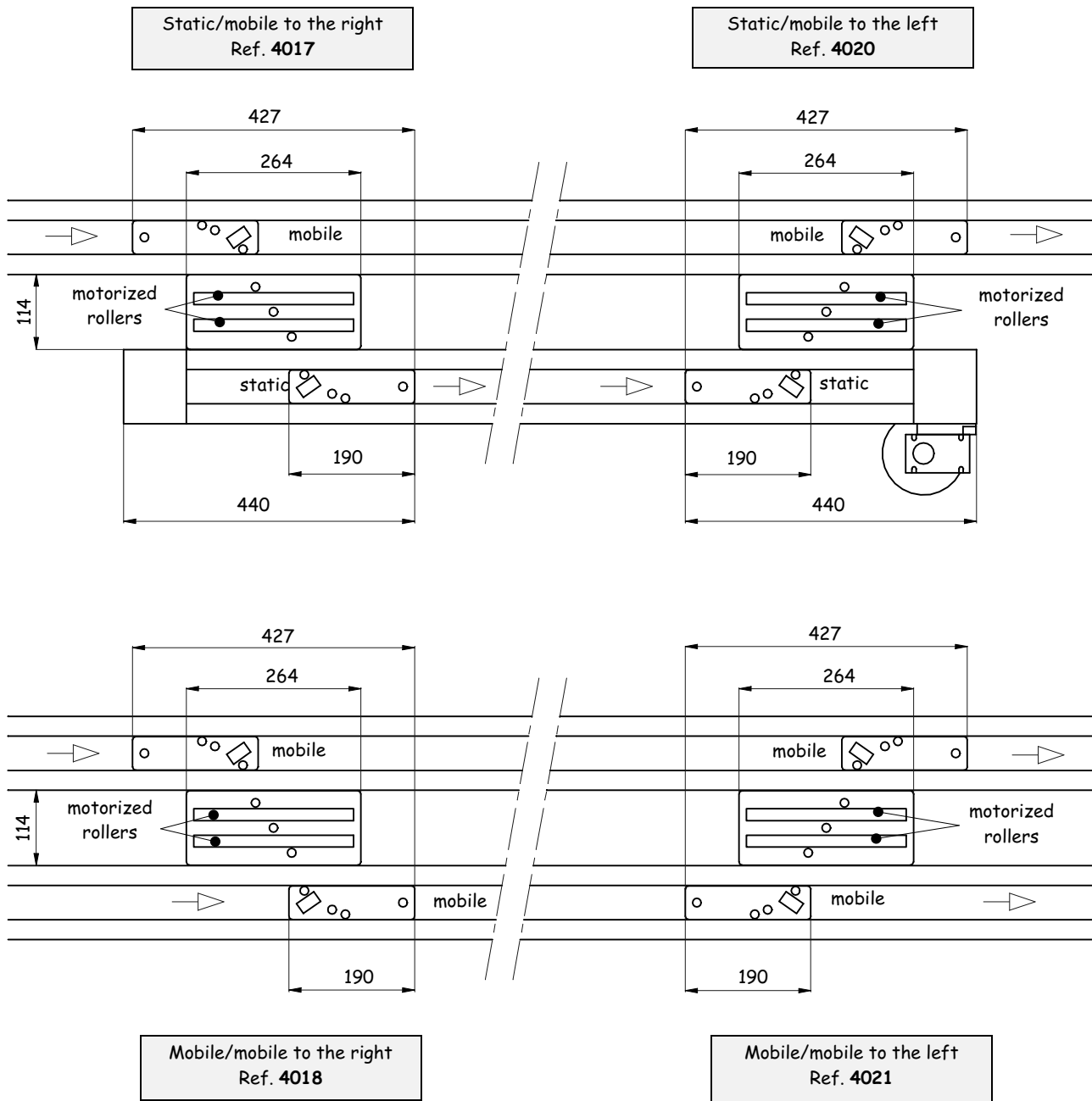
Counter-clokwise



Clockwise

The function of the input/output combination is adapted to transfer workpiece carriers from one section to another operating in parallel and running in the same direction.

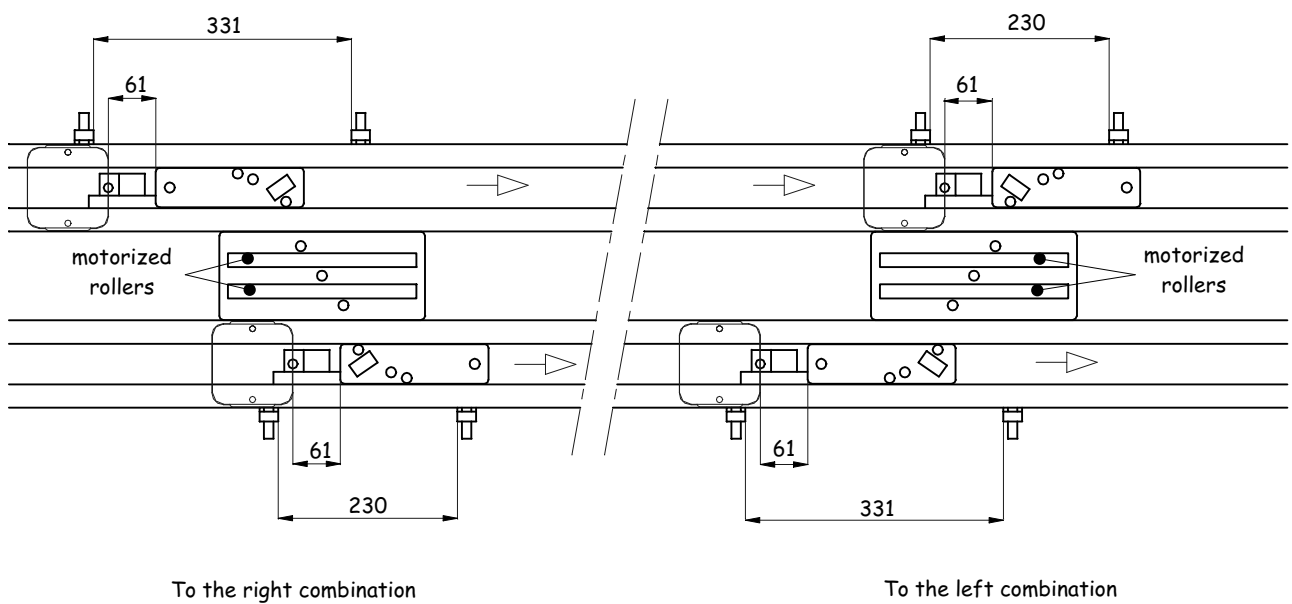
This function is « mobile » due to the retractable bed plate. The bed plate between the sections (« middle bed plate ») is equipped with two motorized rollers (driven by only one motor) to aid workpiece carriers through the transfer sections.



- Retractable bed plate cylinder
- Ø 16mm, double-acting
 - lubricated or not, cleaned air, 5 to 6 bars
 - connectors for Ø 4mm pipe (included)
 - sensors on cylinder body (not included)

- Intermediate motorized rollers
- power 6.3W
 - voltage 220V single-phase
 - frequency 50Hz
 - rated current 73mA

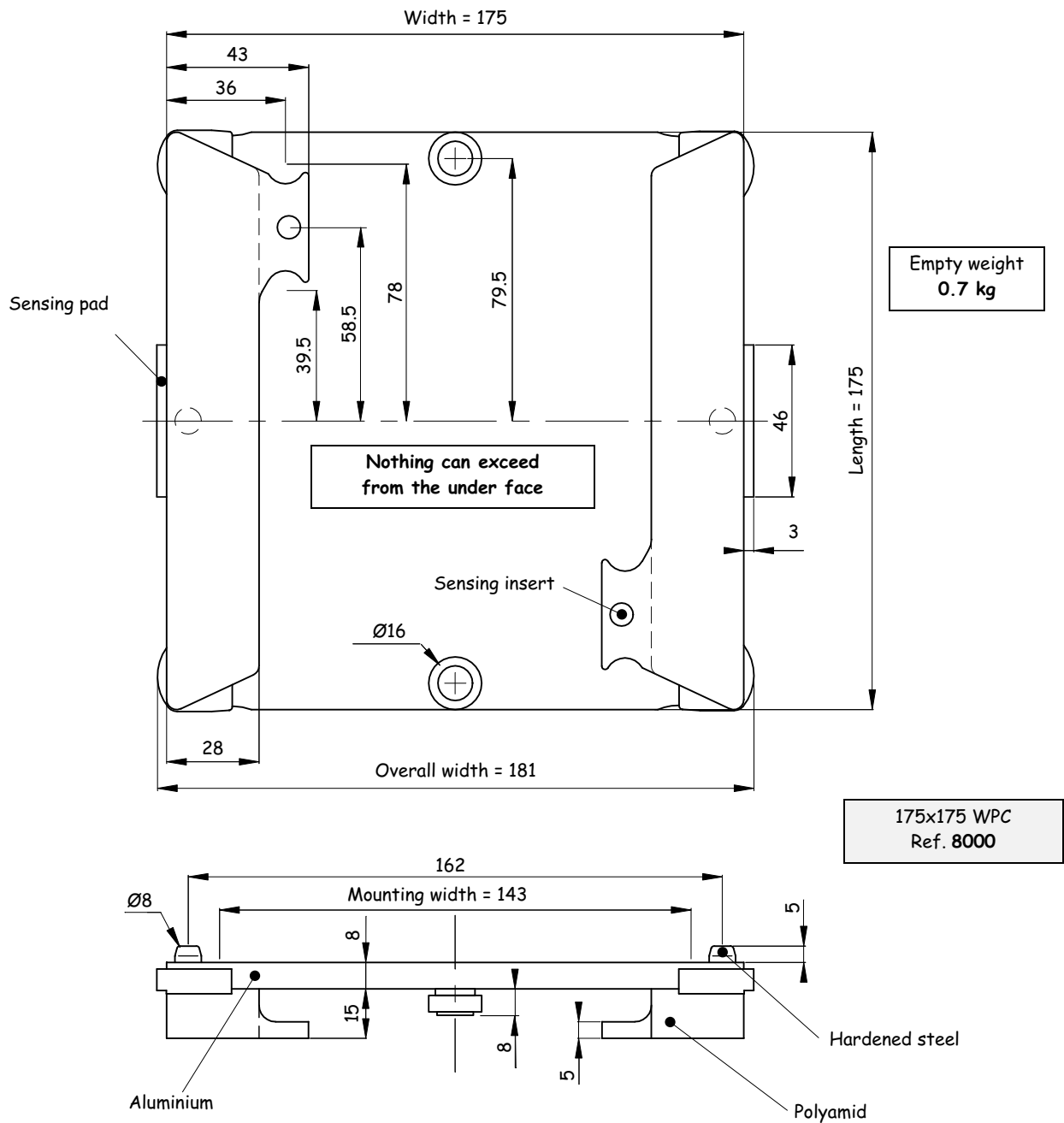
The minimum distance at which the workpiece carriers may be stopped in relationship to the combination is shown in the drawings below.



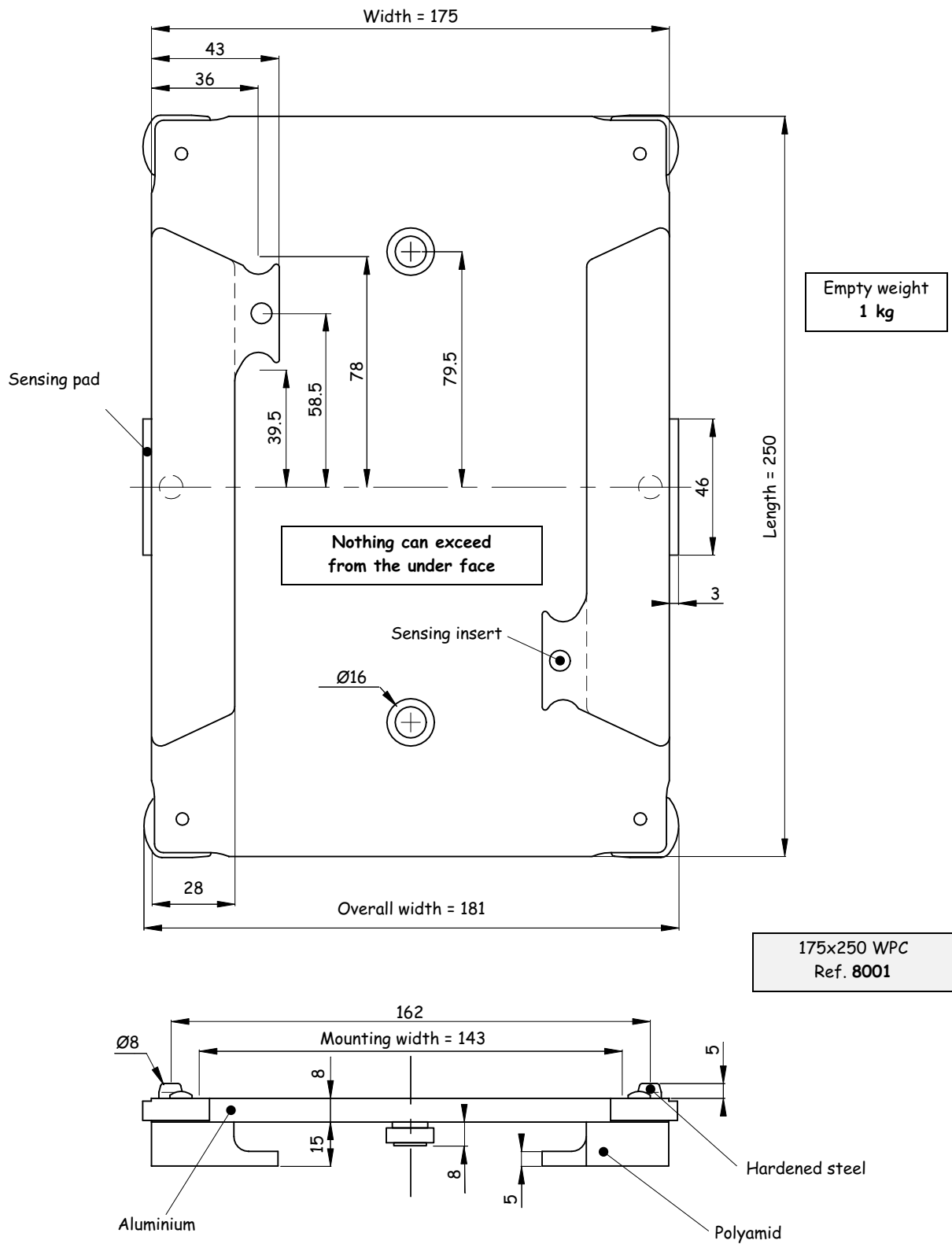
Workpiece carriers (WPC) are used to locate and transfer parts during the whole production and assembly cycle. Line 175 WPC are made of aluminium plate and polyamid pad and are equipped with ball bearings to ensure perfect guidance through curves and other functions.

For indexing, $\varnothing 8$ mm pins are provided and allow precise positioning in X, Y and Z axis within a +/- 0.03mm repeatability. Special contour features within the WPC pad ensures total immobilization at a stop position. Steel pads on either side allow sensing with conventional inductive sensors. Mechanical data processing can be provided as described in page 58.

Line 175 workpiece carriers (references **8000** and **8001**) can accommodate payloads up to **7kg**.



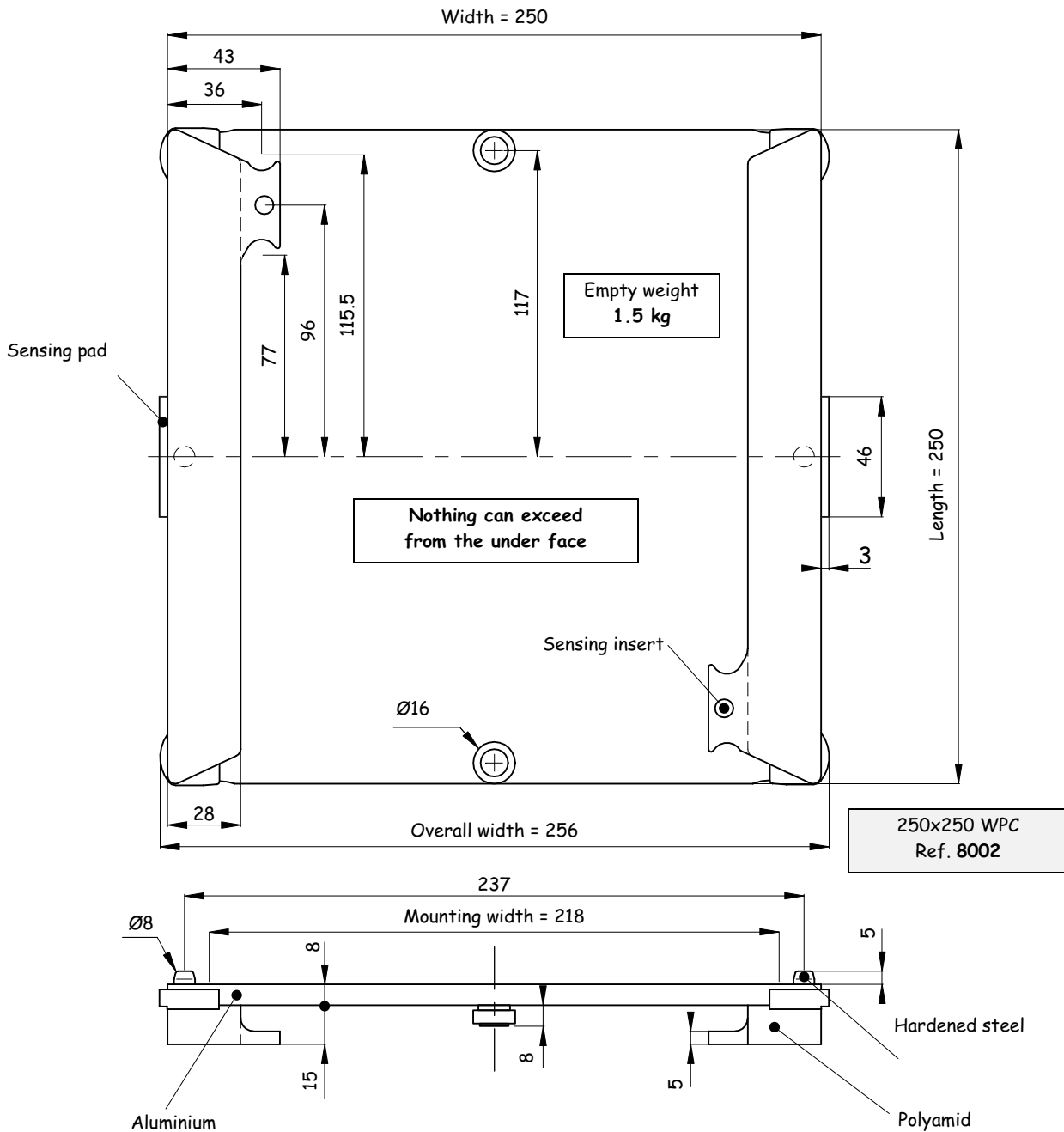
WPC plate is made of anodized aluminium. Flatness is better than 0.5mm. Detachable molded polyamid pads may be replaced easily. Friction coefficients are 0.25 (carrying) and 0.50 (accumulation).



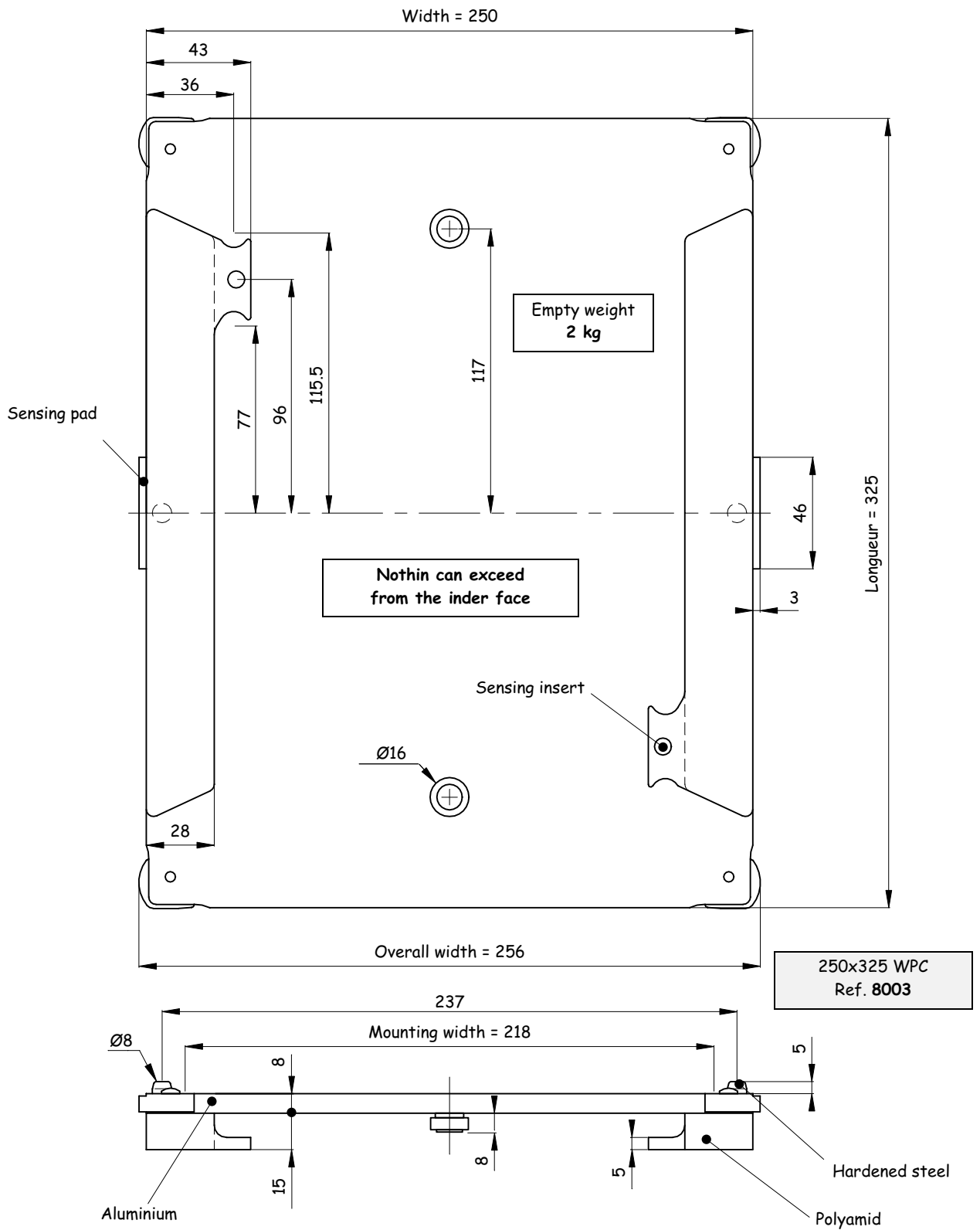
Workpiece carriers (WPC) are used to locate and transfer parts during the whole production and assembly cycle. Line 250 WPC are made of aluminium plate and polyamid pad and are equipped with ball bearings to ensure perfect guidance through curves and other functions.

For indexing, $\varnothing 8$ mm pins are provided and allow precise positioning in X, Y and Z axis within a +/- 0.03mm repeatability. Special contour features within the WPC pad ensures total immobilization at a stop position. Steel pads on either side allow sensing with conventional inductive sensors. Mechanical data processing can be provided as described in page 58.

Line 250 workpiece carriers (references **8002** and **8003**) can accommodate payloads up to **10kg**.



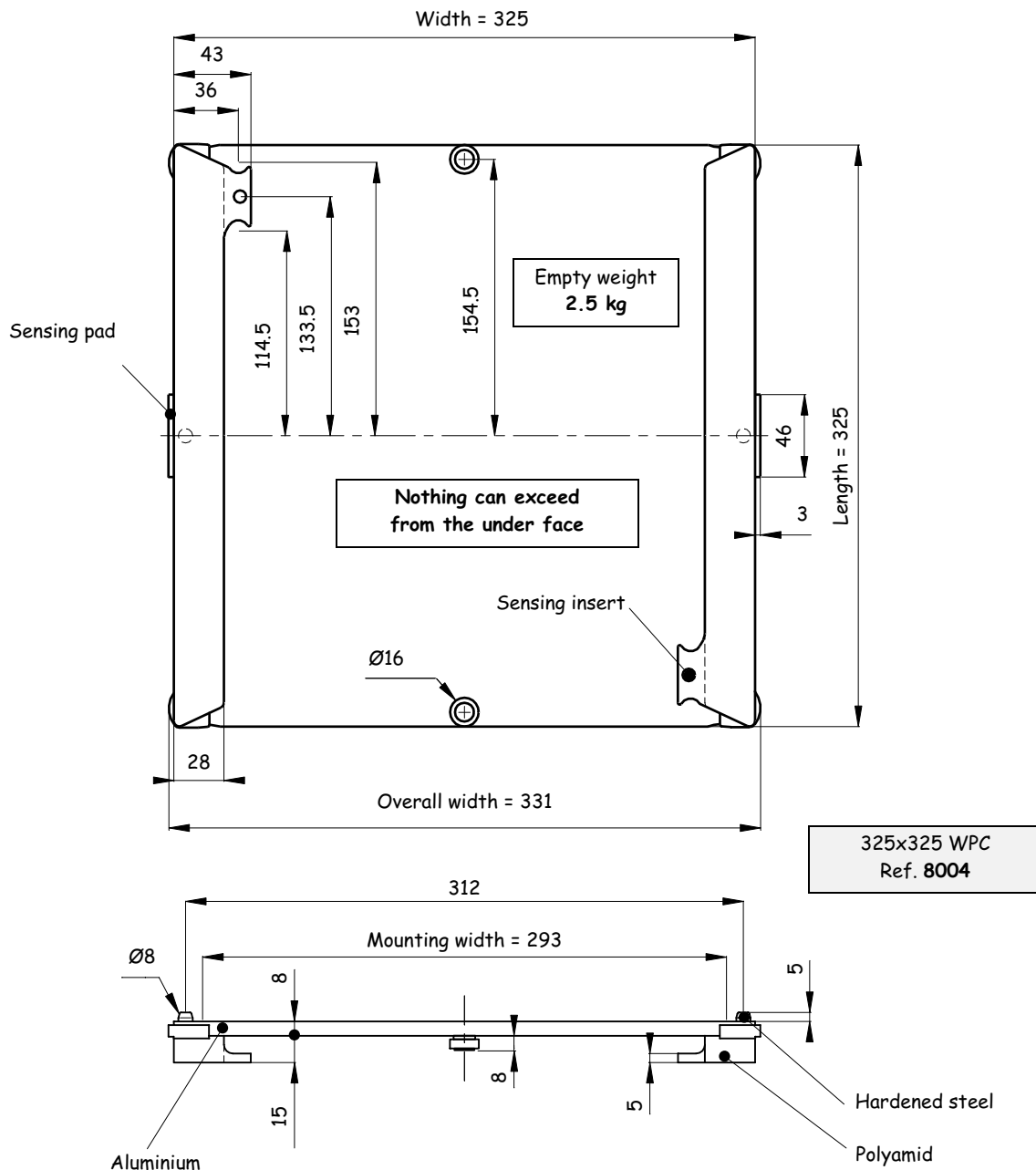
WPC plate is made of anodized aluminium. Flatness is better than 0.5mm. Detachable molded polyamid pads may be replaced easily. Friction coefficients are 0.25 (carrying) and 0.50 (accumulation).



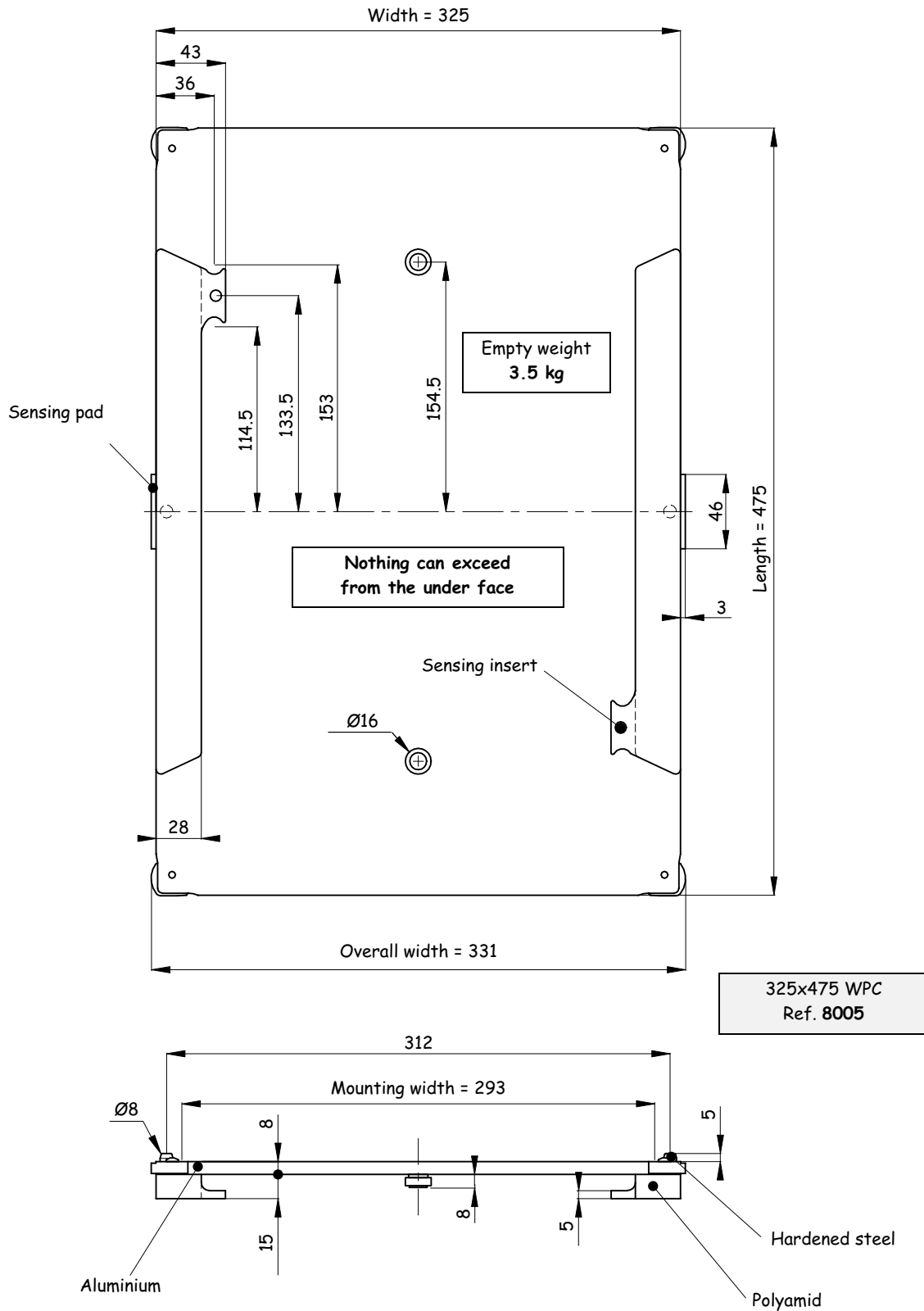
Workpiece carriers (WPC) are used to locate and transfer parts during the whole production and assembly cycle. Line 325 WPC are made of aluminium plate and polyamid pad and are equipped with ball bearings to ensure perfect guidance through curves and other functions.

For indexing, $\varnothing 8$ mm pins are provided and allow precise positioning in X, Y and Z axis within a +/- 0.03mm repeatability. Special contour features within the WPC pad ensures total immobilization at a stop position. Steel pads on either side allow sensing with conventional inductive sensors. Mechanical data processing can be provided as described in page 58.

Line 325 workpiece carriers (references **8004** and **8005**) can accommodate payloads up to **10kg**.



WPC plate is made of anodized aluminium. Flatness is better than 0.5mm. Detachable molded polyamid pads may be replaced easily. Friction coefficients are 0.25 (carrying) and 0.50 (accumulation).

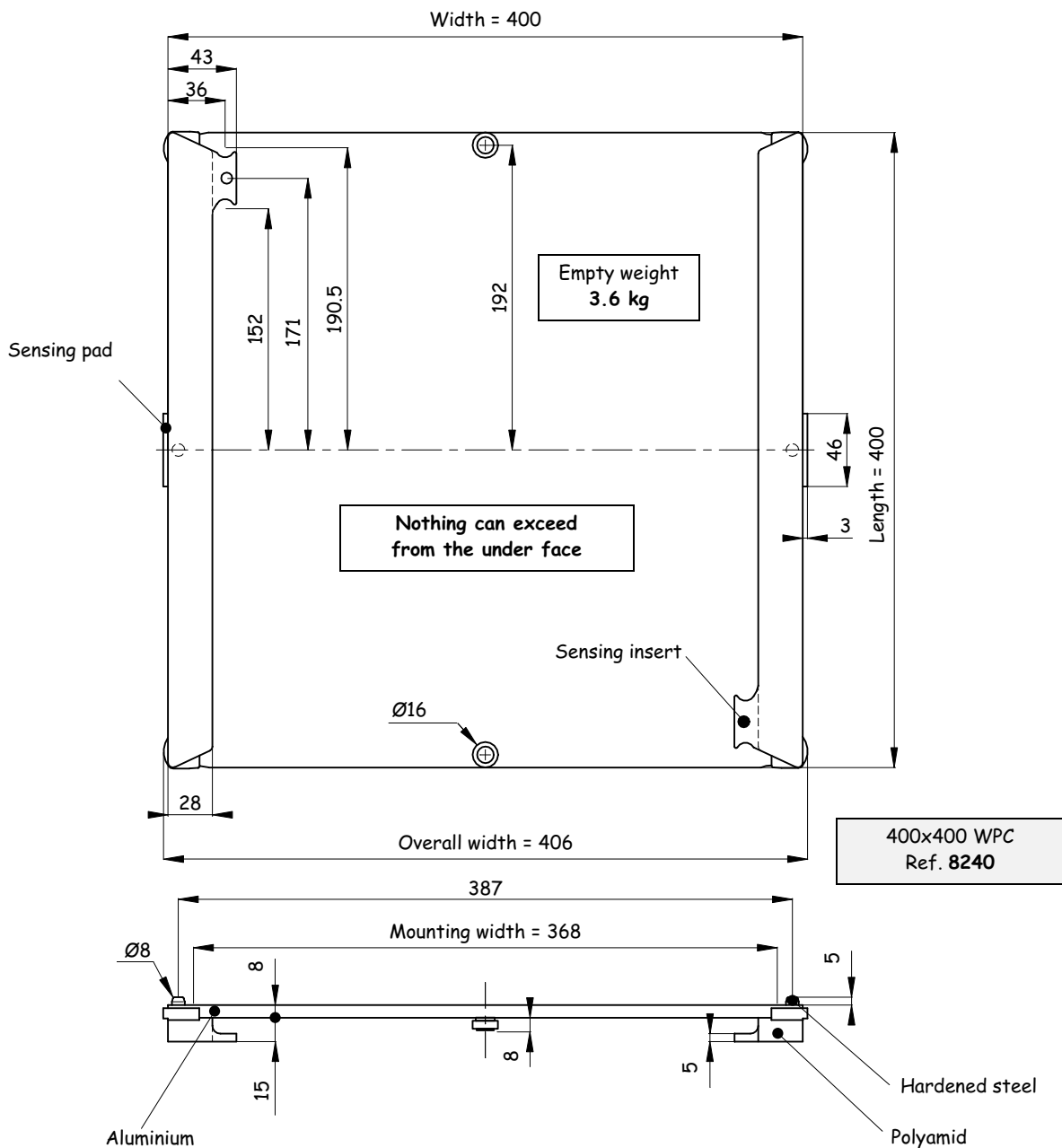


Workpiece carriers (WPC) are used to locate and transfer parts during the whole production and assembly cycle. Line 400 WPC is made of aluminium plate and polyamid pad and is equipped with ball bearings to ensure perfect guidance through curves and other functions.

For indexing, $\varnothing 8$ mm pins are provided and allow precise positioning in X, Y and Z axis within a +/- 0.03mm repeatability. Special contour features within the WPC pad ensures total immobilization at a stop position. Steel pads on either side allow sensing with conventional inductive sensors. Mechanical data processing can be provided as described in page 58.

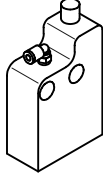

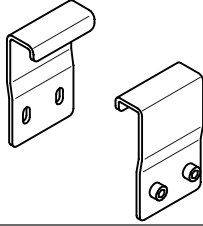
Line 400 workpiece carrier (reference **8240**) can accommodate payloads up to **10kg**.

WPC plate is made of anodized aluminium. Flatness is better than 0.5mm. Detachable molded polyamid pads may be replaced easily. Friction coefficients are 0.25 (carrying) and 0.50 (accumulation).

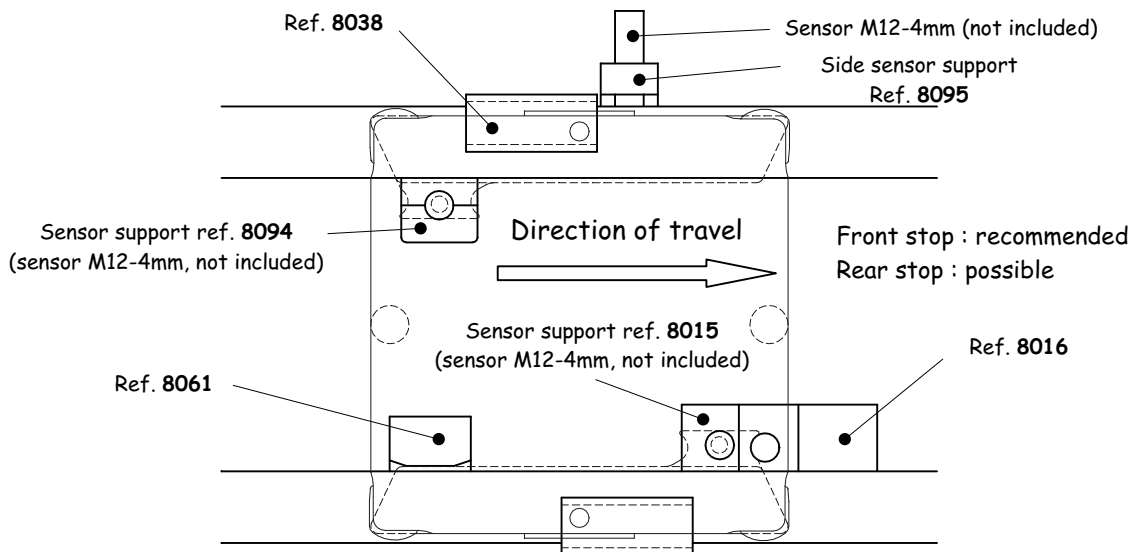


The stop unit 8016 provides a simple stop facility when precise positioning of the workpiece carrier is not necessary. The stop may also be used for flow control and prioritisation of workpiece carriers prior to and after « mobile » functions and precise station stops.


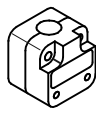
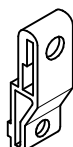
The pad 8061 improves the stop precision by limiting the WPC rotation and the efforts on side fuchsia guides. Its use is compulsory. When unloading pieces at manual workstations, the anti-lift kit 8038 prevents the operator from lifting of the WPC from the transfer line.

Stop	Pad	Anti-lift
		
Ref. 8016	Ref. 8061	Ref. 8038

- Stop
- stop capability 75kg
 - stop accuracy +/-0.3mm (with pad 8061)
 - cylinder Ø 25mm, single-acting
 - lubricated or not, cleaned air, 5 to 6 bars
 - connector for Ø 4mm pipe (provided)
 - acetal body, stainless steel plunger
 - sensing up/down positions : on request ref. 8014 (M8 sensors not included)

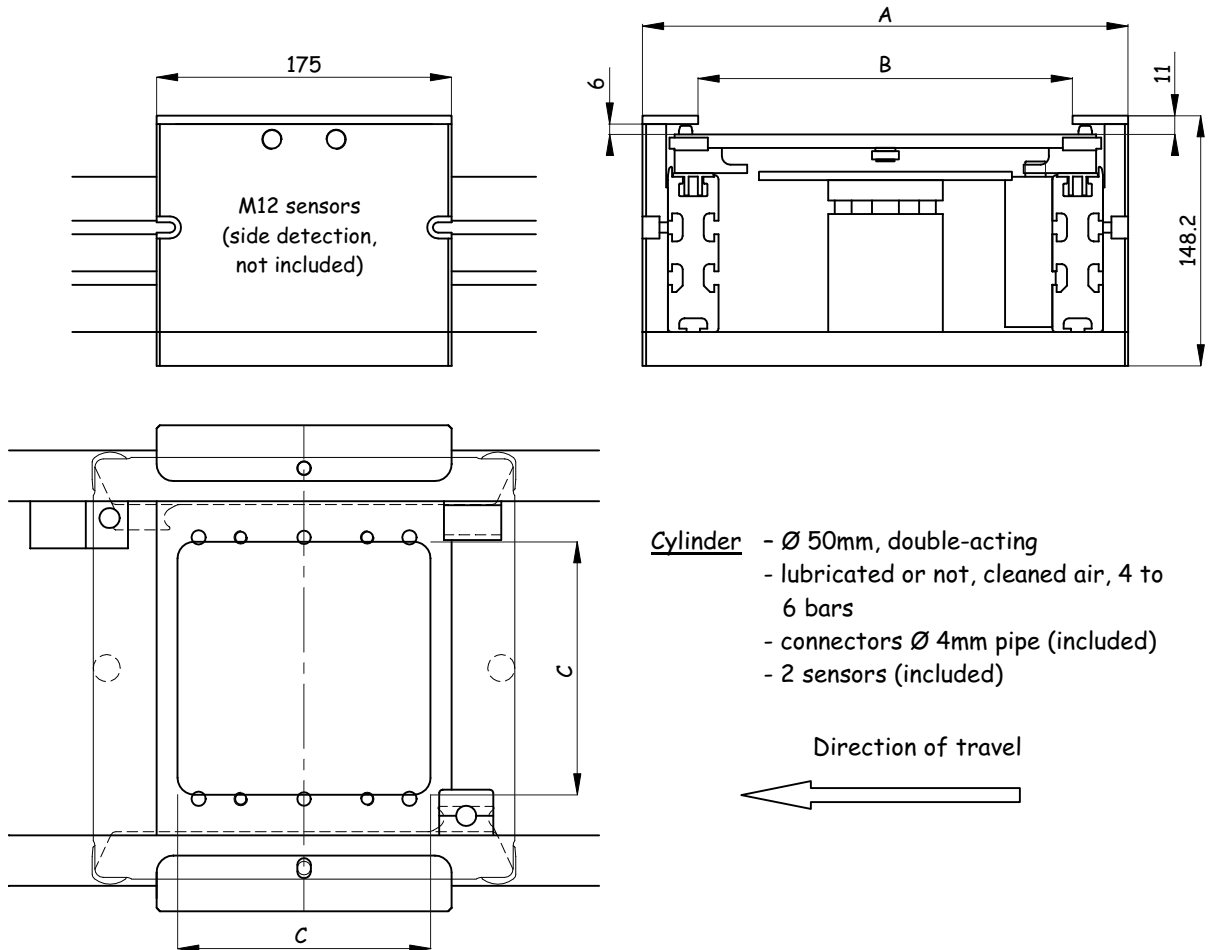


When stopping within a workstation, workpiece carriers may be detected using inductive sensors M12 (recommended span 4mm), with or without connectors, fitted to supports 8015, 8094 or 8095. These sensors also ensure flow and priority control.

Sensor supports		
on stop	under WPC	side
		
Ref. 8015	Ref. 8094	Ref. 8095

When a process requires precise positioning for the workpiece carriers, the 40kg positioning tool (6mm stroke) ensures a +/- 0.03mm XYZ repeatability. The positioning tool is manufactured from high grade aluminium. A double-acting pneumatic cylinder lifts and secures the workpiece carrier in hardened steel jaws. Two sensors fitted on the cylinder body ensure detection of up/down positions. Threads in the side of the positioning tool allow the use of M12 sensors (not included).

Vertical central available loading : 100kg. Provide for 2 stops 8016 and 2 pads 8061.



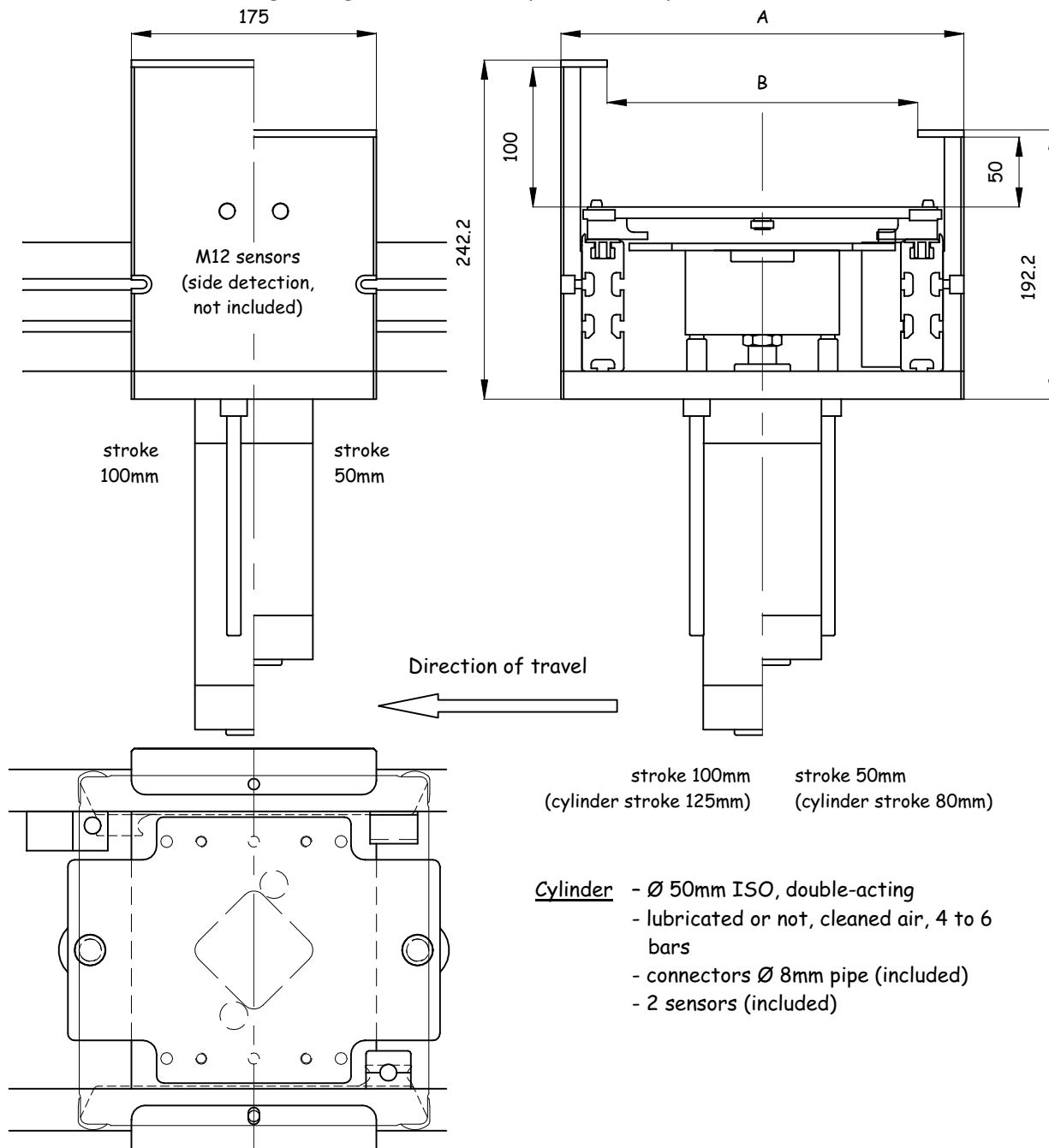
	Line 175	Line 250	Line 325	Line 400
Reference :	8417	8418	8419	8424
A (mm)	213	288	363	438
B (mm)	147	222	297	372
C (mm)	85	150	200	270

IMPORTANT

1. The positioning tool must be fitted to a stable and robust structure in order to ensure the accuracy of this function.
2. The positioning tool must be fully guarded once fitted.

The 50mm or 100mm stroke version of the 40kg positioning tool ensures a +/- 0.03mm XYZ repeatability. The positioning tool is manufactured from high grade aluminium. A double-acting pneumatic cylinder lifts and secures the workpiece carrier in hardened steel jaws. Two sensors fitted on the cylinder body ensure detection of up/down positions. Threads in the side of the positioning tool allow the use of M12 sensors (not included).

Vertical central available loading : 100kg. Provide for 2 stops 8016 and 2 pads 8061.



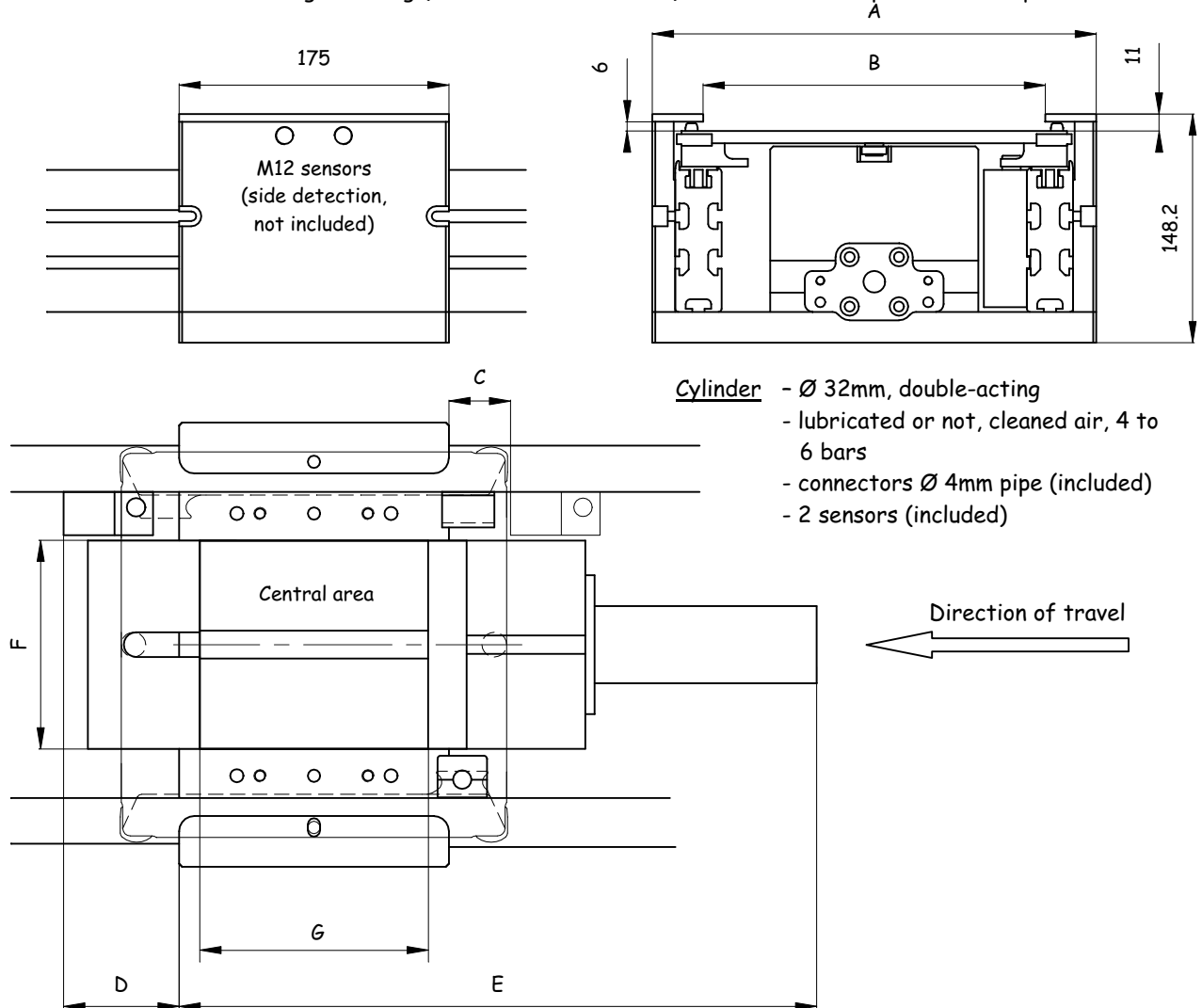
	Line 175	Line 250	Line 325	Line 400
Reference (stroke 50mm)	8117	8118	8119	8124
Reference (stroke 100mm)	8217	8218	8219	8224
A (mm)	213	288	363	438
B (mm)	147	222	297	372

IMPORTANT

1. The positioning tool must be fitted to a stable and robust structure in order to ensure the accuracy of this function.
2. The positioning tool must be fully guarded once fitted.

When a process requires precise positioning under strong efforts, the anvil positioning tool ensures a +/- 0.03mm XYZ repeatability. The positioning tool is manufactured from high grade aluminium. The lift mechanism is designed with synthetic material (reduced maintenance) and is actuated by a double-acting pneumatic. Two sensors fitted on the cylinder body ensure detection of up/down positions. Threads in the side of the positioning tool allow the use of M12 sensors (not included).

Vertical central available loading : 5000kg (irreversible mechanism). Provide for 2 stops 8016 and 2 pads 8061.

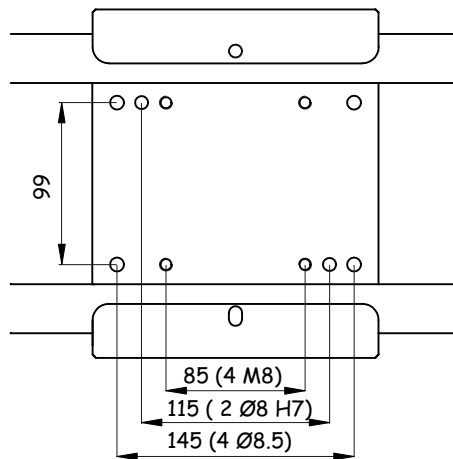


	Line 175	Line 250	Line 325	Line 400
Reference :	8020	8021	8022	8324
A (mm)	213	288	363	438
B (mm)	147	222	297	372
C (mm)	70	40	78	116
D (mm)	38	75	112.5	150
E (mm)	382		413.5	
F (mm)	75		130	
G (mm)	80		140	

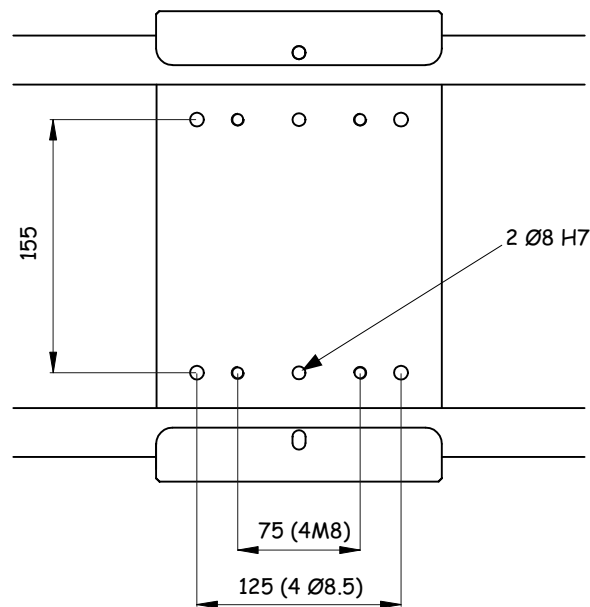
IMPORTANT

1. The positioning tool must be fitted to a stable and robust structure in order to ensure the accuracy of this function.
2. The positioning tool must be fully guarded once fitted.

General setting for 100Kg positioning tools **Line 175**.

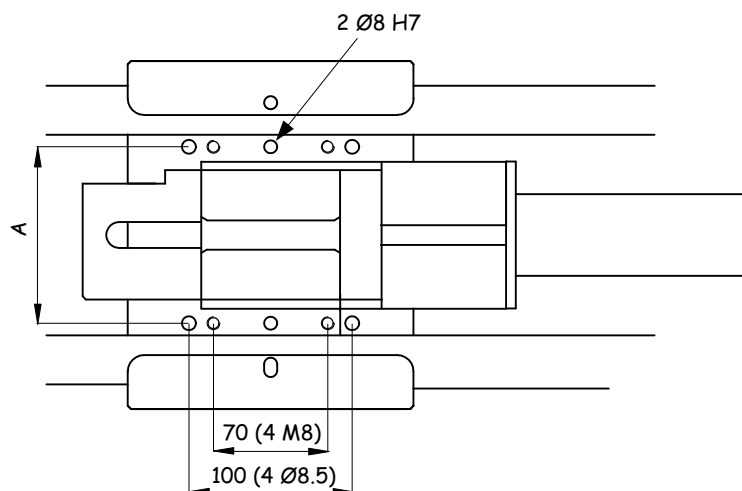


General setting for 100Kg positioning tools **Lines 175 to 400**.



General setting for anvil positioning tools **Lines 175 to 400**.

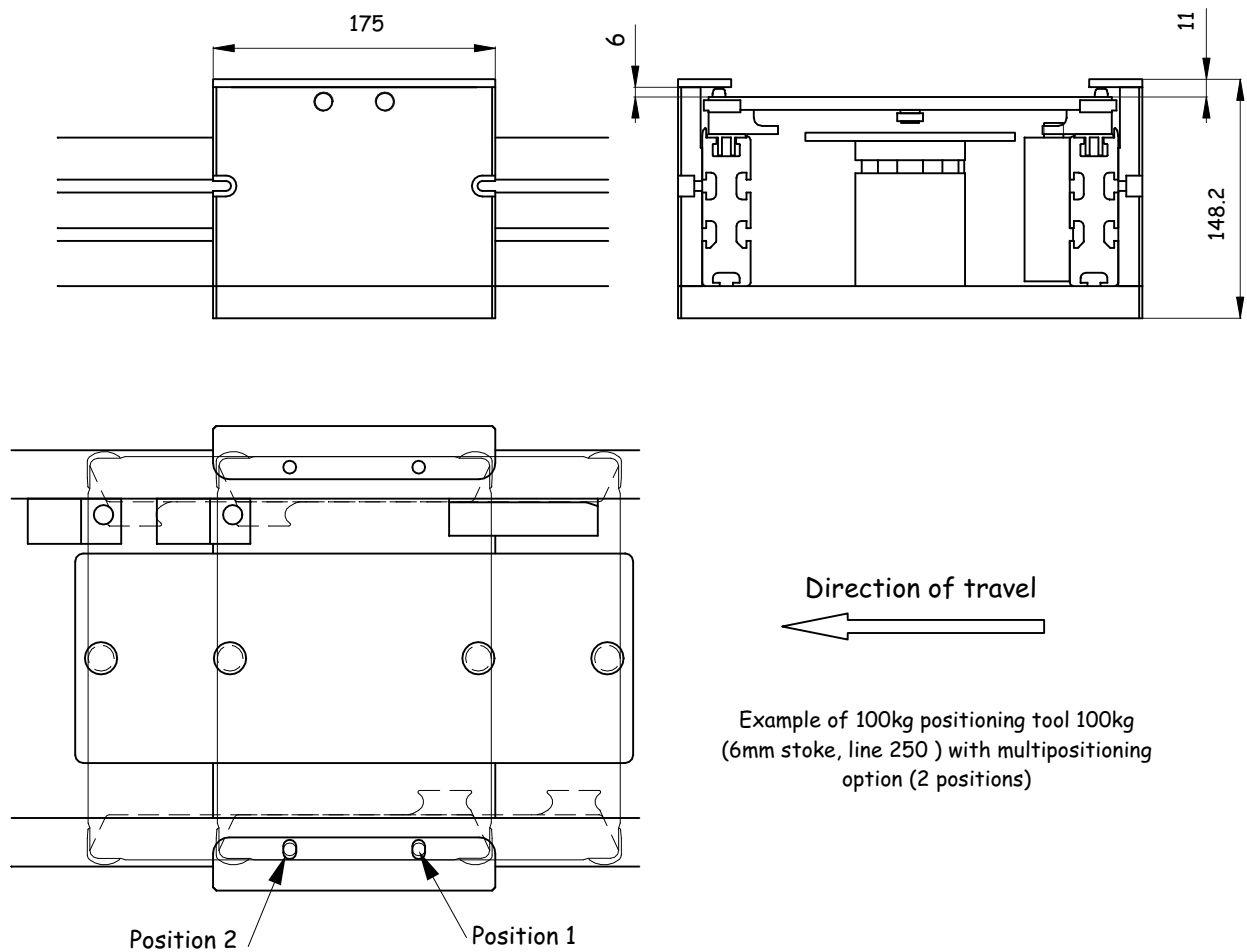
	A (mm)
Voie 175	108
Voie 250	170
Voie 325	
Voie 400	



Multipositioning tool

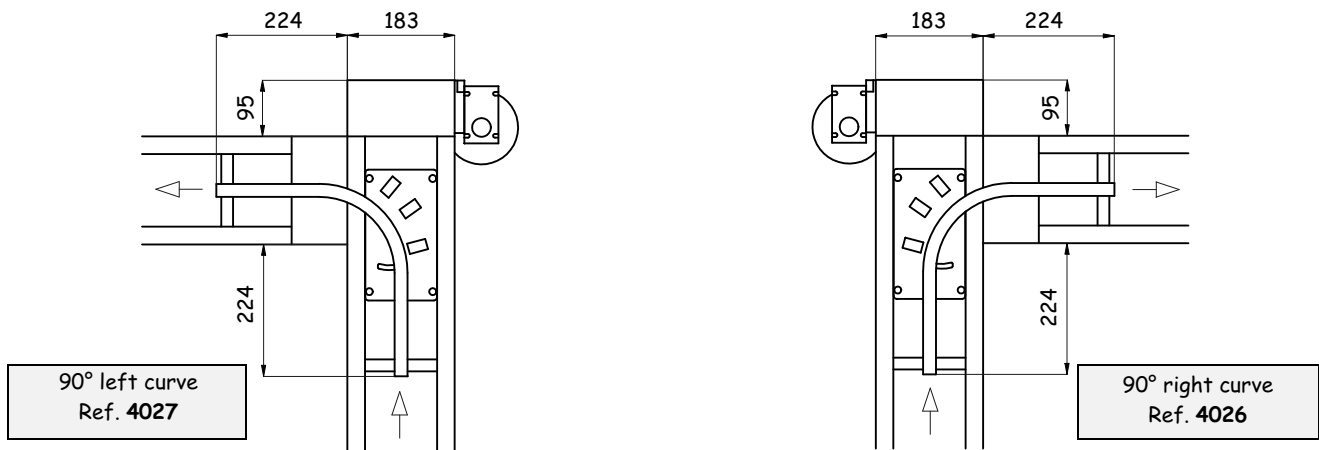
In order to reduce cycle times and to repeat an operation on the same workpiece carrier, 100kg and anvil positioning tools may receive special steel jaws for multiple indexing (2 or 3 positions).

This option is not available for line 100 and is quite difficult to apply to line 175. For lines 250 to 400, it requires a specific study, depending on the number of positions, span and workpiece carrier lifting and sensing.



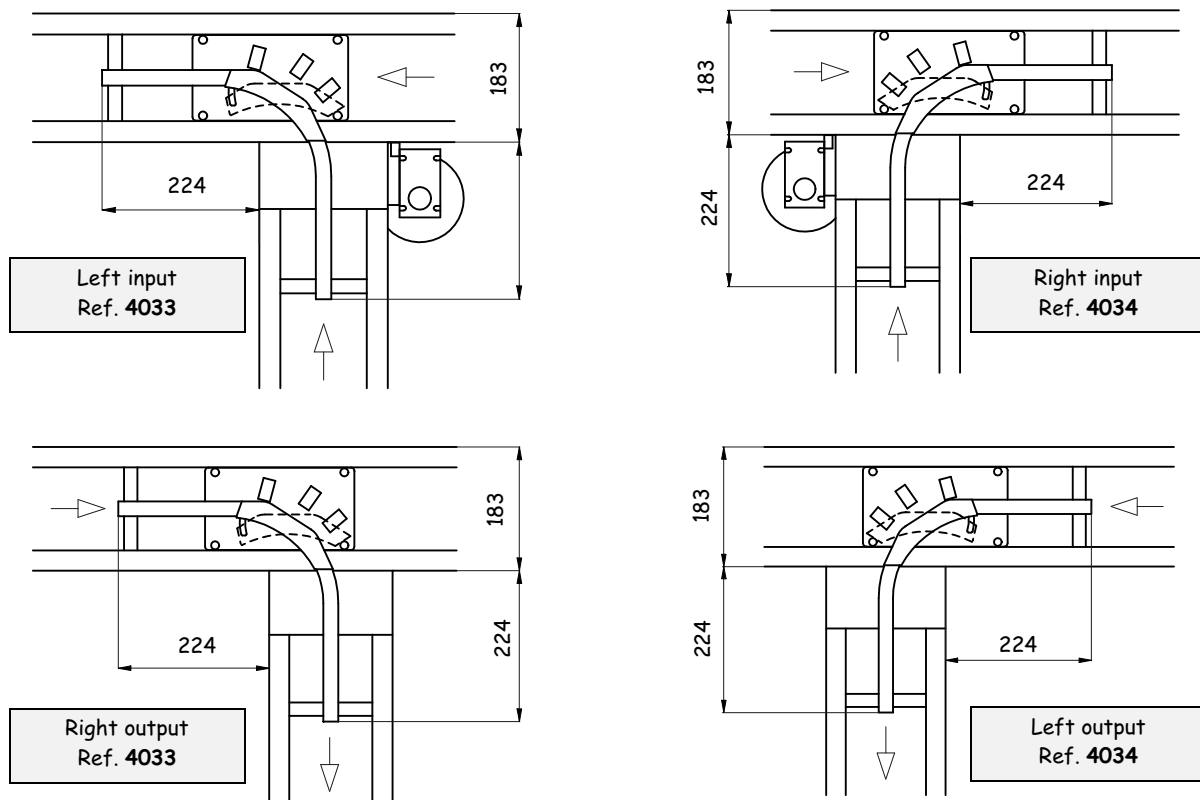
Using the 90° **static** curve, it is possible to cross from one section perpendicular to another. Two railwheels beneath the workpiece carriers ensure perfect guidance by fitting into a central 12x22 aluminium rail. Specially designed claws allow the bed plates to be fitted easily.

In this configuration, accumulation of workpiece carriers is possible. The small content of mechanical elements and features within the 90° curve results in high reliability.



The 90° curve **mobile** allows workpiece carriers to be introduced from a secondary section to a main one (« input ») or from a main section to a secondary one (« output »). Two railwheels beneath the workpiece carriers ensure perfect guidance by fitting into a central 12x22 aluminium rail.

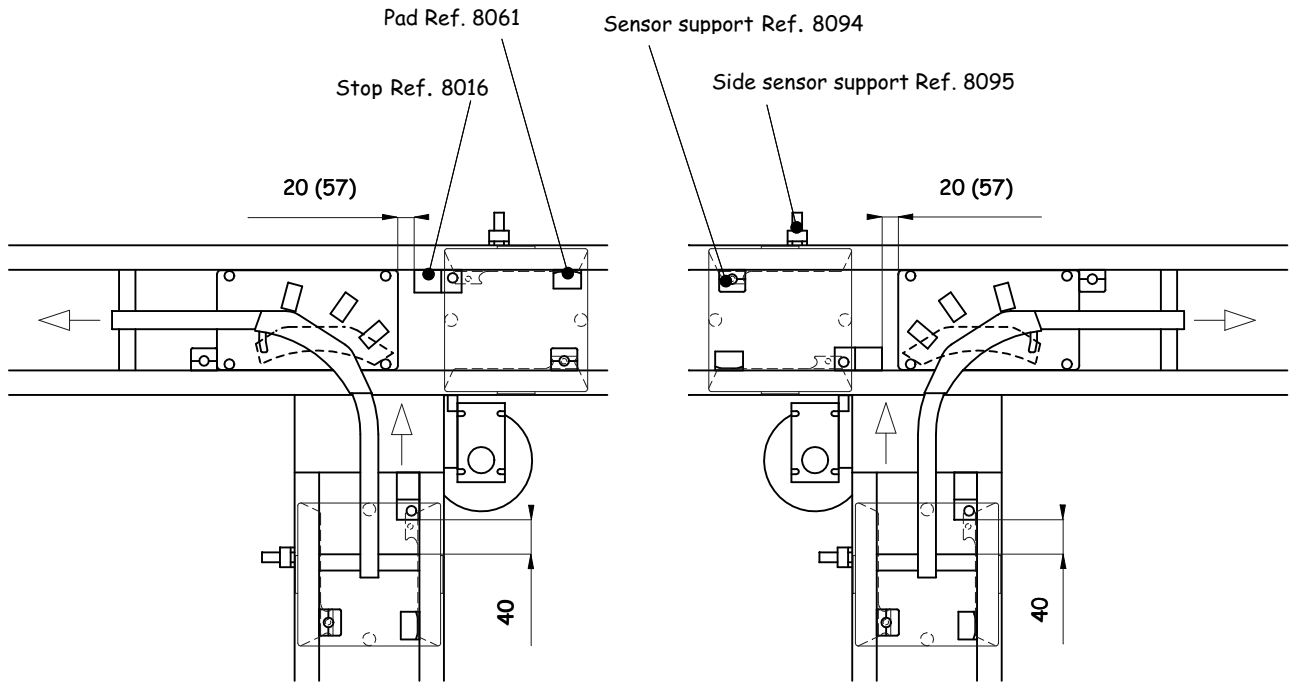
This function is « mobile » due to the swivel curved central rail. The 90° curve **mobile** presents a reduced flow-stoppage rate requiring minimum automation.



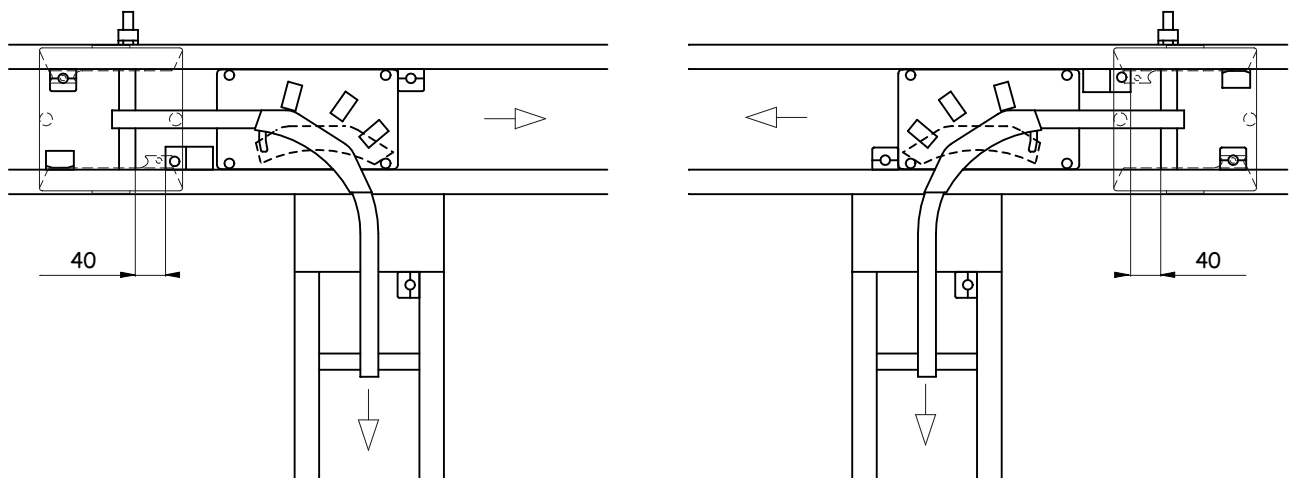
- Mobile rail cylinder**
- Ø 15mm, double-acting
 - lubricated or not, cleaned air, 5 to 6 bars
 - connectors for Ø 4mm pipe (included)
 - M8 sensors under mobile rail bearing (not included)

The minimum distance at which the workpiece carriers may be stopped in relationship to the curve is shown in the drawings below. Both 175x175 and 175x250 workpiece carriers are concerned.

Similarly, to chain up 90° curves (static or mobile), it is compulsory to take care of minimal space as shown in page 57.

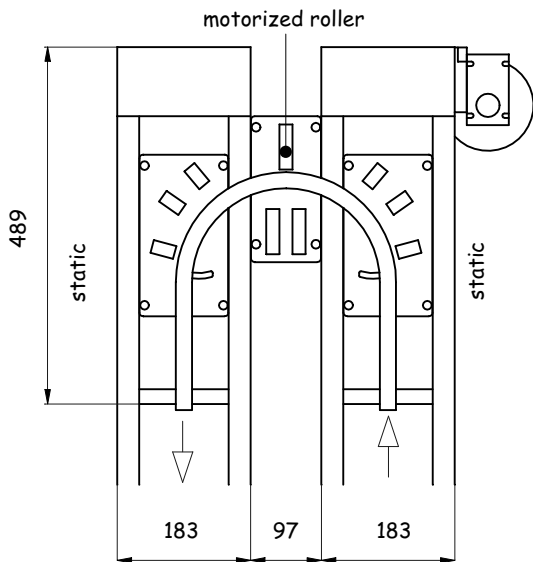


() : 175x250 WPC

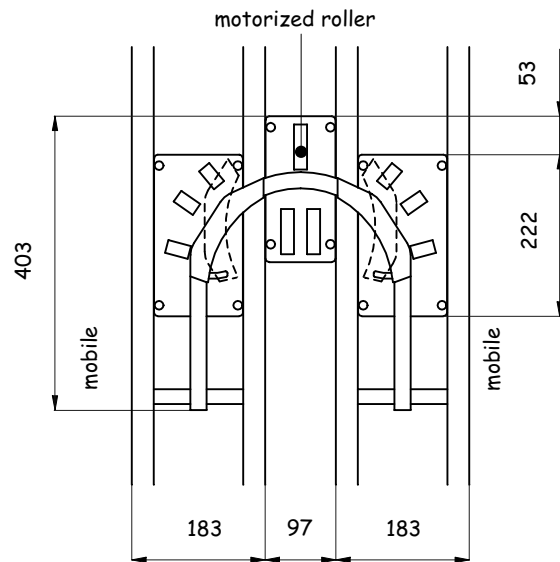


Using the 180° curve, it is possible to cross from one section in parallel to another operating in the opposite direction. Four combinations cover all possible configurations. This function is « mobile » due to the swivel curved central rail. In the « static/static » curve, accumulation of workpiece carriers is possible. The bed plate between the sections (« middle bed plate ») is equipped with a motorized roller to aid workpiece carriers through the curve.

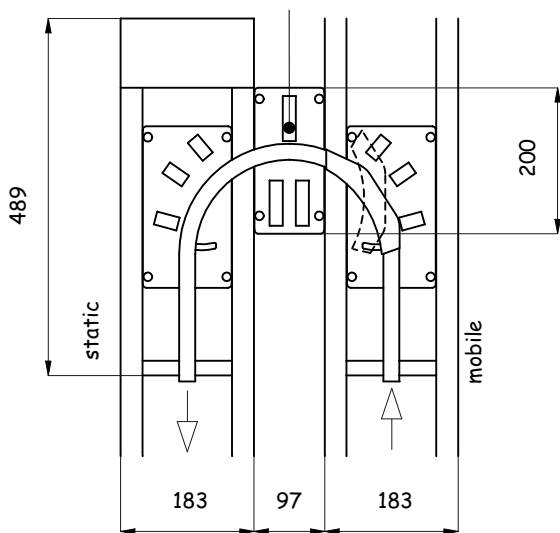
Ref. 4064 (static/static)



Ref. 4073 (mobile/mobile)

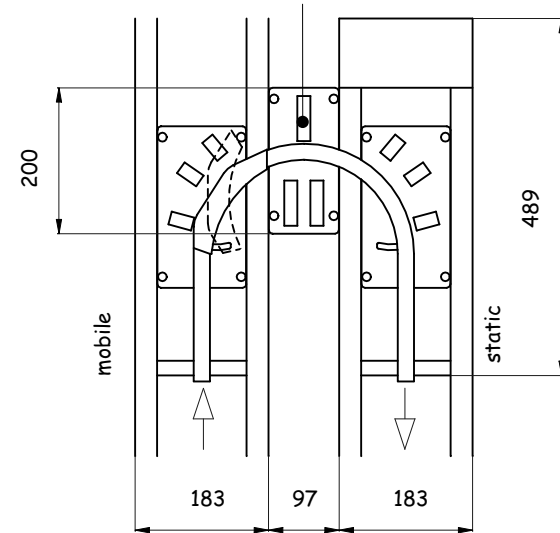


Ref. 4067 (static/mobile)



Ref. 4067 (static/mobile)

Ref. 4068 (mobile/static)



Ref. 4068 (mobile/static)

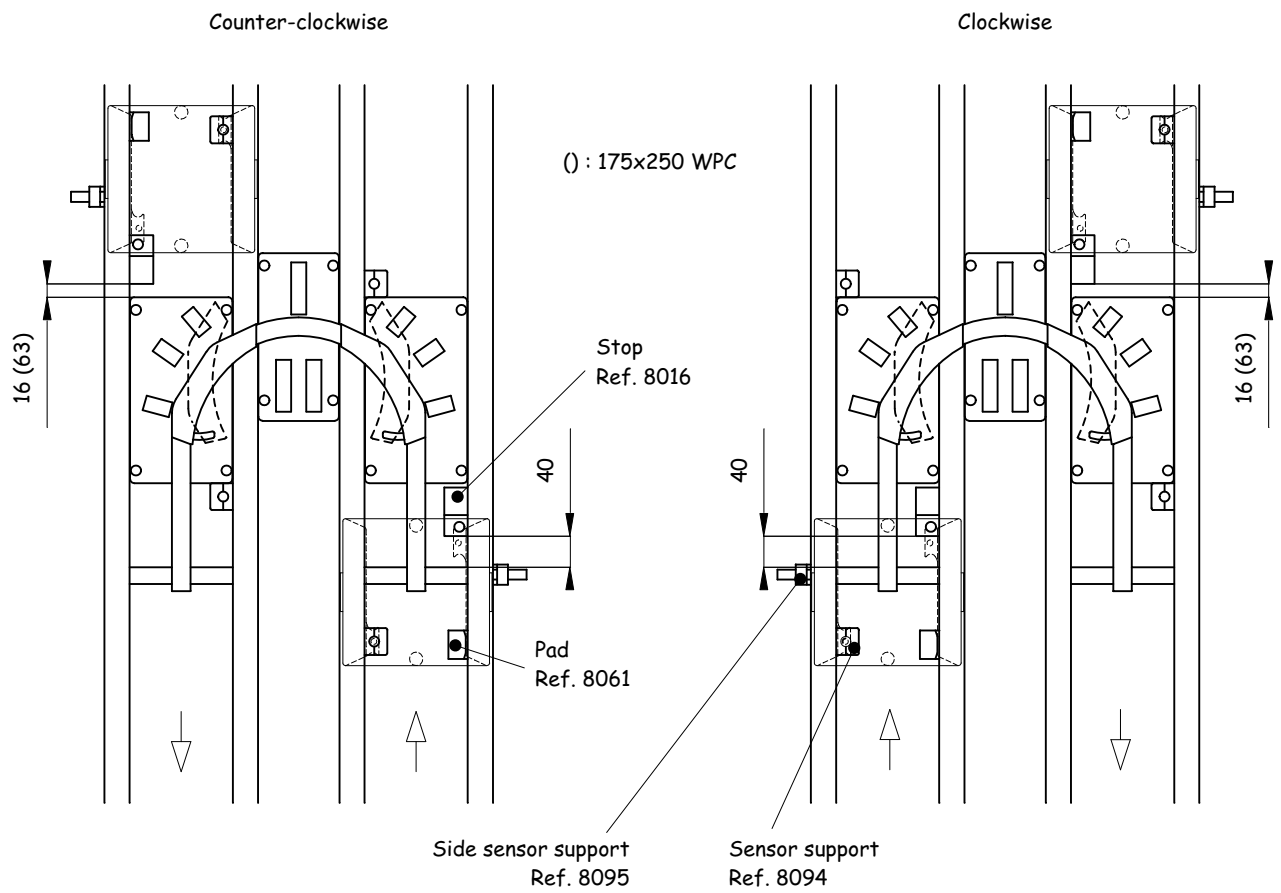
Mobile rail cylinder

- Ø 15mm, double-acting
- lubricated or not, cleaned air, 5 to 6 bars
- connectors for Ø 4mm pipe (included)
- M8 sensors under mobile rail bearing (not included)

Motorized roller motor

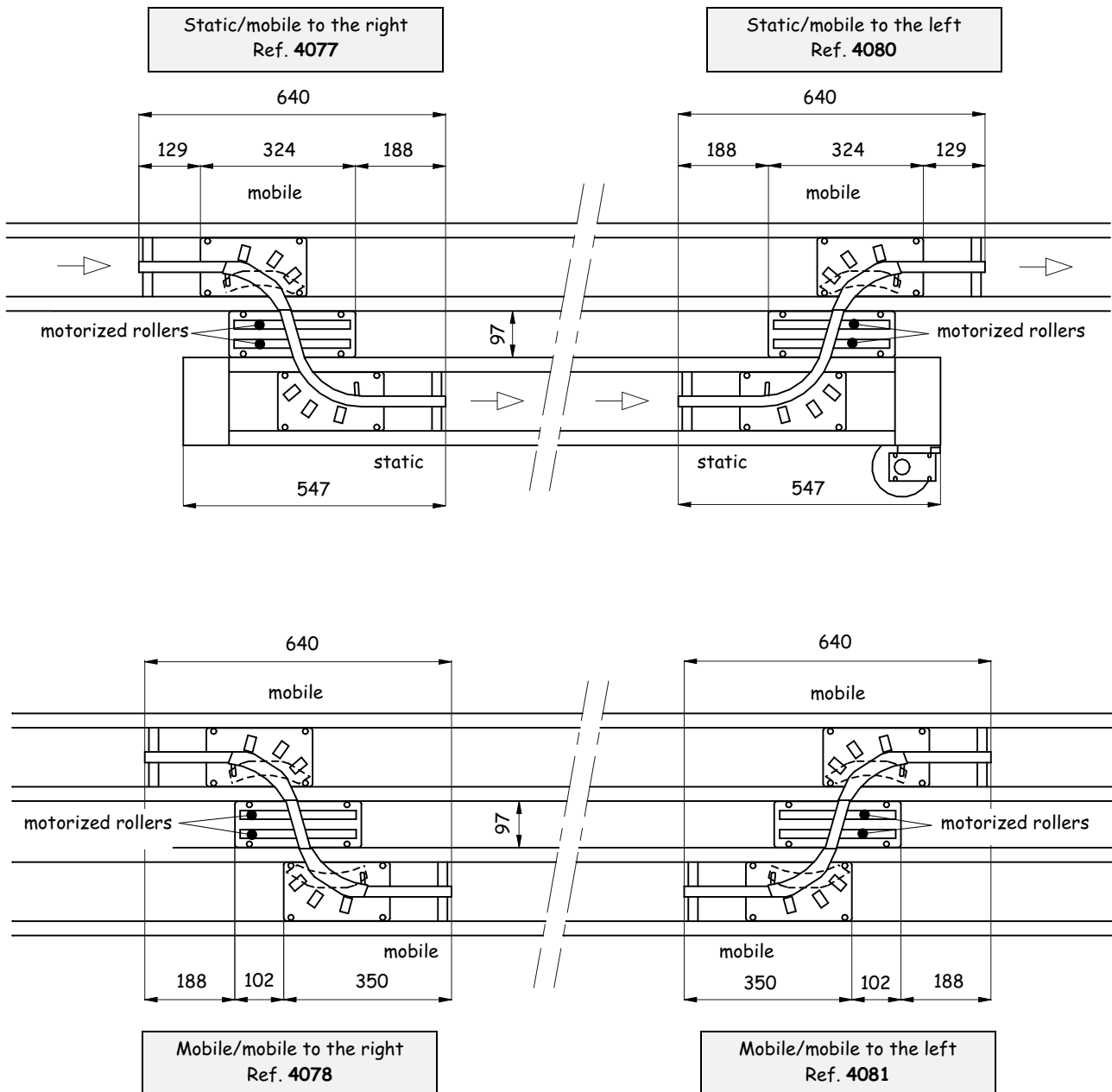
- power 6.3W
- voltage 220V single-phase
- frequency 50Hz
- rated current 73mA

The minimum distance at which the workpiece carriers may be stopped in relationship to the curve is shown in the drawings below. Both 175x175 and 175x250 workpiece carriers are concerned.



The function of the input/output combination is adapted to transfer workpiece carriers from one section to another operating in parallel and running in the same direction.

This function is « mobile » due to the swivel curved 12x22 rail. The bed plate between the sections (« middle bed plate ») is equipped with two motorized rollers (driven by only one motor) to aid workpiece carriers through the transfer sections.



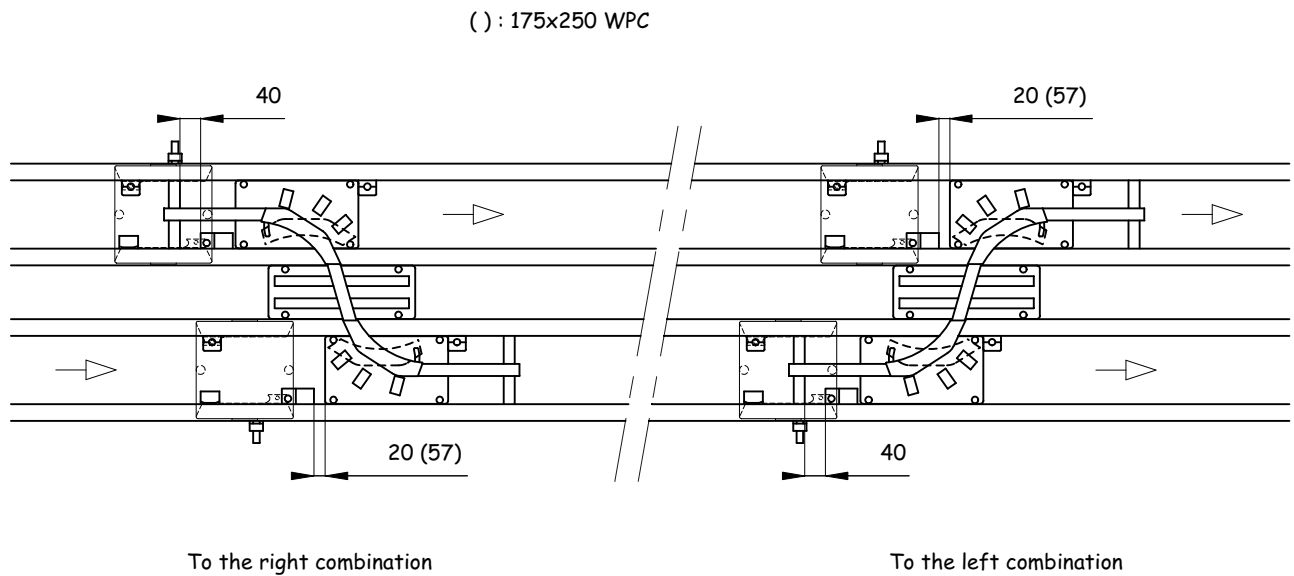
Mobile rail cylinder

- Ø 15mm, double-acting
- lubricated or not, cleaned air, 5 to 6 bars
- connectors for Ø 4mm pipe (included)
- M8 sensors under mobile rail bearing (not included)

Motorized roller motor

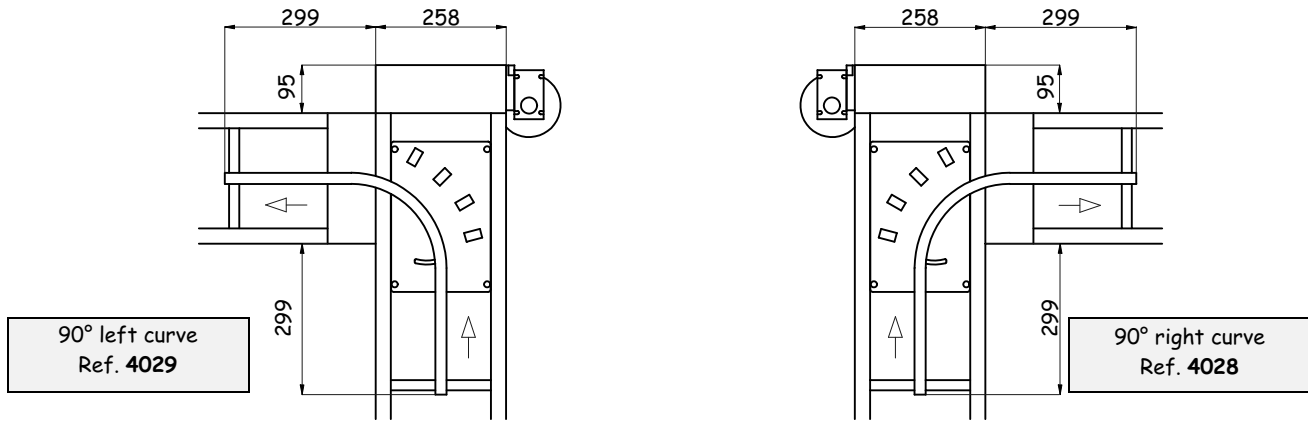
- power 6.3W
- voltage 220V single-phase
- frequency 50Hz
- rated current 73mA

The minimum distance at which the workpiece carriers may be stopped in relationship to the combination is shown in the drawings below.



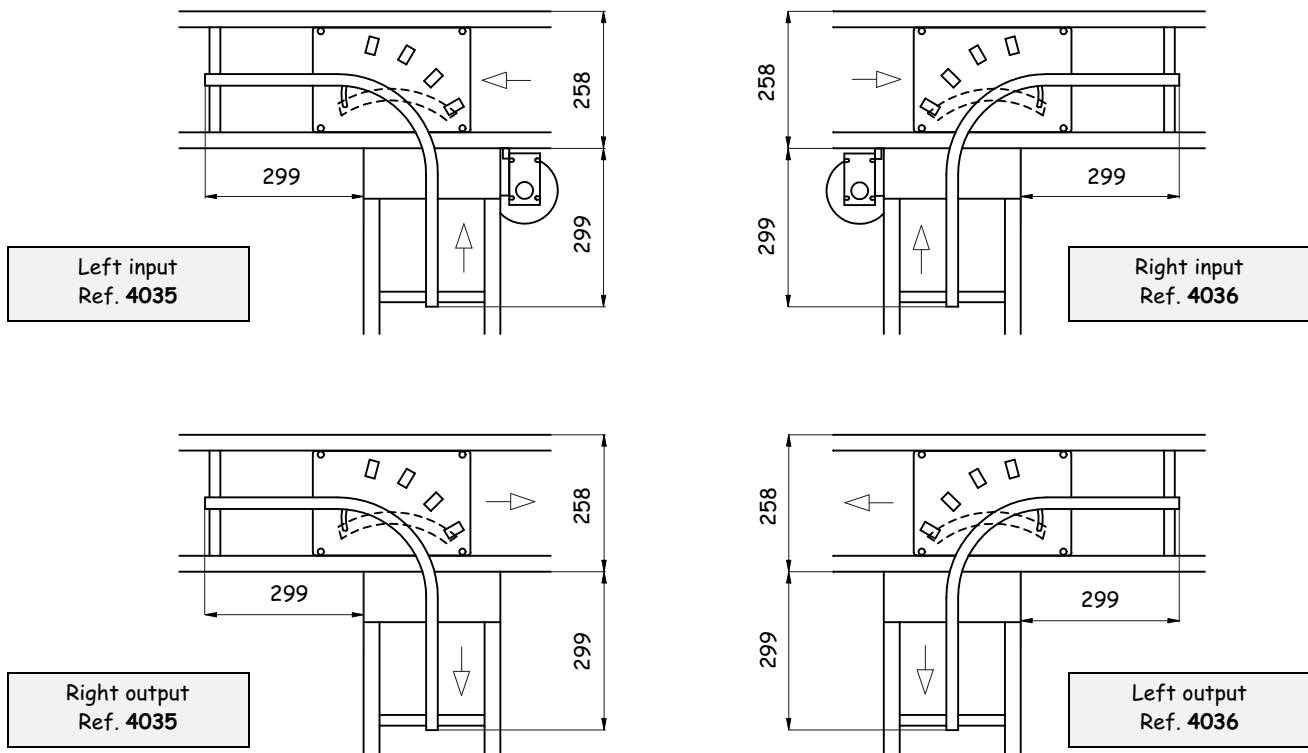
Using the 90° **static** curve, it is possible to cross from one section perpendicular to another. Two railwheels beneath the workpiece carriers ensure perfect guidance by fitting into a central 12x22 aluminium rail. Specially designed claws allow the bed plates to be fitted easily.

In this configuration, accumulation of workpiece carriers is possible. The small content of mechanical elements and features within the 90° curve results in high reliability.



The 90° curve **mobile** allows workpiece carriers to be introduced from a secondary section to a main one (« input ») or from a main section to a secondary one (« output »). Two railwheels beneath the workpiece carriers ensure perfect guidance by fitting into a central 12x22 aluminium rail.

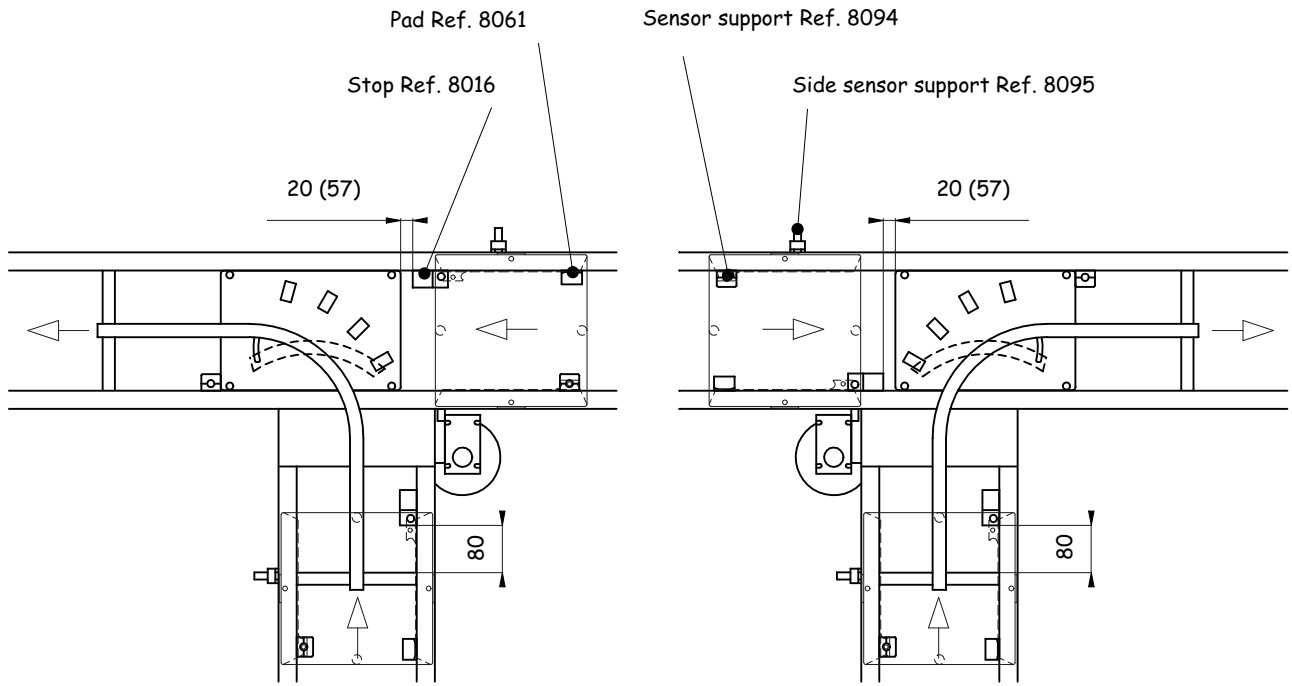
This function is « mobile » due to the swivel curved central rail. The 90° curve **mobile** presents a reduced flow-stoppage rate requiring minimum automation.



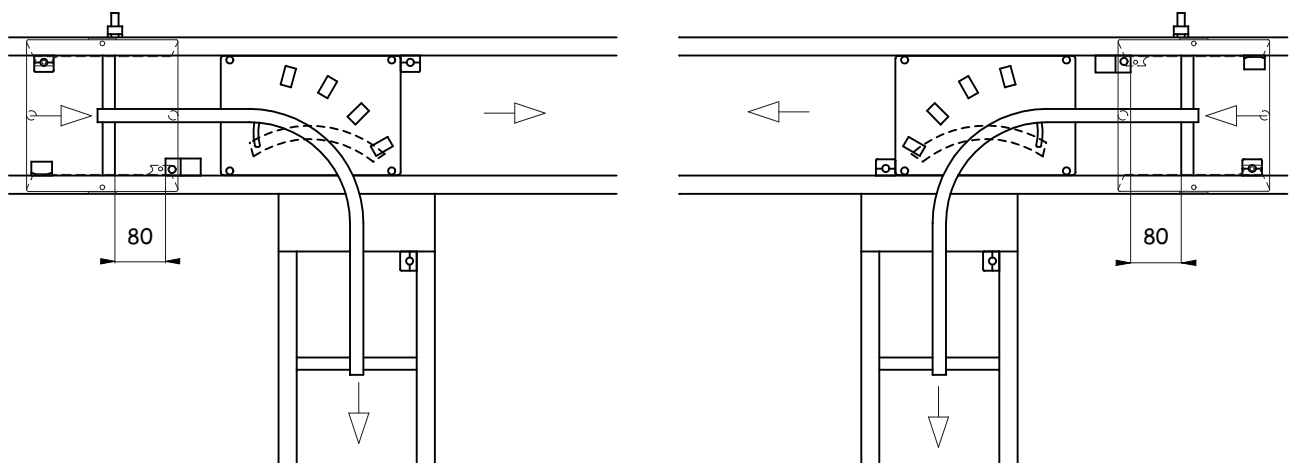
- Mobile rail cylinder**
- Ø 15mm, double-acting
 - lubricated or not, cleaned air, 5 to 6 bars
 - connectors for Ø 4mm pipe (included)
 - M8 sensors under mobile rail bearing (not included)

The minimum distance at which the workpiece carriers may be stopped in relationship to the curve is shown in the drawings below. Both 250x250 and 250x325 workpiece carriers are concerned.

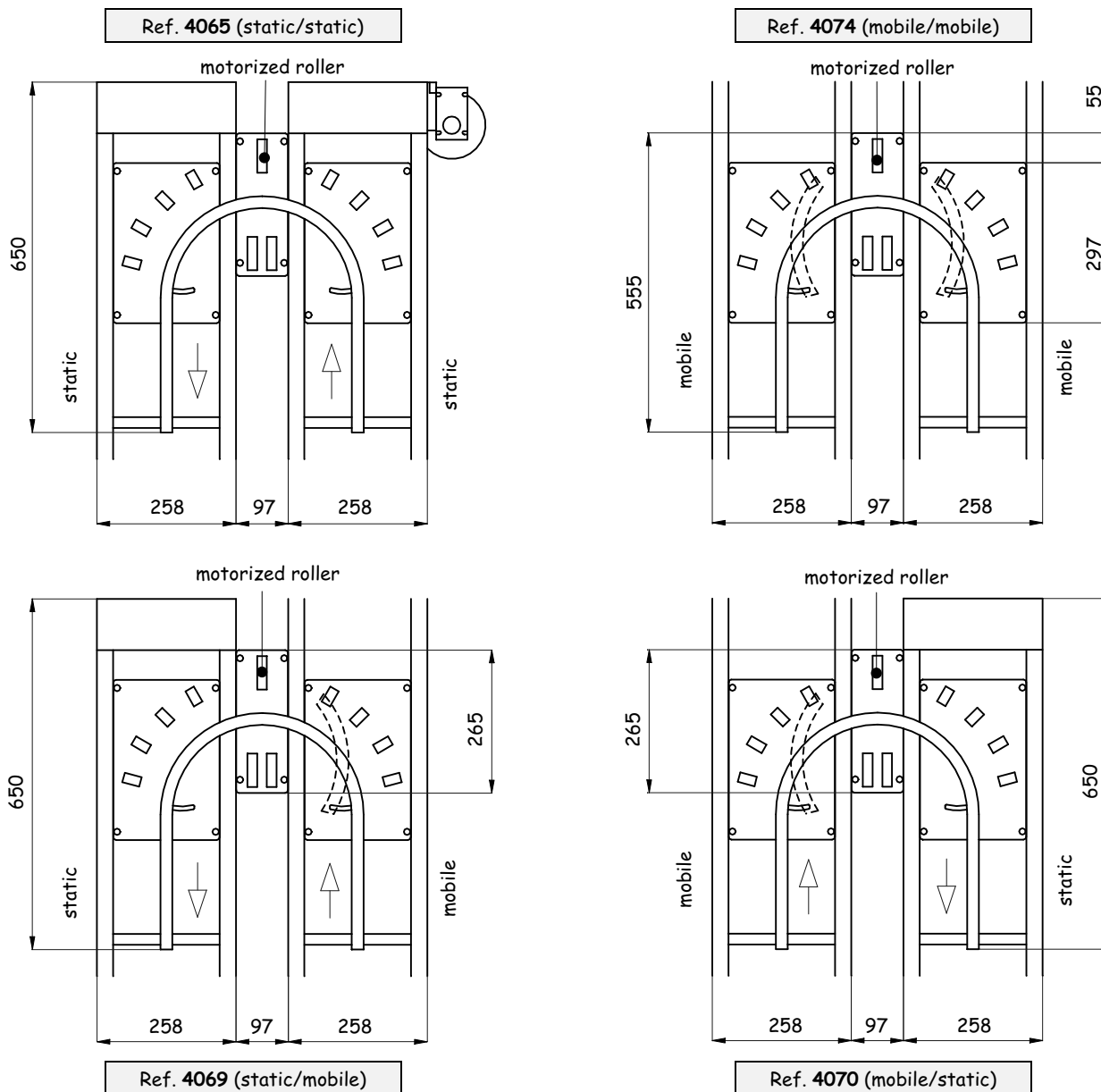
Similarly, to chain up 90° curves (static or mobile), it is compulsory to take care of minimal space as shown in page 57.



() : 250x325 WPC



Using the 180° curve, it is possible to cross from one section in parallel to another operating in the opposite direction. Four combinations cover all possible configurations. This function is « mobile » due to the swivel curved central rail. In the « static/static » curve, accumulation of workpiece carriers is possible. The bed plate between the sections (« middle bed plate ») is equipped with a motorized roller to aid workpiece carriers through the curve.



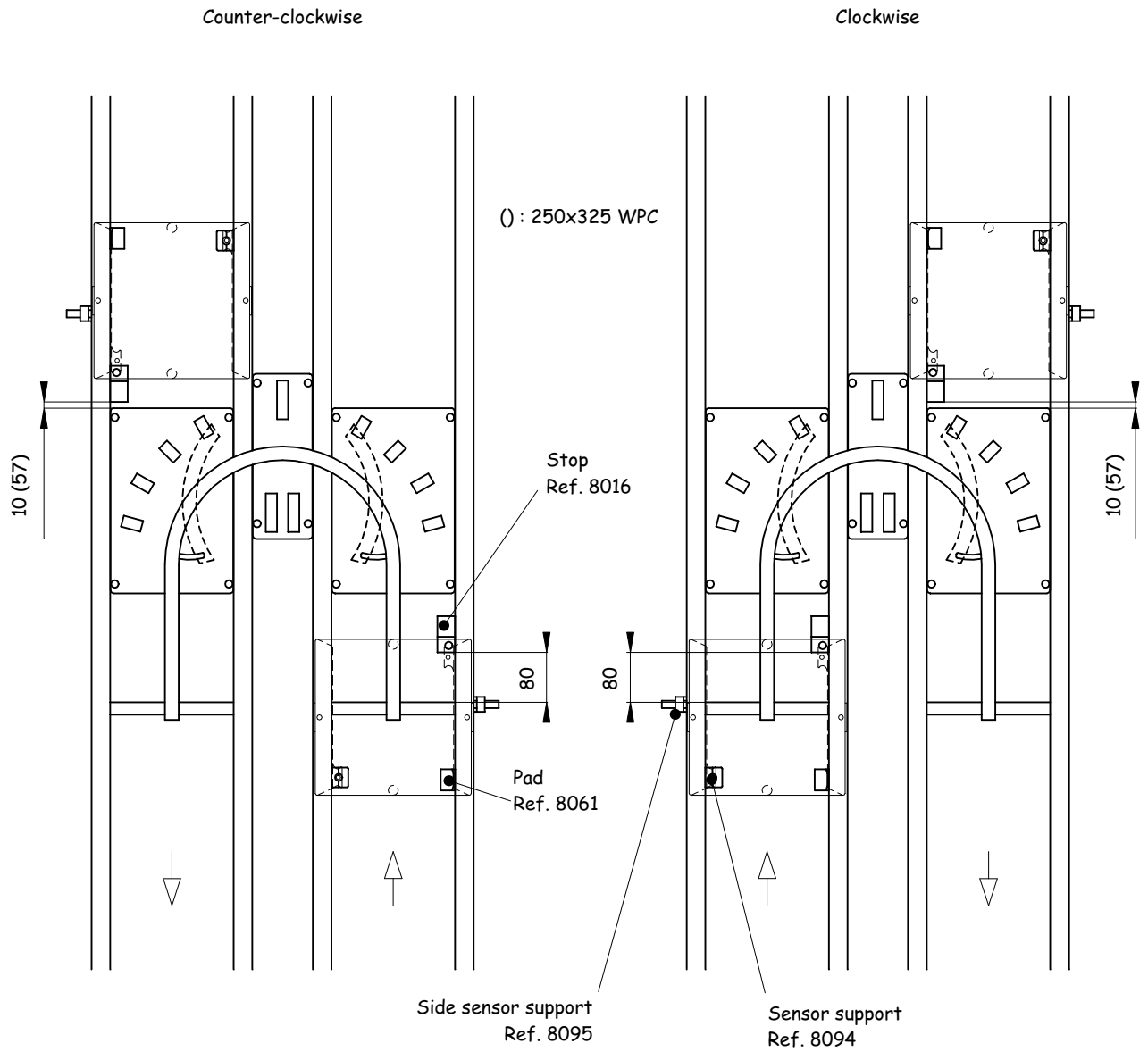
Mobile rail cylinder

- Ø 15mm, double-acting
- lubricated or not, cleaned air, 5 to 6 bars
- connectors for Ø 4mm pipe (included)
- M8 sensors under mobile rail bearing (not included)

Motorized roller motor

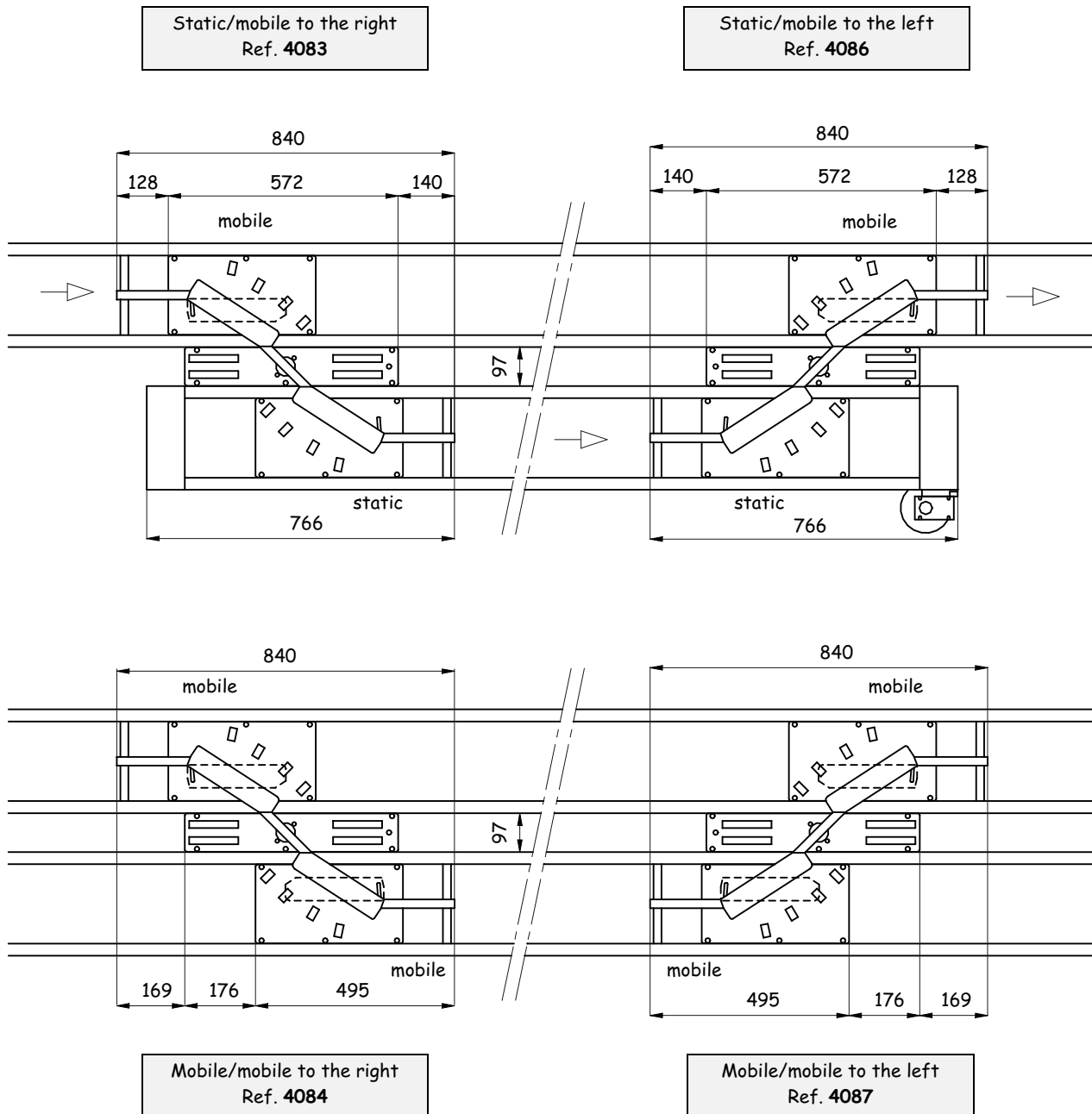
- power 6.3W
- voltage 220V single-phase
- frequency 50Hz
- rated current 73mA

The minimum distance at which the workpiece carriers may be stopped in relationship to the curve is shown in the drawings below. Both 250x250 and 250x325 workpiece carriers are concerned.



The function of the input/output combination is adapted to transfer workpiece carriers from one section to another operating in parallel and running in the same direction.

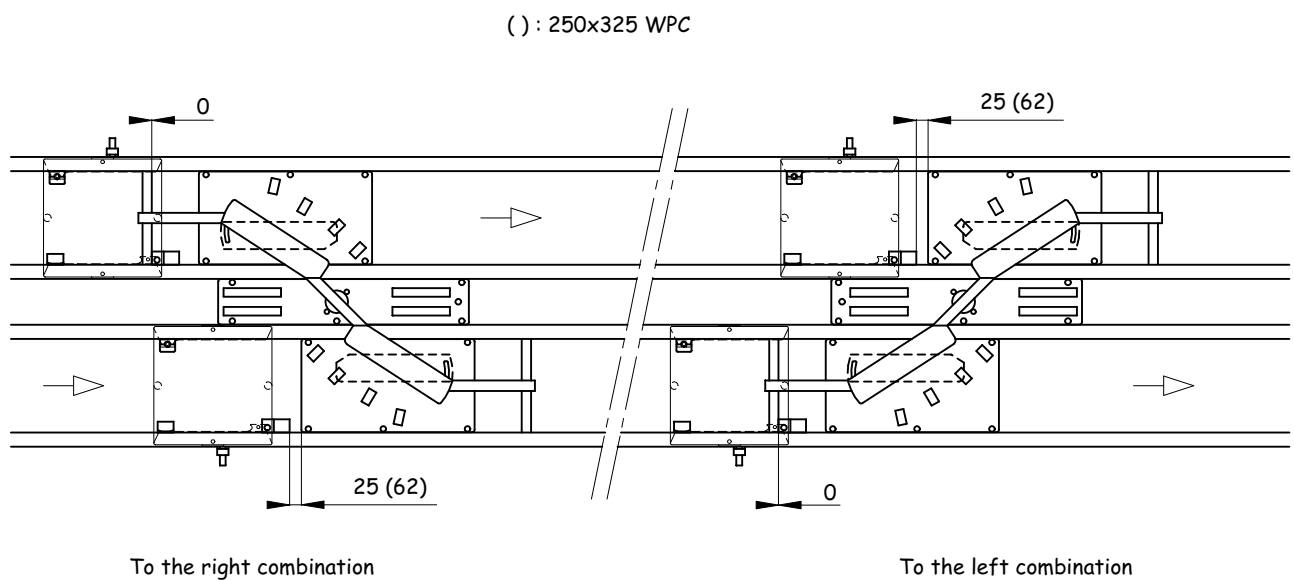
This function is « mobile » due to the swivel curved 12x22 rail.



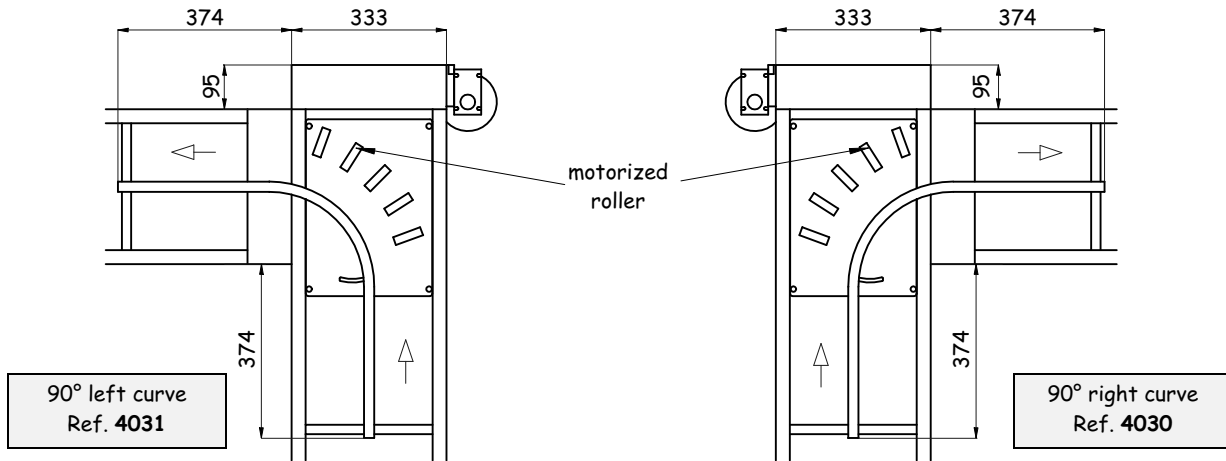
Mobile rail cylinder

- Ø 15mm, double-acting
- lubricated or not, cleaned air, 5 to 6 bars
- connectors for Ø 4mm pipe (included)
- M8 sensors under mobile rail bearing (not included)

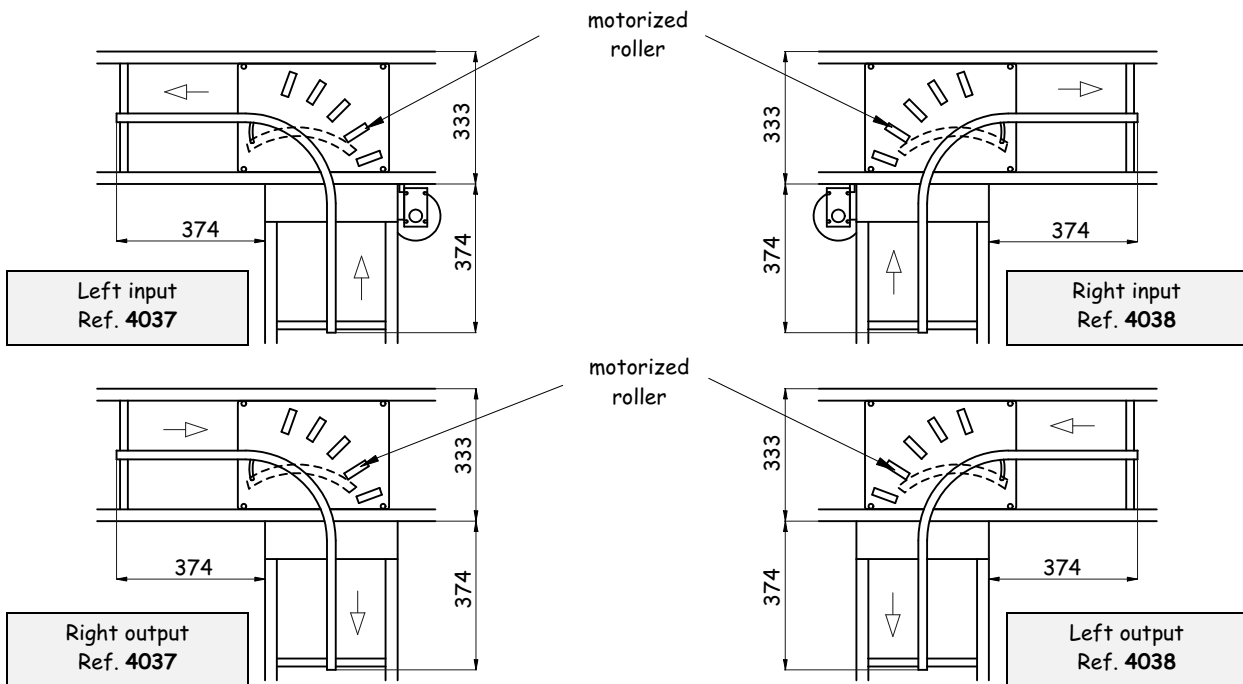
The minimum distance at which the workpiece carriers may be stopped in relationship to the combination is shown in the drawings below.



Using the 90° **static** curve, it is possible to cross from one section perpendicular to another. Two railwheels beneath the workpiece carriers ensure perfect guidance by fitting into a central 12x22 aluminium rail. Specially designed claws allow the bed plates to be fitted easily. The bed plate is equipped with a motorized roller to aid workpiece carrier through the curve. In this configuration, accumulation of workpiece carriers is possible. The small content of mechanical elements and features within the 90° curve results in high reliability.



The 90° curve **mobile** allows workpiece carriers to be introduced from a secondary section to a main one (« input ») or from a main section to a secondary one (« output »). Two railwheels beneath the workpiece carriers ensure perfect guidance by fitting into a central 12x22 aluminium rail. The bed plate is equipped with a motorized roller to aid workpiece carrier through the curve. This function is « mobile » due to the swivel curved central rail. The 90° curve **mobile** presents a reduced flow-stoppage rate requiring minimum automation.



Mobile rail cylinder

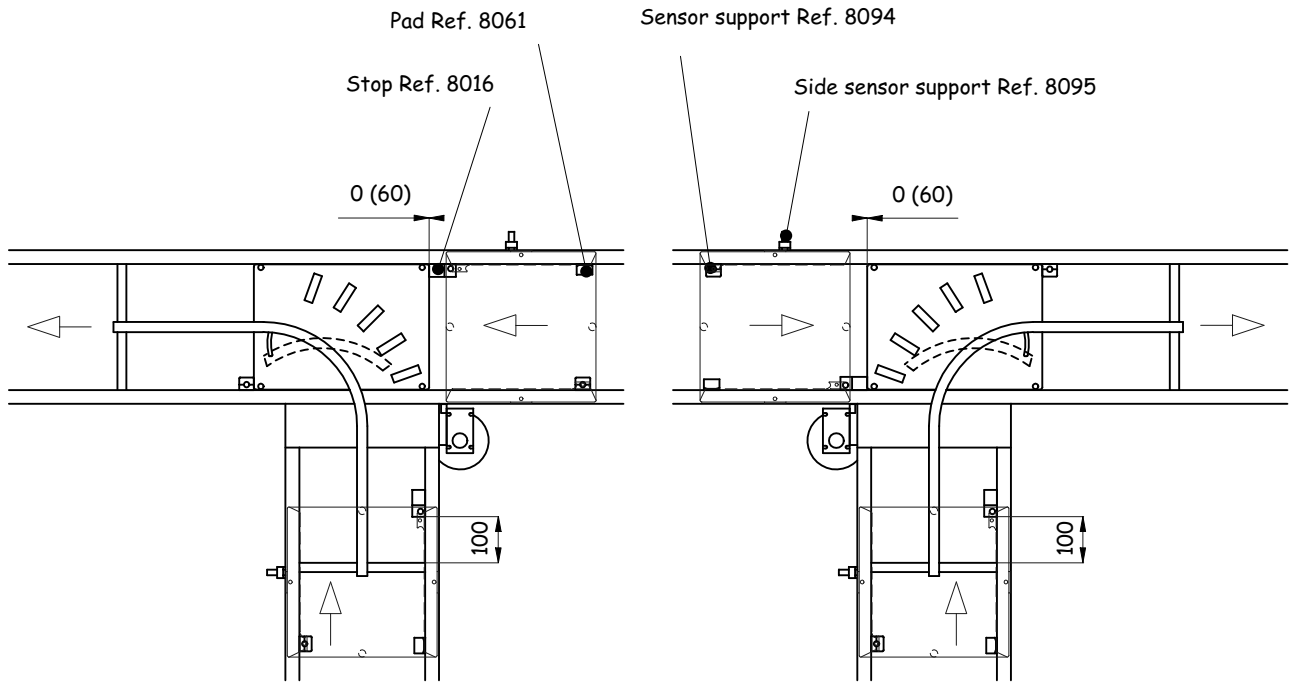
- Ø 15mm, double-acting
- lubricated or not, cleaned air, 5 to 6 bars
- connectors for Ø 4mm pipe (included)
- M8 sensors under mobile rail bearing (not included)

Motorized roller motor

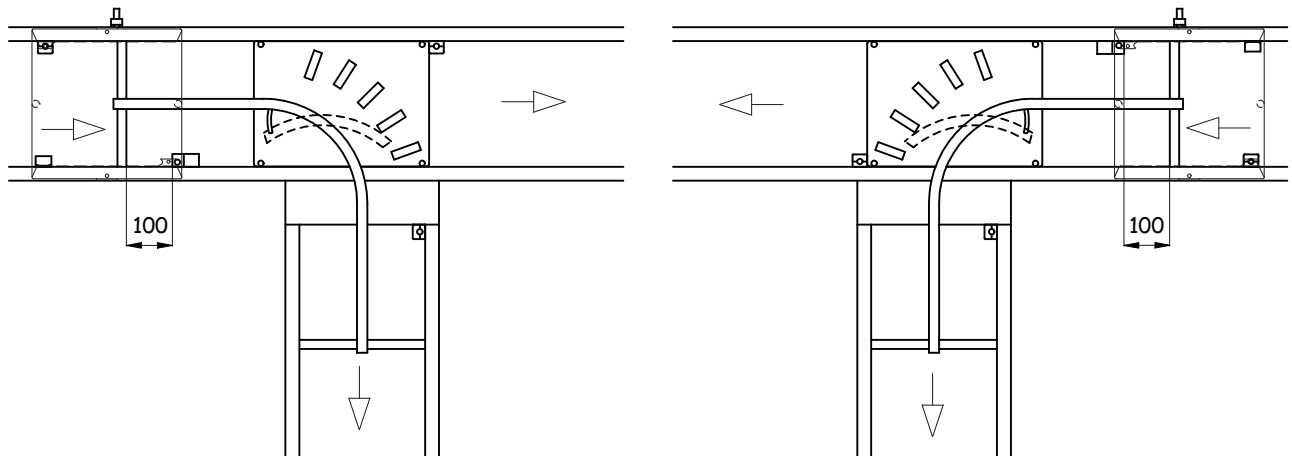
- power 6.3W
- frequency 50Hz
- voltage 220V single-phase
- rated current 73mA

The minimum distance at which the workpiece carriers may be stopped in relationship to the curve is shown in the drawings below. Both 325x325 and 325x475 workpiece carriers are concerned.

Similarly, to chain up 90° curves (static or mobile), it is compulsory to take care of minimal space as shown in page 57.

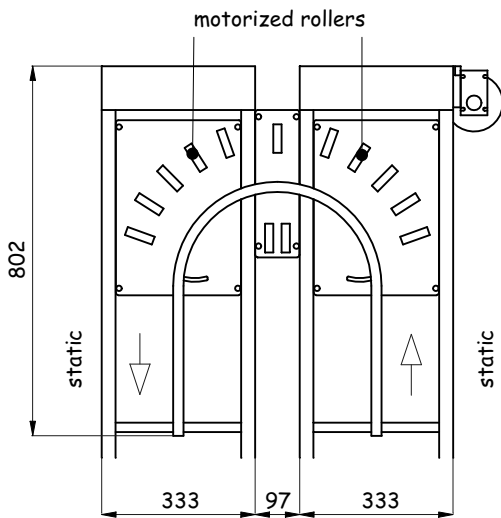


() : 325x475 WPC

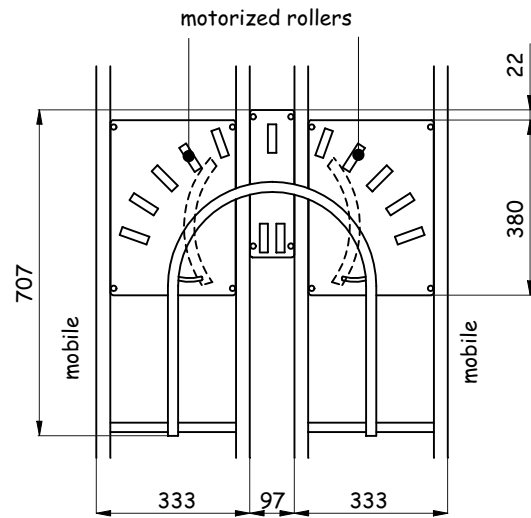


Using the 180° curve, it is possible to cross from one section in parallel to another operating in the opposite direction. Four combinations cover all possible configurations. This function is « mobile » due to the swivel curved central rail. In the « static/static » curve, accumulation of workpiece carriers is possible. Each input and output bed plate is equipped with a motorized roller to aid workpiece carriers through the curve.

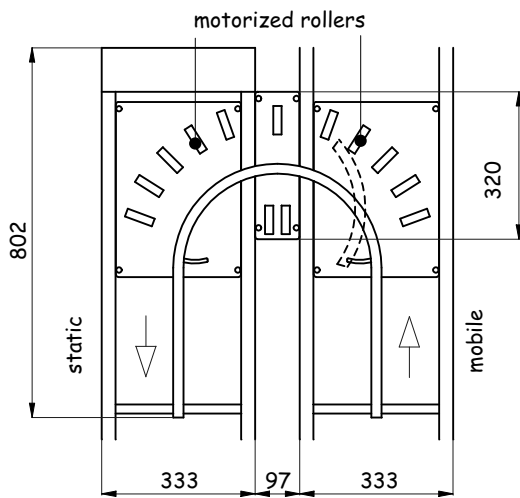
Ref. 4066 (static/static)



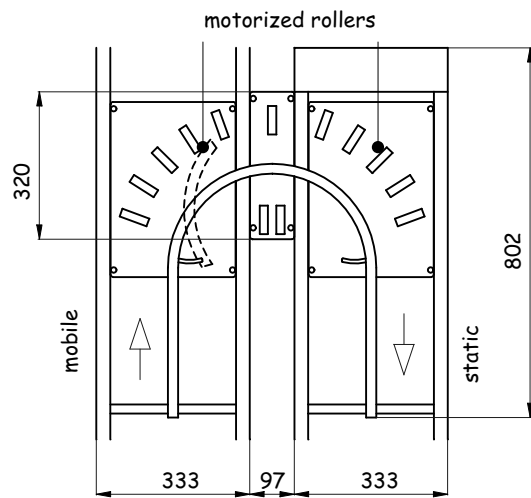
Ref. 4075 (mobile/mobile)



Ref. 4071 (static/mobile)



Ref. 4072 (mobile/static)



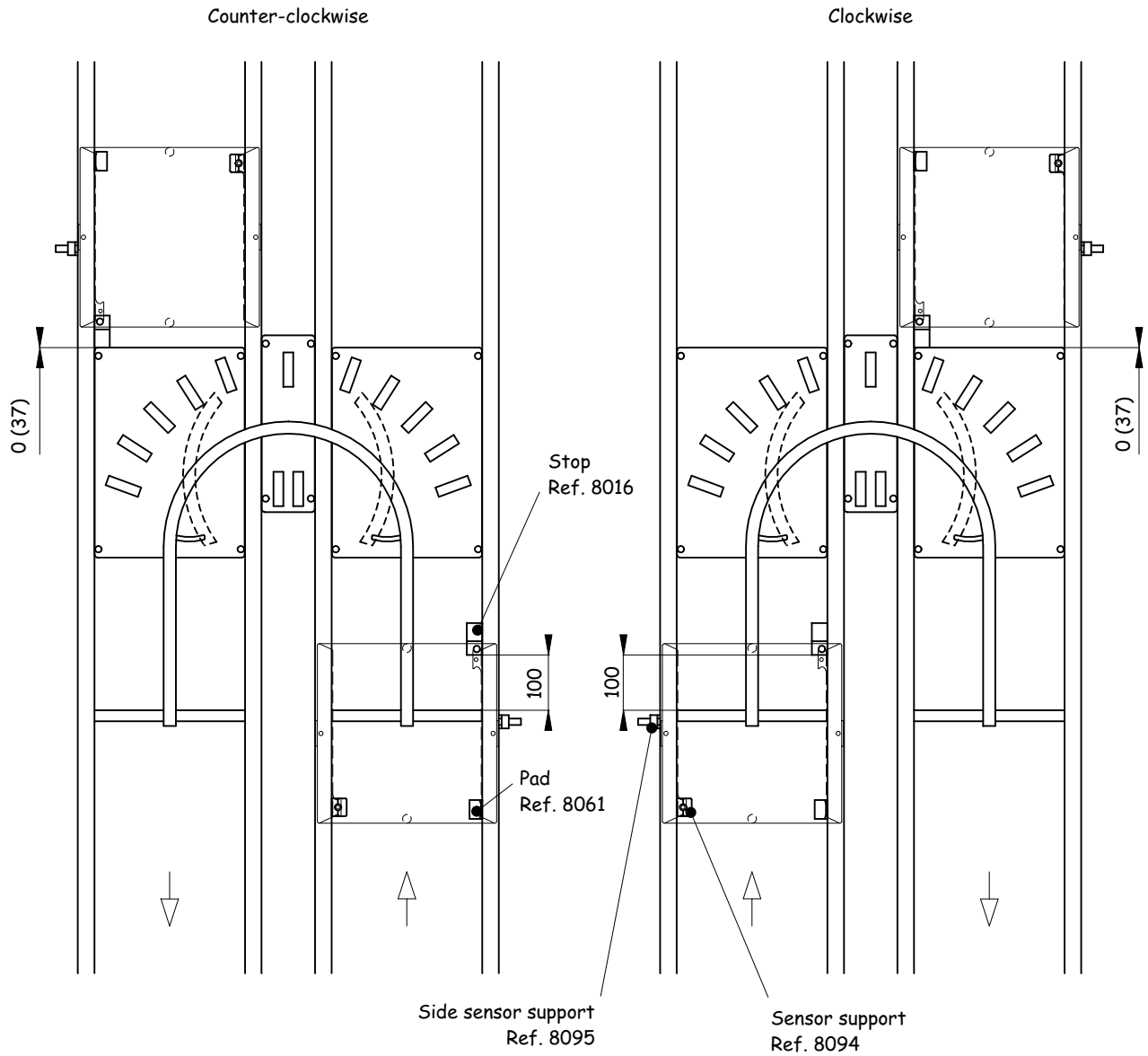
Mobile rail cylinder

- Ø 15mm, double-acting
- lubricated or not, cleaned air, 5 to 6 bars
- connectors for Ø 4mm pipe (included)
- M8 sensors under mobile rail bearing (not included)

Motorized roller motor

- power 6.3W
- voltage 220V single-phase
- frequency 50Hz
- rated current 73mA

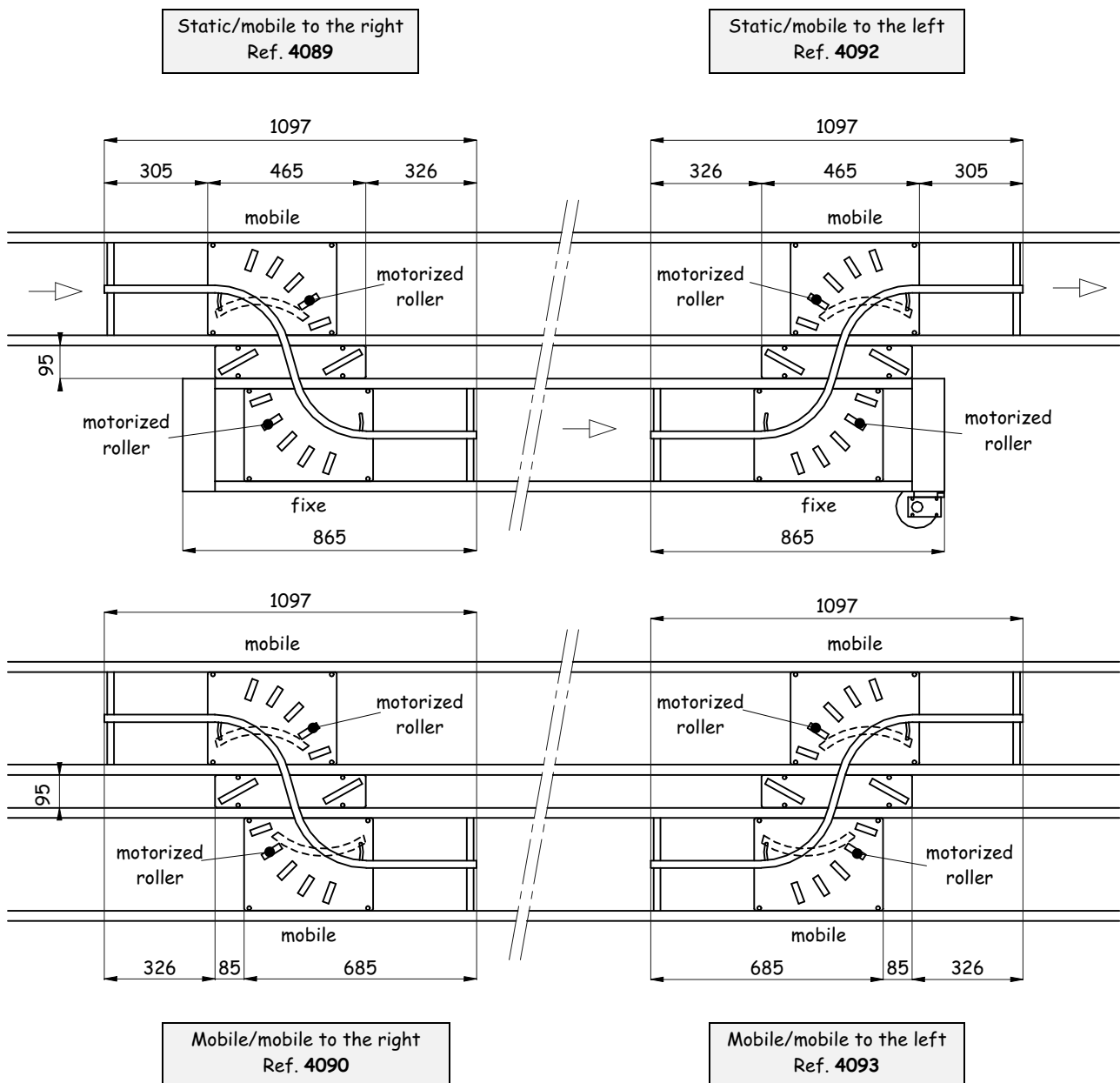
The minimum distance at which the workpiece carriers may be stopped in relationship to the curve is shown in the drawings below. Both 325x325 and 325x475 workpiece carriers are concerned.



() : 325x475 WPC

The function of the input/output combination is adapted to transfer workpiece carriers from one section to another operating in parallel and running in the same direction.

This function is « mobile » due to the swivel curved 12x22 rail. Each input and output bed plate is equipped with a motorized roller to aid workpiece carriers through the curve.



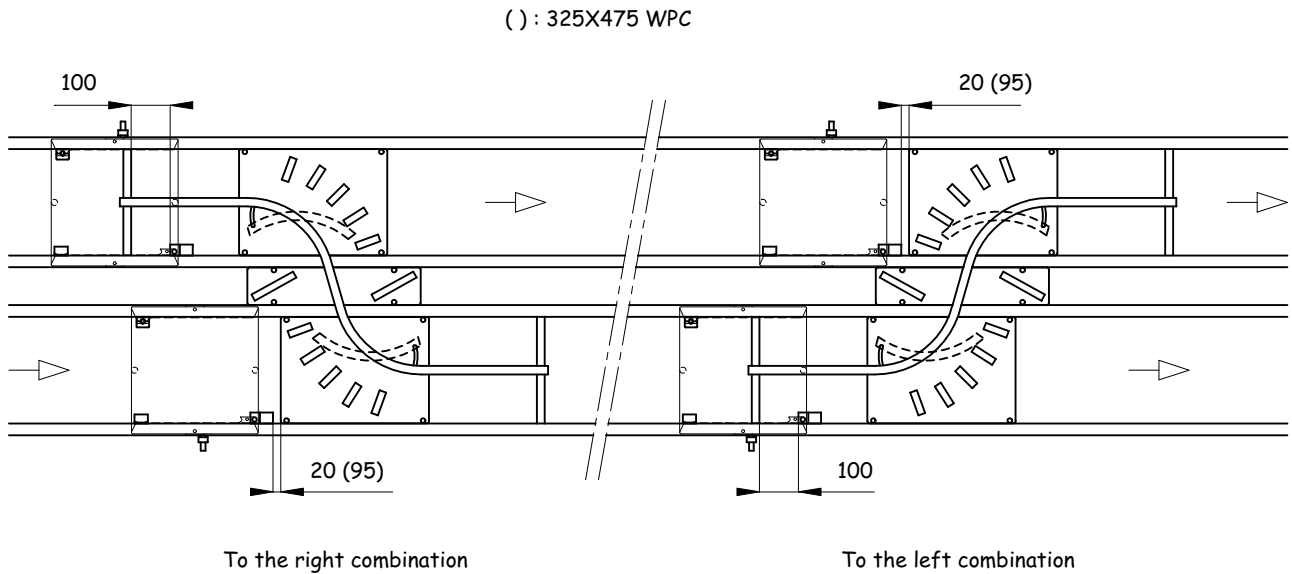
Mobile rail cylinder

- Ø 15mm, double-acting
- lubricated or not, cleaned air, 5 to 6 bars
- connectors for Ø 4mm pipe (included)
- M8 sensors under mobile rail bearing (not included)

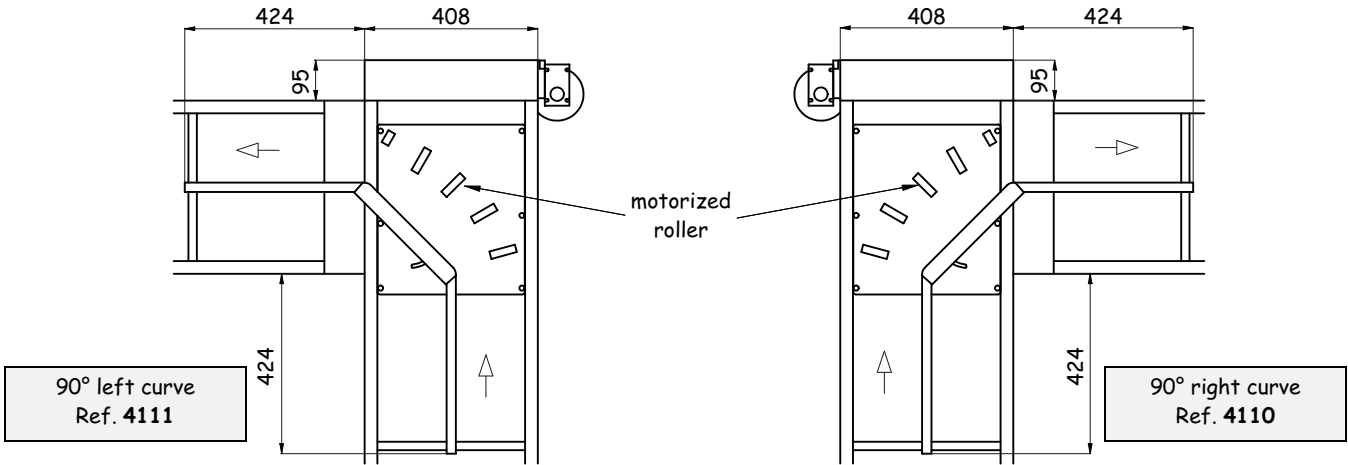
Motorized roller motor

- power 6.3W
- voltage 220V single-phase
- frequency 50Hz
- rated current 73mA

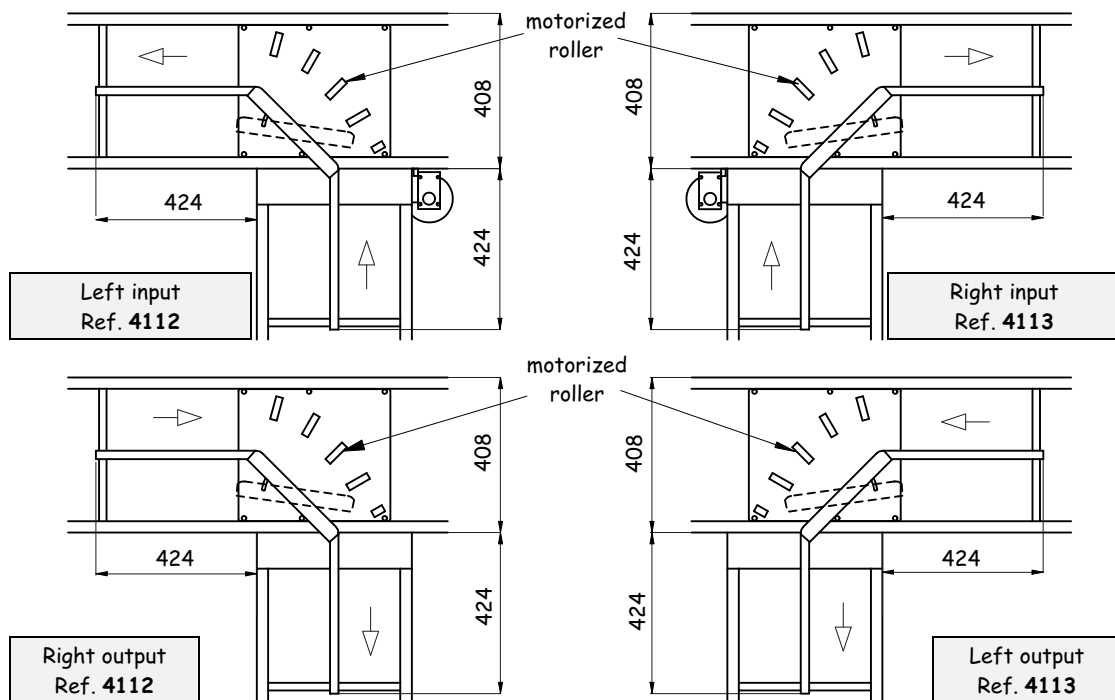
The minimum distance at which the workpiece carriers may be stopped in relationship to the combination is shown in the drawings below.



Using the 90° **static** curve, it is possible to cross from one section perpendicular to another. Two railwheels beneath the workpiece carriers ensure perfect guidance by fitting into a central 12x22 aluminium rail. Specially designed claws allow the bed plates to be fitted easily. The bed plate is equipped with a motorized roller to aid workpiece carrier through the curve. In this configuration, accumulation of workpiece carriers is possible. The small content of mechanical elements and features within the 90° curve results in high reliability.



The 90° curve **mobile** allows workpiece carriers to be introduced from a secondary section to a main one (« input ») or from a main section to a secondary one (« output »). Two railwheels beneath the workpiece carriers ensure perfect guidance by fitting into a central 12x22 aluminium rail. The bed plate is equipped with a motorized roller to aid workpiece carrier through the curve. This function is « mobile » due to the swivel curved central rail. The 90° curve **mobile** presents a reduced flow-stoppage rate requiring minimum automation.



Mobile rail cylinder

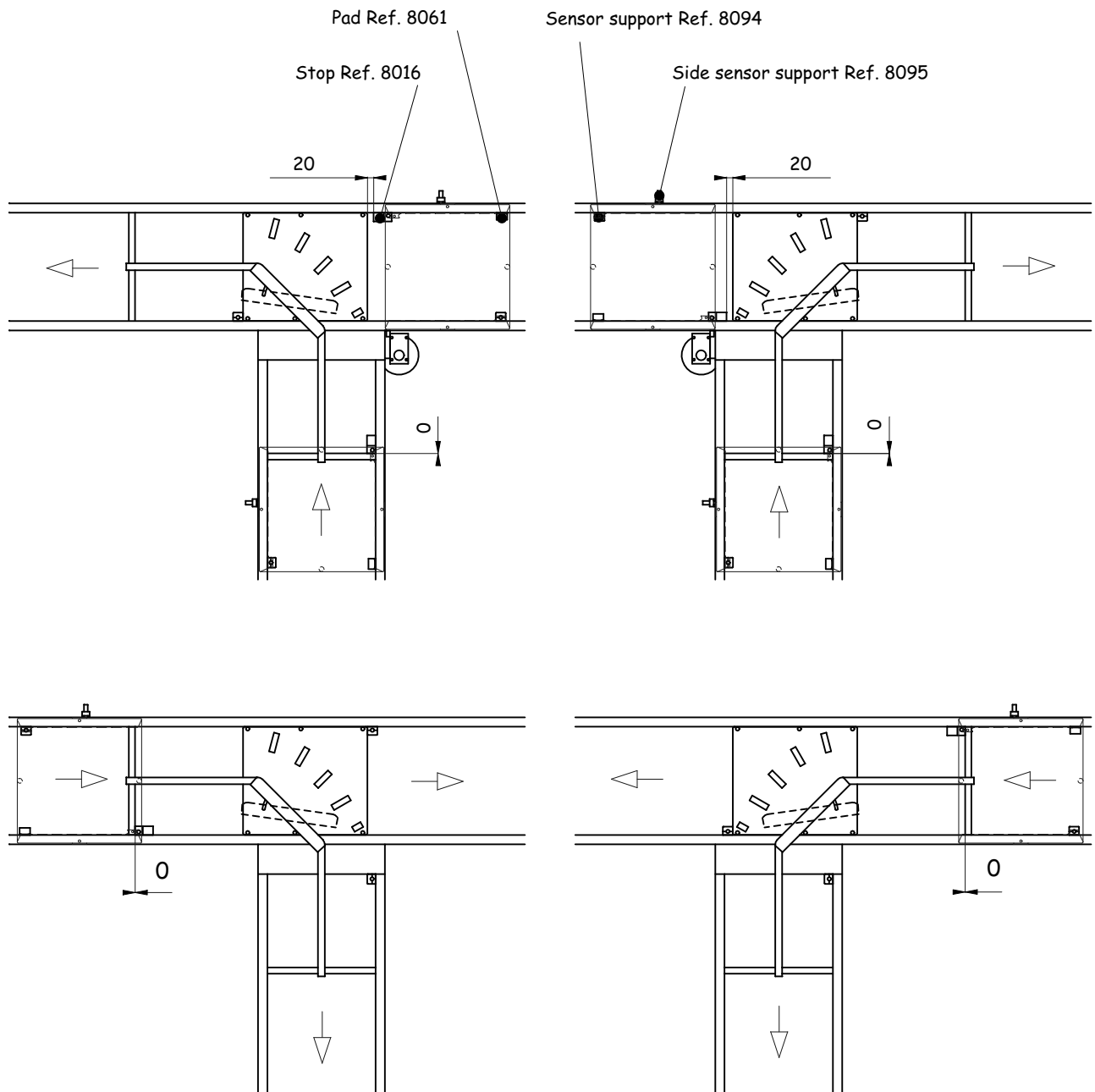
- Ø 15mm, double-acting
- lubricated or not, cleaned air, 5 to 6 bars
- connectors for Ø 4mm pipe (included)
- M8 sensors under mobile rail bearing (not included)

Motorized roller motor

- power 6.3W
- voltage 220V single-phase
- frequency 50Hz
- rated current 73mA

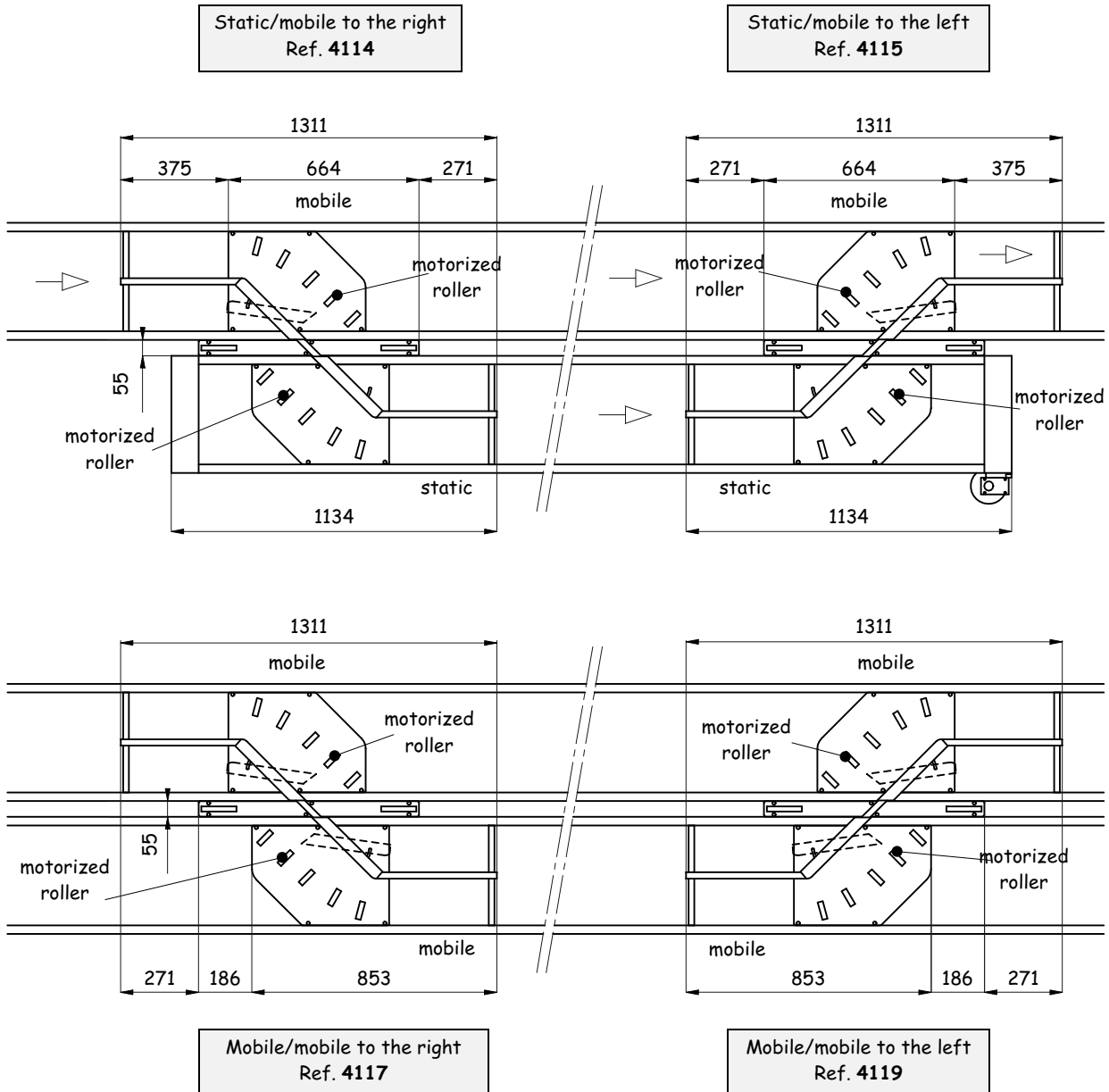
The minimum distance at which the workpiece carriers may be stopped in relationship to the curve is shown in the drawings below. 400x400 workpiece carriers are concerned.

Similarly, to chain up 90° curves (static or mobile), it is compulsory to take care of minimal space as shown in page 57.



The function of the input/output combination is adapted to transfer workpiece carriers from one section to another operating in parallel and running in the same direction.

This function is « mobile » due to the swivel 12x22 rail. Each input and output bed plate is equipped with a motorized roller to aid workpiece carriers through the curve.



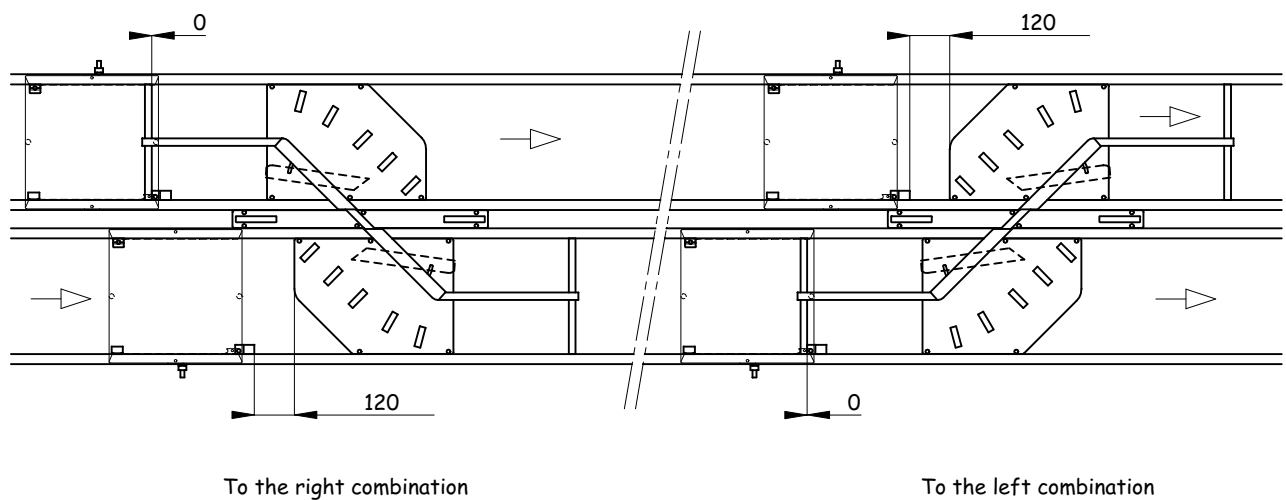
Mobile rail cylinder

- Ø 15mm, double-acting
- lubricated or not, cleaned air, 5 to 6 bars
- connectors for Ø 4mm pipe (included)
- M8 sensors under mobile rail bearing (not included)

Motorized roller motor

- power 6.3W
- voltage 220V single-phase
- frequency 50Hz
- rated current 73mA

The minimum distance at which the workpiece carriers may be stopped in relationship to the combination is shown in the drawings below.

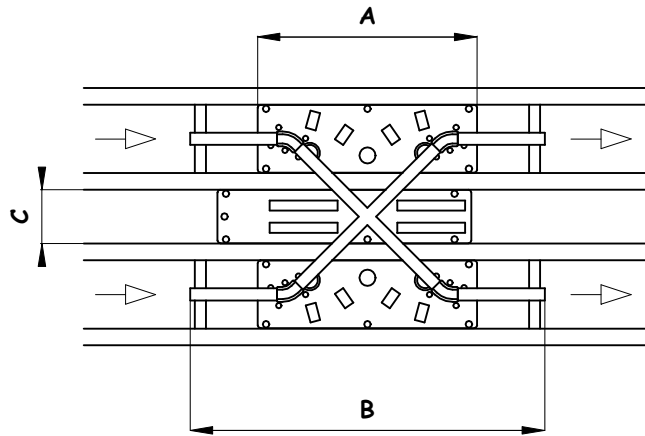


Cross combination

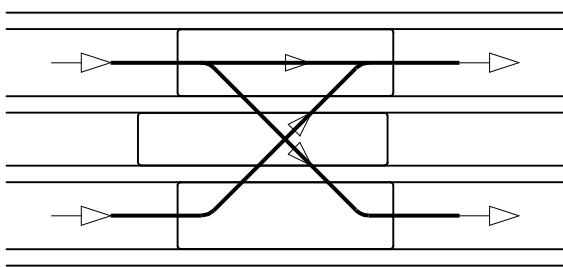
The cross combination function may replace two following input/output combination in order to make the transfer system more compact.

This function is available on special request and may be chosen « static/mobile » or « mobile/mobile ».

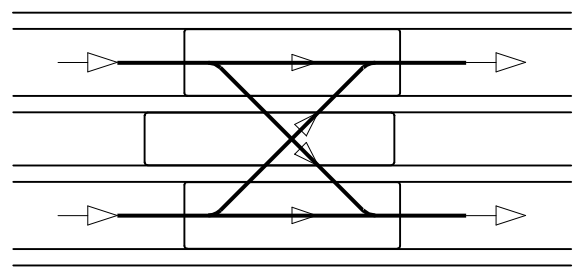
	A (mm)	B (mm)	C (mm)
Line 175	395	639	97
Line 250	470	864	97
Line 325	545	1089	97
Line 400	578	1272	55



Example of line 175



Static/mobile cross



Mobile/mobile cross

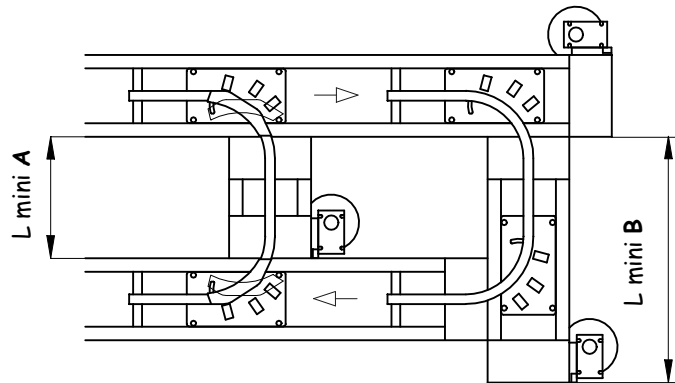
	References
Line 175	4183
Line 250	4181
Line 325	4185
Line 400	4187

	References
Line 175	4184
Line 250	4182
Line 325	4186
Line 400	4188

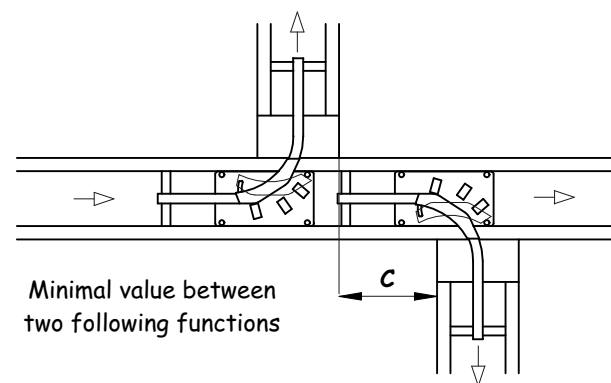
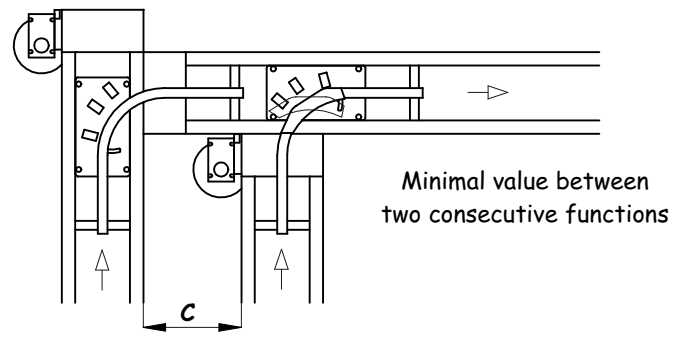
Linking of functions

To chain up curves of 90° (static or mobile), it is compulsory to take care of minimal space as shown below.

	Length A (mini, mm)	Length B (mini, mm)
Line 100	330	507
Line 175	272	550
Line 250	347	700
Line 325	422	850
Line 400	447	950

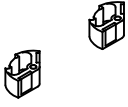
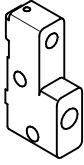
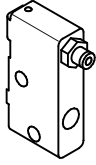


	Cote C (mini, mm)
Line 175	225
Line 250	300
Line 325	375
Line 400	425



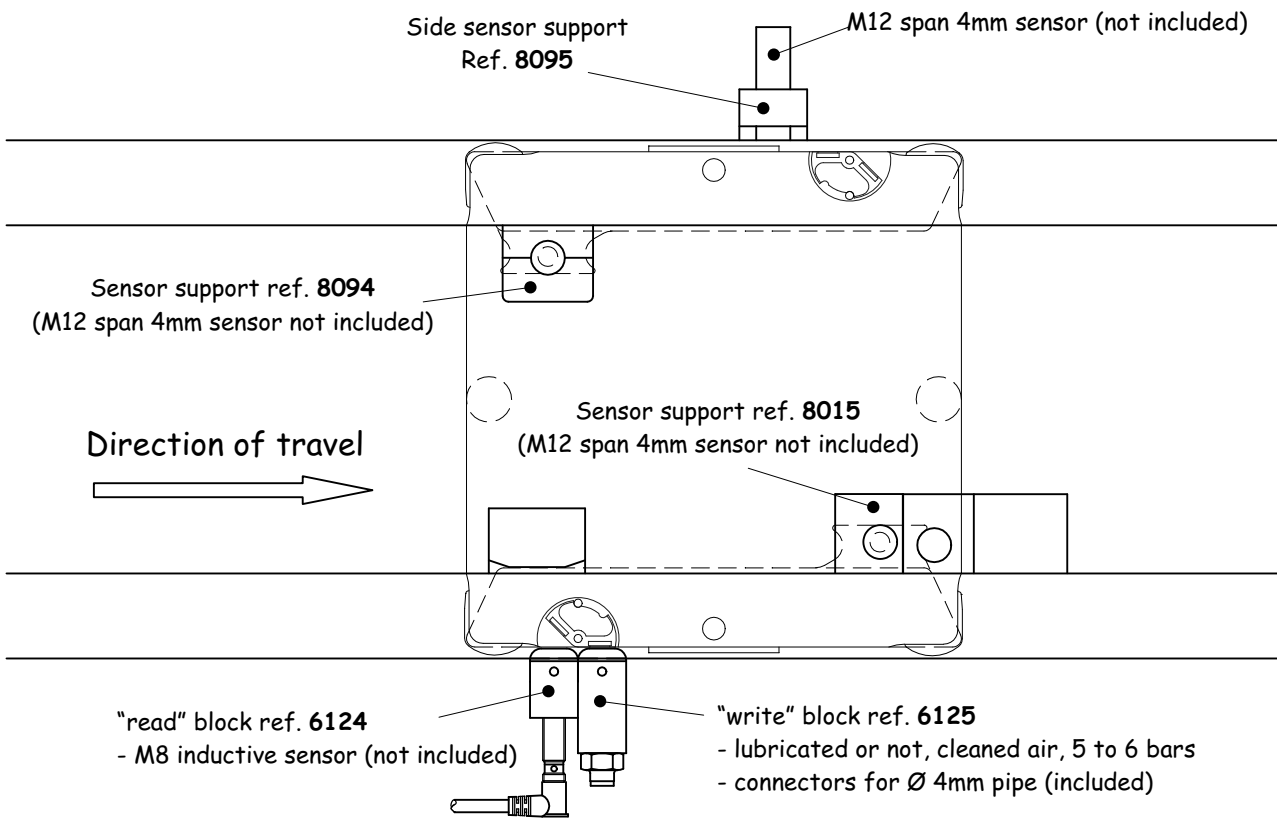
Data processing

The mechanic data processing system provides accurate means of identification for the status of the products, components or pieces. Two rockers 7046 can be inserted (on request) in the workpiece carrier pas, which allow four combinations. A « write » block 6125, equipped with a micro-cylinder, can move a rocker. A « read » block 6124 allows its sensing (M8 sensor not included). Blocks 6124 and 6125 can be included to provide multiple combinations.

Data processing		
rockers  (couple)	"read" block 	"write" block 
Ref. 7046	Ref. 6124	Ref. 6125

Maximal available number of rockers for each workpiece carrier :

- Line 100 : 2 couples
- Line 175 : 2 couples
- Line 250 : 4 couples
- Line 325 : 6 couples
- Line 400 : 8 couples



Example with a 175x175 workpiece carrier

Miscellaneous, maintenance, accessories

Lubrication

Lubricate every 5,000 h with TRANSEPT special spray lubricant, to be applied at the rear of each straight section.

Maintenance set

Change snapped-pads, TRANSEPT special spray lubricant, transmission protectors (cover caps), spare sprockets, chain tools.

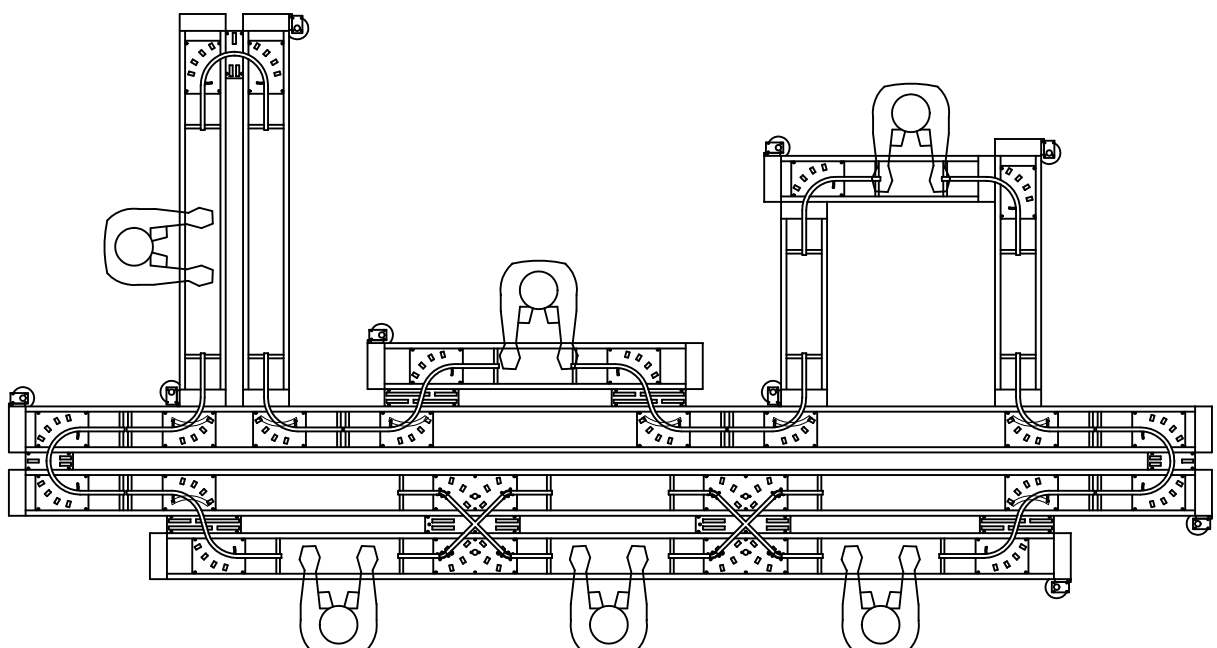
Maintenance	Lubricant	Maintenance set
Reference	0033	7123

Data base

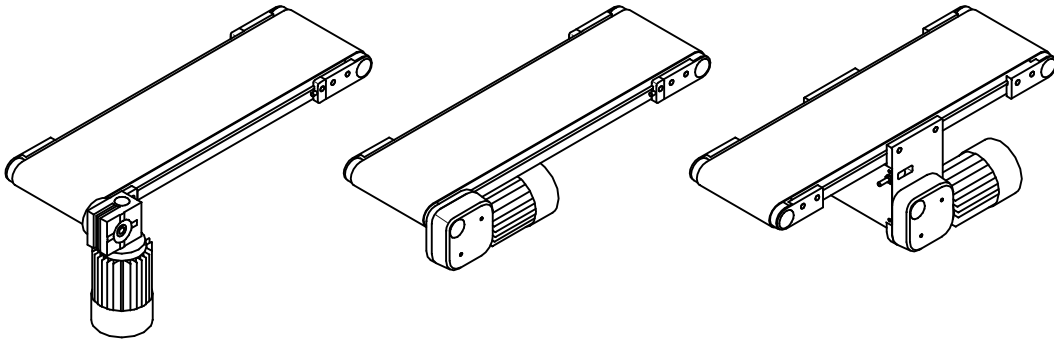
TRANSEPT modularity allows miscellaneous configurations. A data base of every function in this catalogue is available through AUTOCAD files™ and gives you the ability to design and choice a lot of implants. Encoded draws ensure too the reliability of the required bill of components.

TRANSEPT transfer system and other products built by the company are available too on the WEB at address :

www.transept.fr

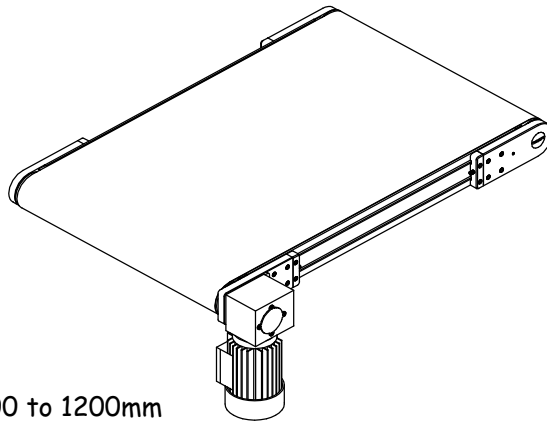


Other products by TRANSEPT



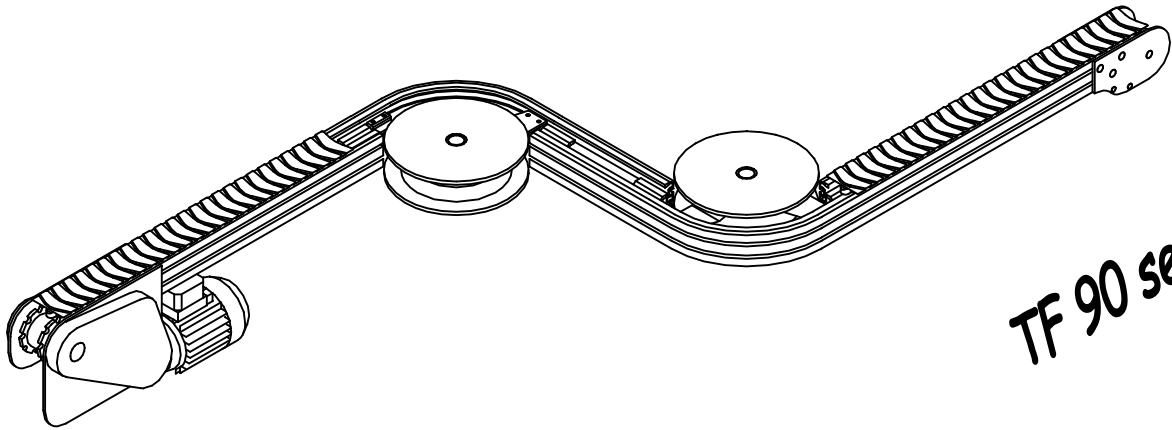
TB 50 series

Belt conveyors Ø50 : width from 70 to 500mm



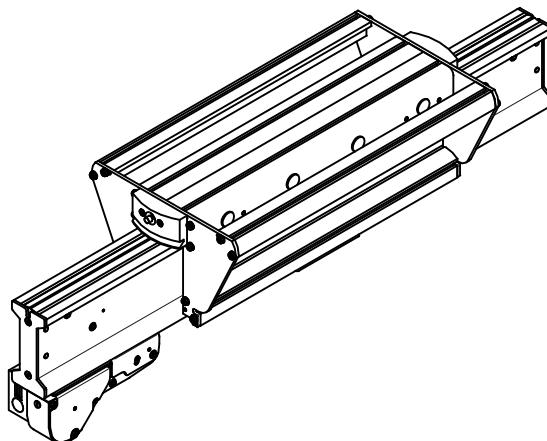
TB 90 series

Belt conveyors Ø90 : width from 600 to 1200mm



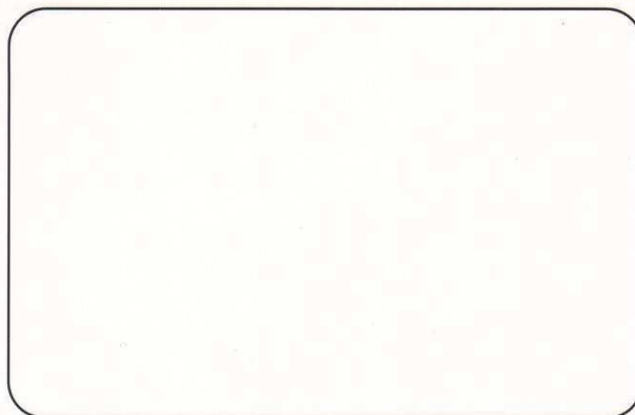
TF 90 series

Scale conveyor : width 90mm



TM series

Monorail conveyor
Loading up to 100kg per shuttle



TRANSEPT sarl

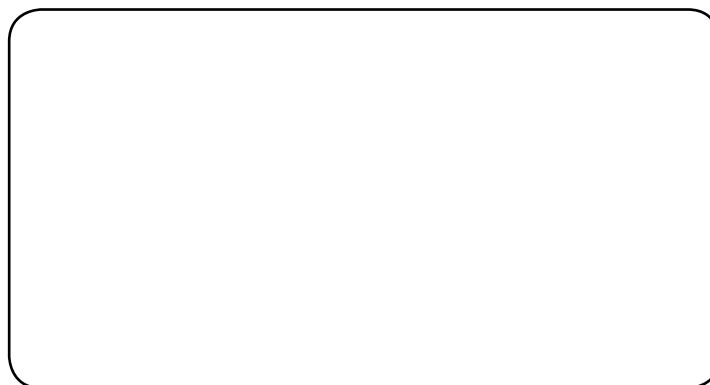
Rue Gustave Eiffel - BP 653 - 85306 CHALLANS Cedex - France

Tel. 33 (0)2 51 68 69 45 - Fax : 33 (0)2 51 68 81 78

Web : www.transept.fr - E.mail : message@transept.fr



A complete range of transitic sytems



TRANSEPT

Rue Gustave Eiffel • BP 653 • 85 306 CHALLANS Cedex • France

Tél. 33 (0)2 51 68 69 45 • Fax : 33 (0)2 51 68 81 78

www.transept.fr • e-mail : message@transept.fr