T250

Rapid and cost-effective deburring

The T250 thermal deburring machines provide fast and reliable solution for removing all internal and external burrs simultaneously in a single operation. They are designed to accommodate medium- to large- production volumes, as well as handle a variety of difficult to deburr workpieces.

Available in multiple chamber sizes with maximum operating pressure of 24 bar and cycle time from 30 to 60 seconds.

FEATURES and BENEFITS

+ 100% deburring - cleanliness
  Consistent, repeatable deburring of internal hard to reach intersected / cross-sectional holes and external contours of components.

+ Precise Gas metering via mass flow control
  Mass flow control devices are used to accurately regulate the gas mixture to deliver the right pressure in the chamber.

+ Hydraulically secured closure plates
  The deburring chamber is hermetically sealed off, eliminating contamination concerns and guaranteeing production safety.

+ User-friendly and expandable Programmable Logic Controller (PLC) / HMI
  Software facilitates quick parameter set-up; convenient machine monitoring with integral fault diagnostics.

+ Integrated noise suppression enclosure
  The enclosure prevents noise emissions into the production environment and ensures safety for the machine operator.

+ Productivity
  Significant improvement in the productivity of the overall process of TEM in combination with post-washing.
TECHNICAL INFORMATION

T250

Machine layout dimensions subject to change.

ELECTRICAL SPECIFICATIONS

- Main control cabinet integrated into the noise reduction enclosure.
- 10” touchscreen HMI
- Manual or automatic mode of operation

Power

Voltage 400 VAC; 3 P/N/PE/50 Hz

*Other voltages available on request

Controls

PLC Siemens S7-1500

(Fail Safe PLC)*

*Other controls are available as option.

HMI Siemens Comfort Panel 10”

touch screen**

** Optional process HMI display and interface to master computer are available.

CONNECTION REQUIREMENTS

<table>
<thead>
<tr>
<th>Water</th>
<th>Pneumatics</th>
<th>Oxygen</th>
<th>Methane</th>
</tr>
</thead>
<tbody>
<tr>
<td>Port</td>
<td>G 1/2”</td>
<td>G 1/2”</td>
<td>G 1/2”</td>
</tr>
<tr>
<td>Pressure</td>
<td>min 3 bar</td>
<td>min 5 bar</td>
<td>min 25 bar</td>
</tr>
</tbody>
</table>

ELECTRICAL SPECIFICATIONS

- Three-post-portal machine frame construction.
- Clamping forces up to 2.5 MN
- Indexing table equipped with up to five closure plates.

Noise Level < 70 dB(A)

Weigh T250: approx. 10,000 kg

Cycle Time (single ignition) 30 - 60 seconds

NOTE: Specifications and availability are subject to change without notice.

MACHINE CONFIGURATION

<table>
<thead>
<tr>
<th>Chamber size (ØxH)</th>
<th>Chamber Pressure (bar)</th>
</tr>
</thead>
<tbody>
<tr>
<td>250 x 150 / 300</td>
<td>16</td>
</tr>
<tr>
<td>200 x 150 / 300</td>
<td>24</td>
</tr>
<tr>
<td>150 x 150</td>
<td>20</td>
</tr>
<tr>
<td>120 x 150</td>
<td>24</td>
</tr>
</tbody>
</table>

T250

VALUES FOR GAS MIXTURE PRESSURE

<table>
<thead>
<tr>
<th>Material</th>
<th>Natural Gas</th>
</tr>
</thead>
<tbody>
<tr>
<td>Steel</td>
<td>8-20 bar</td>
</tr>
<tr>
<td>Cast Iron</td>
<td>5-20 bar</td>
</tr>
<tr>
<td>Zinc</td>
<td>5-10 bar</td>
</tr>
<tr>
<td>Aluminium</td>
<td>5-10 bar</td>
</tr>
<tr>
<td>Brass</td>
<td>8-20 bar</td>
</tr>
</tbody>
</table>

SAFETY

- Exhaust fan with vacuum sensor
- Gas detection system
- Mixing valve tester
- Probing station with integrated seal cleaner

ACCESSORIES/OPTIONS

- Multiple chamber options – diameter and height
- Gas compressor
- Closed loop cooling system
- Full automation

All machines in this series comply with the applicable EU Directives governing machine safety and bear the CE mark. They also comply with accident prevention and the VDE and VDI regulations, as well as the requirements concerning electromagnetic compatibility.

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