




CARPANO
EQUIPMENT
welding automation



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TWO

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TWO

Rotary table positioner with 200 Kg. maximum weight capacity, available with several different electronic controls. It can be equipped by a large range of optional devices for a semi-automatic or a fully automatic use

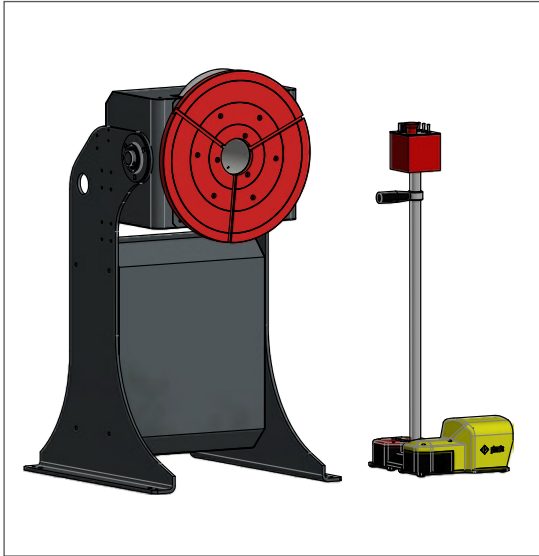
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200 Kg.
Rotary table positioner

Two controls and two different motorisations:



TWO BASE

- Driven by an AC servo-ventilated motor, managed by vector inverter, speed from 0,4 to 4 rpm.
- Rollo1-CD foot remote control with 5 m cable made up of :
 - Start and stop foot devices
 - Emergency stop push-button.
 - 10-turns potentiometer.
 - RPM digital tachograph.
 - On/off weld switch.
 - Clockwise/counterclockwise switch.
 - Adjustable/maximum speed switch.

TWO BASE DC

- DC motor with speedometer dynamo, managed by closed-loop electric drive, with adjustable speed from 0,1 to 4 rpm.
- Further optional devices as per ONE BASE model.



TWO PLC

- AC servo-ventilated motor, managed by vector inverter, speed from 0,4 to 4 rpm.
- Control cabinet on adjustable support made up of :
 - RPM digital tachograph.
 - Emergency stop push-button with reset on the inverter panel.
 - 10 turns potenziometer.
 - Start / stop cycle push-button.
 - Clockwise/counterclockwise switch.
 - On/off weld switch.
 - Adjustable/maximum speed switch.
 - On/off pneumatic tailstock switch.
 - On/off tilting pneumatic torch holder switch.
 - Overlap and delayed start in seconds digital setting.

TWO PLC WORKING CYCLE

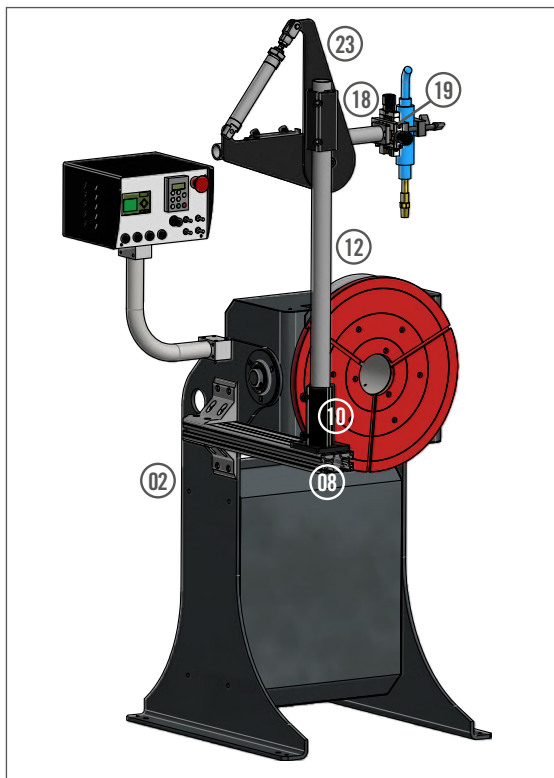
- Forward tailstock (by means of the a.m. switch) [*]
- Start cycle (Forward tailstock after starting cycle on request) [*]
- Tilting torch holder DOWN [*]
- Arc strike and delayed rotation start
- 360° rotation + x° overlapping
- OFF Arc
- Tilting torch holder UP [*]
- Reset - x° to the Start position
- Back Tailstock (by means of the a.m. switch)[*]

TWO PLC DC

- DC motor with speedometer dynamo, managed by closed-loop electric drive, with adjustable speed from 0,1 to 4 rpm
- Further optional devices as per ONE PLC model.

[*] These working cycles are obviously omitted in case the tailstock and/or the torch holder are not installed

Examples of possible configurations

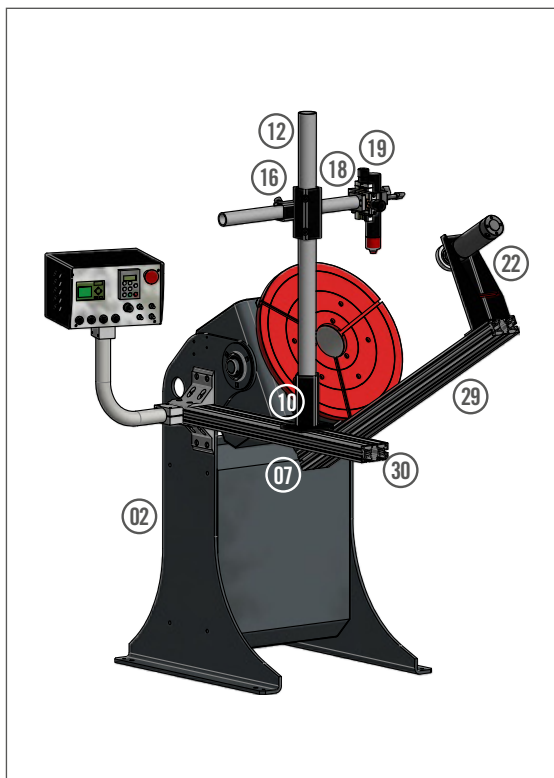


TWO PLC with TWO ARM Pneumo

Such configuration includes :

- Two PLC
- TWO ARM Pneumo torch-holder arm with pneumatic actuator

02	TWO PLC	200Kg tilting rotary table
08	ONE-2050	500mm (Al 40x80x500mm) crossbar with fixing brackets
10	ONE-2110	Vertical column base
12	ONE-3075	750mm vertical column
18	ONE-3040	400mm horizontal pipe
19	SM 50/2 + PT	Torch-holder with 50x50mm. cross micrometric slides
23	ONE-TL-100	ARM PNEUMO : 30° tilting arm



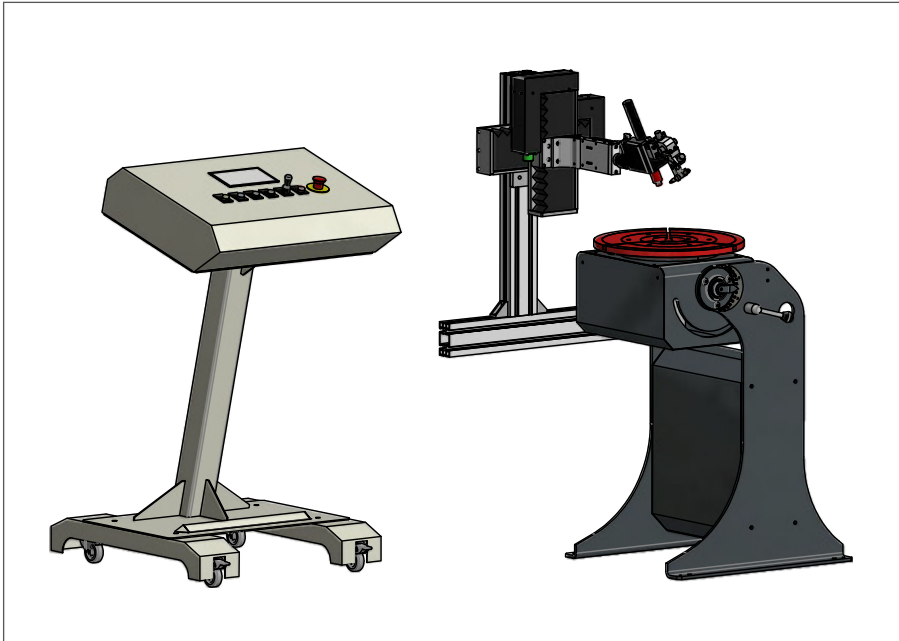
TWO PLC with TWO Swan and TWO ARM MAN

Such configuration includes:

- TWO PLC
- TWO ARM MAN torch-holder arm without pneumatic actuator
- TWO SWAN tailstock Assembly

02	TWO PLC	200Kg tilting rotary table positioner
07	ONE-033	Rail connection- pos. 29
10	ONE-2110	Vertical column base
12	ONE-3075	750mm. vertical column
16	ONE-2054	Cross connection for \varnothing 40/35 mm. pipes with lock
18	ONE-3040	400mm horizontal pipe
19	SM50/2 + PT	Torch-holder with 50x50mm. cross micrometric slides
22	TWO-TS-075S	75mm. Stroke pneumatic tailstock
29	TWO-2085	850mm (Al 4 0x80x850mm) rail
30	TWO-2075	750mm (Al 40x80x750mm) rail

Examples of possible configurations

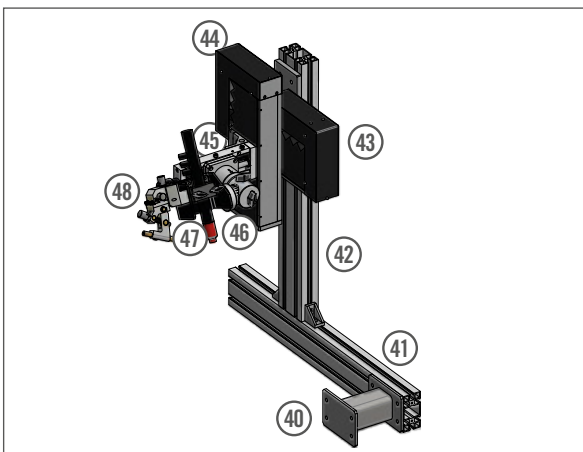


Fully automated TWO for multi-layer cold wire TIG circular welding:

- PLC with 7" Touch-sensitive screen Panel
- AVC control vertical slide
- Swinging control horizontal slide
- Cold wire managed by PLC
- PLC with welding torch JOB recall
- Possibility to enter at least 200 working programs, for each program it is possible to set the step number and for each step it is possible to set :
 - Ø of the item in mm.
 - Rotation delay
 - Overlap in mm
 - Arc Voltage in Volt
 - Swinging parameters : width, speed, center, pause left-center-right
 - Welding torch Job, with bus connection

Optional devices:

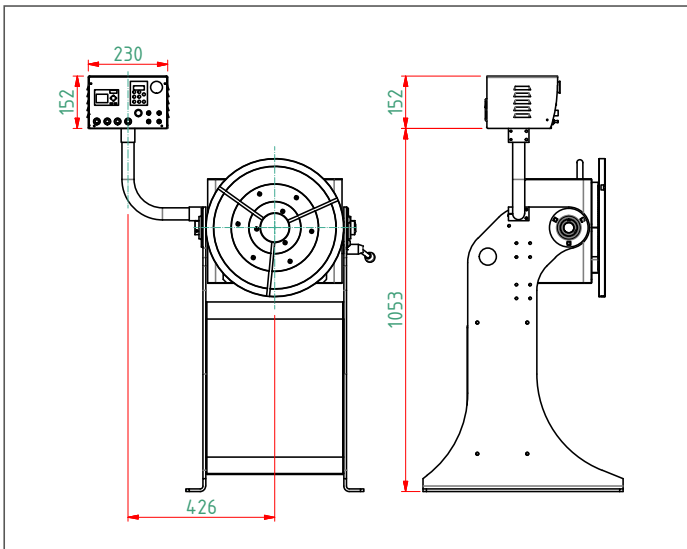
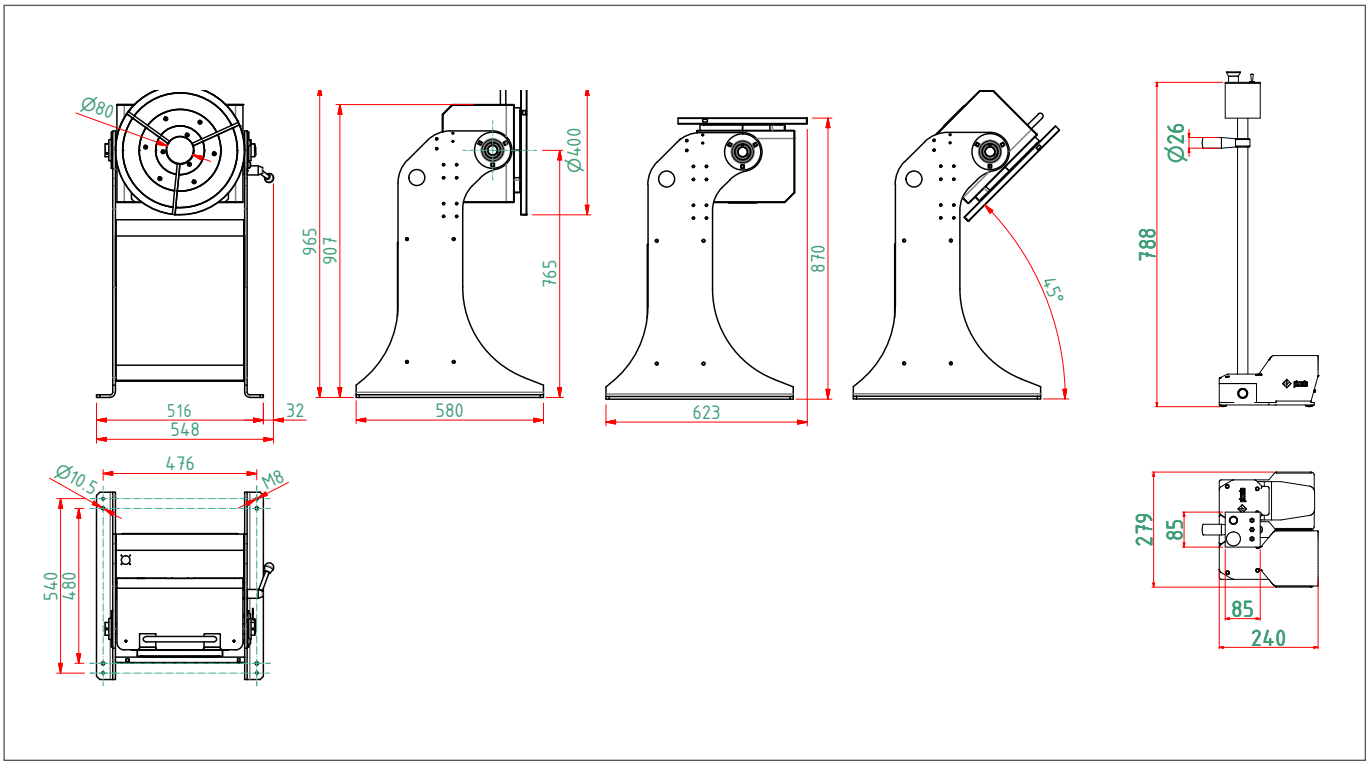
- Modem connection, for Remote-control or to update programs
- 4.0 Industry Package : for monitoring working parameters, off-line programming, OPC UA server to communicate with the production management system.



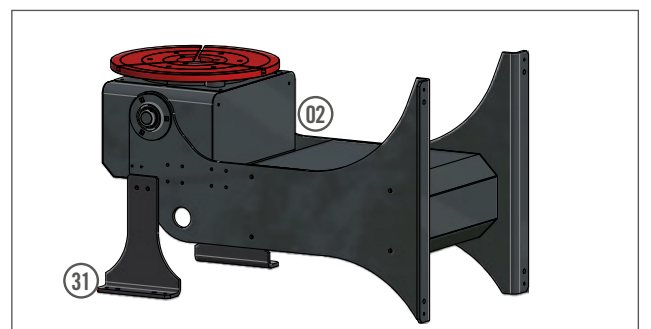
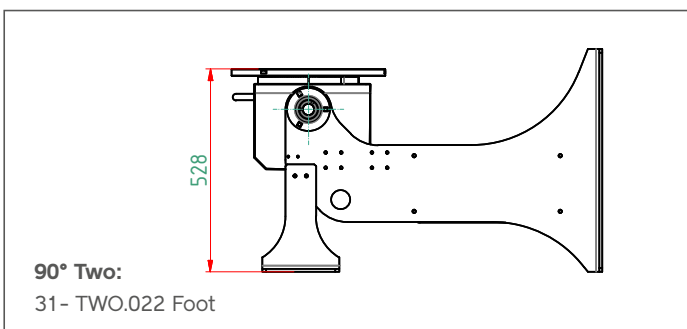
This configuration includes:

- 40 TWO-4040 Support
- 41 TWO-4070 650mm (A I 45x90x700) crossbar
- 42 TWO-4065 700mm. (A I 45x90x700) column
- 43 MM MINI180 with oscillator purpose
- 44 MM MINI180 with AVC purpose
- 45 SM160 SM MIDI160 manual slide
- 46 TWIN 2 axes support
- 47 TWO-4041 Flange
- 48 CEFF 4 axes wire-guide

Dimension



CONTROL FEATURES	TWO BASE	TWO PLC
Feeding	230V 50Hz	230V 50Hz
Power installed	90 W	90W
Speed display rpm	OK	OK
EMG with reset	OK	OK
On/off weld switch	OK	OK
Adjust/max. Speed switch	OK	OK
Left/right rotation switch	SI	-
Left/right Push button	-	OK
Start/stop foot switch	OK	-
Start/stop Push button	-	OK
On/off tailstock switch	-	OK
Up/down torch switch	-	OK
10-turn potentiometer	OK	OK
Overlapping setting	-	OK
Delayed Start/post gas	-	OK
Automatic cycle	-	OK
HF shielding	OK	OK



Features

	TWO BASE/PLC AC	TWO BASE/PLC DC
Max weight capacity	200 kg	200 kg
Tilt torque	30 kgm	30 kgm
Rotation torque	7 kgm	7 kgm
Tilt	manual with 0-135°releasing lever	Manual with 0-135° releasing lever
Motor	AC from 90 W servo ventilated 4-poles	DC with speedometer
Transmission	VSF Reductor with pinion on ball bearings toothed ring	VSF Reductor with pinion on ball bearings toothed ring
Rotation speed	from 0,4 to 4 rpm – other solutions on request	from 0,1 to 4 rpm – other solutions on request
Table	Ø400, with Ø80 mm through hole	Ø400, with ø80 mm through hole
Weight	100 kg + 5 kg Rollo1-CD	105 kg

TWO PLC with SWAN and ARM MAN

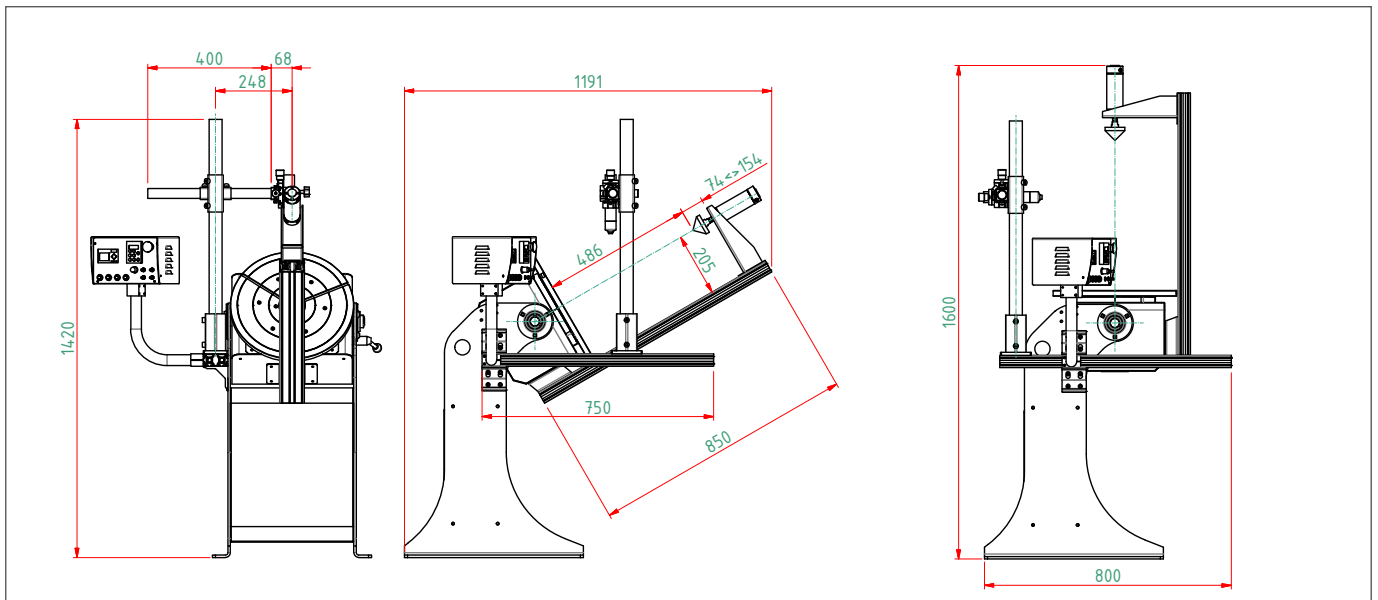
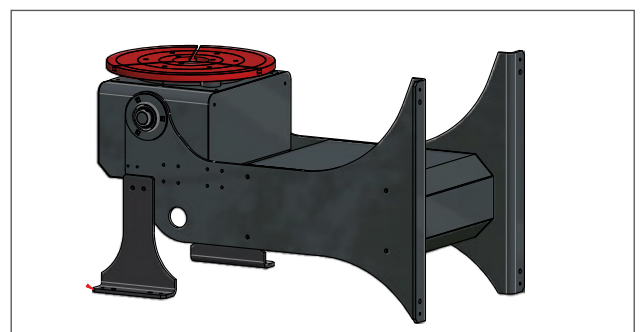


Photo gallery



Special version with increased table up to $\varnothing 650$ mm and supporting feet in order to bring the table to a low ground height.



1. SUPPLY OBLIGATION ARRANGEMENT

The following general terms of business are always to be considered applicable to every order made by the buyer. Therefore, any supply clause written by the buyer on his orders or any other document given to the seller, which may result to be conflicting with the present general conditions, will be considered not written. The buyer has to forward the orders to the seller in writing. The seller reserves the authority to accept telephone and verbal orders. The order is to be considered executed when the buyer receives the written acceptance of the same (order confirmation) by the vendor or, in the absence thereof, automatically 15 days after the order receipt by the seller. All offers and prices are just an indication and are not binding. Therefore the seller considers himself to be bound only to what is declared in his order confirmations.

2. TERMS FOR DELIVERY

The delivery dates indicated by the seller as well as the ones written on the buyers' orders have to be considered just as an indication and are not binding and are subject to the punctual supply by the buyer of all the specifics, to the variations due to the availability of the goods with the suppliers or to reasons of force majeure: delays in the delivery due to said availability variations are not attributable to the seller, who is not in duty bound to the compensation for damages suffered by the buyer. Reasons of force majeure have also to be considered the accidents (industrial injury, disease, etc) and any other circumstances which may cause a total or partial job reduction, as well as the lack of raw materials, troubles with transportation, etc. The seller reserves the authority to suspend the delivery of the goods if the buyer has not seen to the payment of the invoices relative to other supplies whose terms of payment are overdue. The goods are understood as being delivered for all intents and purposes to the buyer from the time they were picked up by the carrier or the buyer himself at the seller's warehouse.

3. PAYMENT AND TERMS OF PAYMENT

The payments have to be made to the seller's domicile and in accordance with the established conditions. In the event of a delay, the due amounts of money will automatically imply the charge of interests based on the official discount rate plus 5 points. In the event of a non-payment, the buyer is to be considered in default without the necessity of any formal notice by the seller. The presence of possible faults and/or defects in the products does not excuse the buyer for suspending the payment of the invoices. Should the client suspend and/or delay the payments, the seller may suspend the supplies, with the authority to consider the contract automatically terminated by rights and to demand for damages.

4. WARRANTY

CARPANO EQUIPMENT guarantees the products for a period of 24 months starting from the delivery date, for a daily work cycle of 8 hours. The warranty is intended ex works CARPANO EQUIPMENT. CARPANO EQUIPMENT guarantees the performance of its products in accordance with the instructions written in the relative manuals. For the products based on job orders, the warranty is pertaining to the specifics agreed with the client.

5. VOID WARRANTY

In case of any tampering or unauthorized intervention the warranty shall be deemed void.

6. LIABILITY FOR DAMAGE

The seller's liability is limited only to the obligations above and it's expressly agreed that the seller does not accept any liability for damages resulting from any cause connected with the use and utilization of the sold products.

CARPANO EQUIPMENT is not responsible and for no reason whatsoever may the expenses be charged for:

- Machine downtime.
- Direct or in direct damage due to the non-operation of the equipment.
- Working hours spent to solve possible problems on the equipment.

7. RESERVATION OF OWNERSHIP

Until the payment in full of any credit resulting from business relations has taken place, included any additional credit and until the payment of bills and cheques has been made, the property in the goods remains in the seller.

8. COMPETENT COURT

It's established that the court of Bologna will be the sole competent court for every dispute relative to this contract.

9. APPLICABLE LAWS

The applicable law is the Italian law.

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