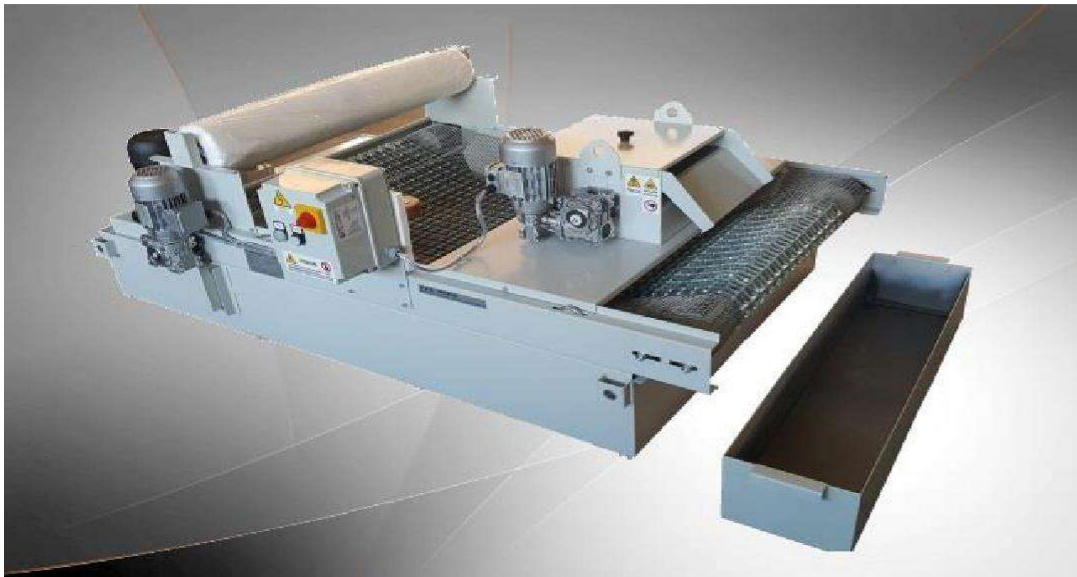
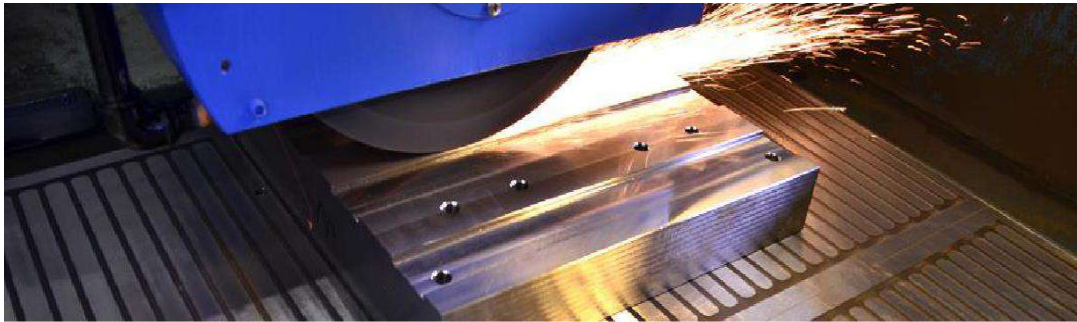


PRESENTATION FOR GRINDING APPLICATION



*SALES
DOCUMENTATION*

SUMMARY



Magnetic chucks for the grinding machines

- Permanent magnetic chucks and blocks
- Electro-magnetic chucks
- Electro-permanent chucks
- Control unit + remote control



Filters for the grinding machines

- Magnetic drum separators
- Paper filters
- Complete filters (magnetic + paper filters)
- Accessories



Demagnetization systems after the grinding operation

- Measure accessories
- Hand demagnetizers
- Plate demagnetizers
- Tunnel demagnetizers
- Conveyor of demagnetization
- Complexe demagnetization

MAGNETIC CHUCKS FOR THE GRINDING MACHINES

Permanent technologies:

A permanent magnetic chuck is simply activated and deactivated mechanically.

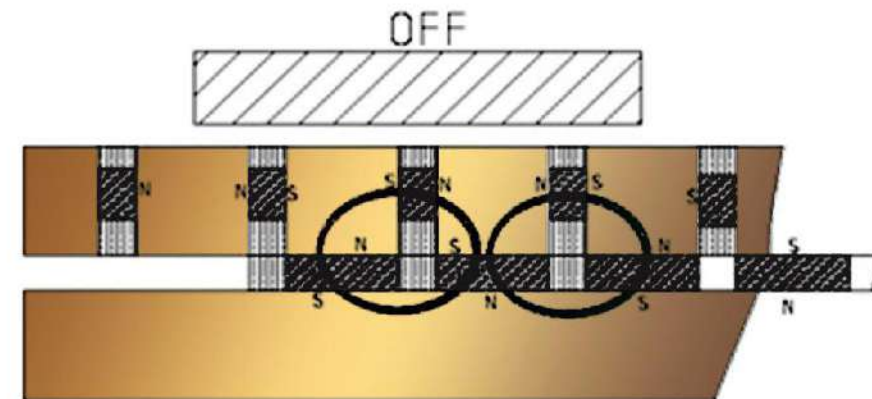
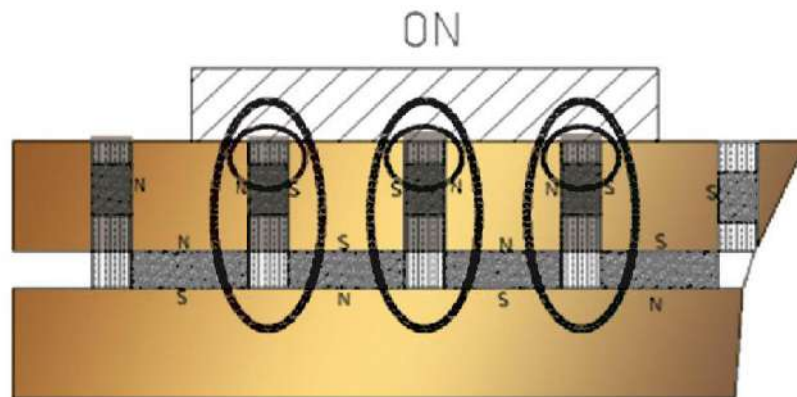
The magnets are always active inside the chuck.

However the magnetic flux stays locked inside the chuck when it is deactivated.

When activated, the magnetic flux is locked into the part that is worked.

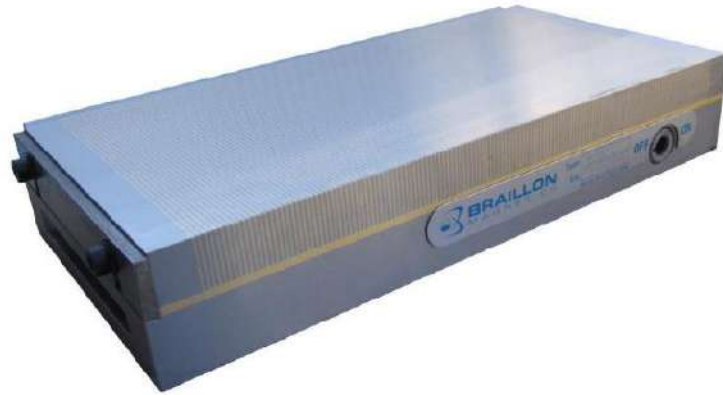
The hold is then secure:

When deactivated, the magnetic flux is locked inside the chuck.
The part is now free, for removal:

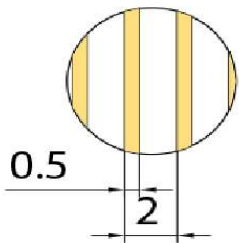


MAGNETIC CHUCKS FOR THE GRINDING MACHINES

Permanent magnetic chucks :



Pole pitch: 1,5mm of steel + 0,5mm of brass



This chuck is particularly suited for very thin (0,5 mm) and small components

REF. 10.01 – Type PF2

. Permanent magnetic chuck with NEODYMIUM magnets . Parallel fine pole pitch with steel + brass.
Reinforced actuating mechanism

Included with purchase:

- 1 Actuating Key
- Long and short side end stops
- Clamps

Nominal force : 100 N/cm²

Admissible wear of top plate : 5 mm

Magnetic field height : 3 mm

Options :All the BMS palettes can be deliver in simple version (without special machining) or for pelletizing system: EROWA-3R- HIRSCHMANN-V&B ...

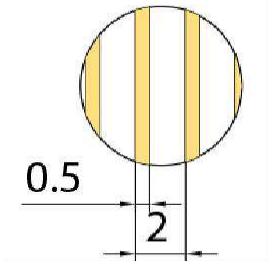
A BMS specialist will inform you.

MAGNETIC CHUCKS FOR THE GRINDING MACHINES

Permanent magnetic palett :



Pole pitch : 1,5mm of steel + 0,5mm of brass



It's the same magnetic construction. The switch is different. The force is adjustable. This Palette can be equipped with the UPC system and the rotor adapter.

REF. 40.60.01 – Type PF2-PAL

. Permanent magnetic chuck with NEODYMIUM magnets . Parallel fine pole pitch with steel + brass . Reinforced actuating mechanism . Without special adaptation

Included with purchase:

- 1 Actuating Key
- Long and short side end stops
- Clamps

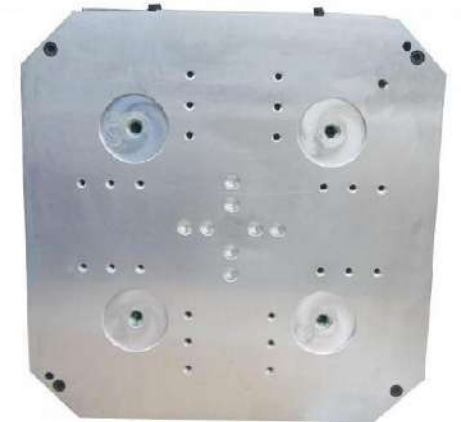
Nominal force : 100 N/cm²

Admissible wear of top plate : 5 mm

Magnetic field height : 3 mm

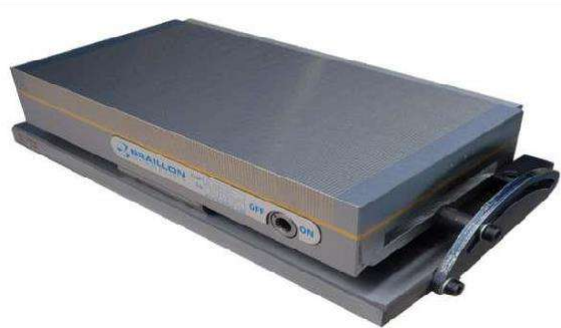
Options :

All the BRAILLON's palettes can be deliver in simple version (without special machining) or for palettizing system: EROWA-3R-HIRSCHMANN-V&B



MAGNETIC CHUCKS FOR THE GRINDING MACHINES

Permanent magnetic chuck with sine table :

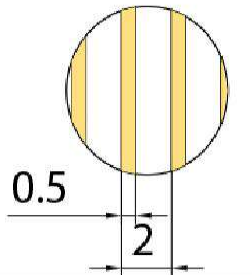


12.01



12.02 I

Pole pitch : 1,5mm of steel + 0,5mm of brass



Ref. 12.02 – PF2-SD

Swiveling on long axis : 0° to 45° and from 0° to 30° for the short axis

REF. 12.01 Type PF2-SS / REF. 12.02 Type PF2-SD

- . With standard permanent magnetic chuck type PF2
- . Steel base body hardened to 60 HRC
- . Precision-ground surface for highest accuracy
- . Swiveling on long axis: from 0 to 60° for REF. 12.01 and 0° to 45° and from 0° to 30° for REF. 12.02

Included with purchase: - 1 Actuating

- key - End stops
- Table of sines

Angular accuracy : ± 5" sec

Nominal force : 100 N/cm²

Parallelism : ± 0.003/100 mm

Admissible wear of top plate : 8 mm

Magnetic field height : 4 mm

Options :

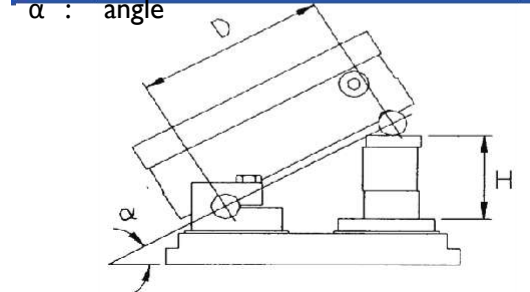
- With other magnetic chucks on request
- Swiveling on short axis
- Part of palletizing system: Erowa, 3R, Hirschmann, Vischer & Boli
- Mounting slot in the base plate

To define the height of the gauge block H in order to the angle α :

$H = D \cdot \sin(\alpha)$

H : height of the gauge block

D : distance of the axis



MAGNETIC CHUCKS FOR THE GRINDING MACHINES

Magnetic block with 4 faces : REF. 13.11 Type BAP4



- . 4 active faces
- . With ON/OFF mechanism
- . Pole pitch 4 mm : 2 mm of brass – 2 mm of steel
- . For small and thin workpieces from 0.5 mm thick

- . Rugged and waterproof construction
- . Force: 70 N/cm²
- . Longer life
- . Low magnetic field (2mm)

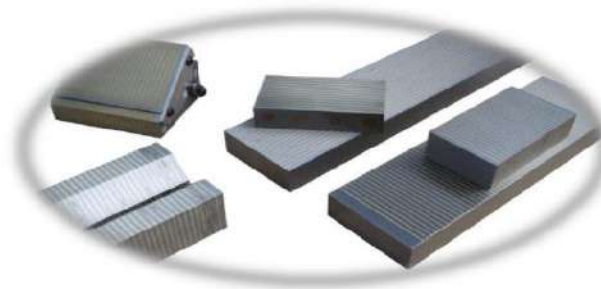
Magnetic block with 3 faces : REF. 13.14 Type BAP3



- . 3 active faces
- . With ON/OFF mechanism
- . Pole pitch 2 mm : 1 mm of brass – 1 mm of steel
- . For small and thin work pieces

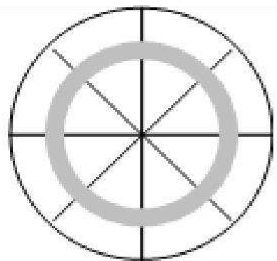
- . Rugged and waterproof construction Force: 150 N/cm²
- . Longer life
- . Low magnetic field (4mm)

Others laminated block and Vee available



MAGNETIC CHUCKS FOR THE GRINDING MACHINES

Circular permanent magnetic chuck :



Radial pole pitch

Ideal for bearing applications, Grinding and turning

REF. 11.01 Type ERCN

- . Uniform and very powerful magnetic field
- . Radial pole pitch with steel + epoxy resin
- . With Neodymium-Magnets

Included with purchase:

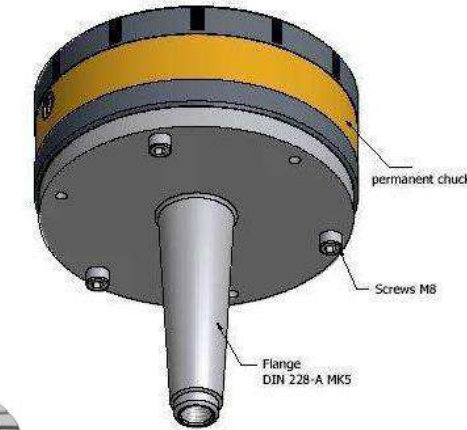
- 1 Actuating Key

Nominal force : 120 N/cm²

Admissible wear of top plate : 3-7 mm

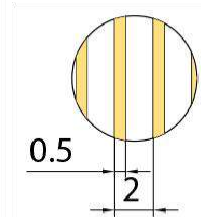
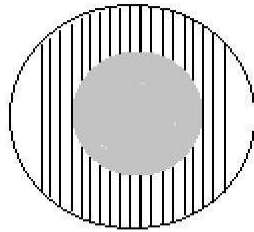
Options :

- T-slots in each pole
- Through hole in the middle
- Raising pole shoes
- Auxiliary top plate
- Fitting adaptors to :
 - . Morse cone 3 or 4
 - . Short taper flanges for :
 - A2 DIN 55026
 - Bayonet DIN 55027
 - Camlock DIN 55029



MAGNETIC CHUCKS FOR THE GRINDING MACHINES

Circular permanent magnetic chuck :



Parallel pole pitch 1,5mm
of steel + 0,5mm of brass

REF. 11.05 Type MPF2

- . Circular magnetic chuck with NEODYMIUM magnets
- . Low magnetic field
- . Suitable for precision machining and thin workpieces
- . Specially designed to hold thin (from 1 mm) or small components 10x10x3 mm or larger

Nominal force : 95 N/cm²

Admissible wear of top plate : 5 mm

Magnetic field height : 4 mm

REF. 11.03 Type FM

- . Uniform and powerful magnetic field, ideal for turning and grinding
- . Parallel pole pitch
- . Adjustable holding force
- . For parts 4mm thick and up

Nominal force : 100 N/cm²

Admissible wear of top plate : 8 mm

Magnetic field height : 8-10 mm

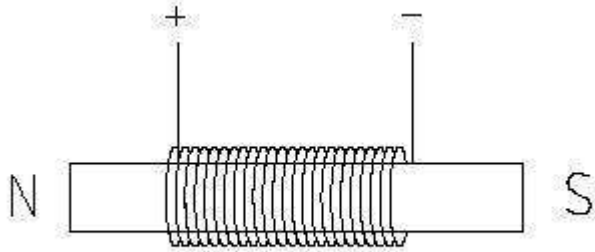
Options :

- Auxiliary top plate for centering
- Machining possible at the rear of the chuck
- Fitting adaptors to:
 - . Morse cone 3 or 4
 - . Short taper flanges for: A2 DIN 55026
 - Bayonet DIN 55027
 - Camlock DIN 55029

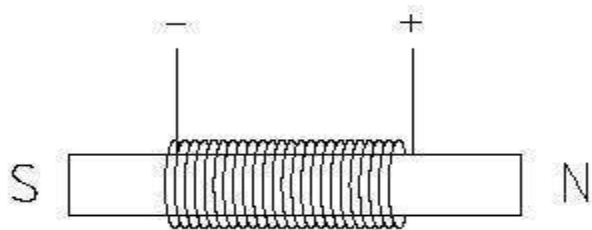
MAGNETIC CHUCKS FOR THE GRINDING MACHINES

Electromagnetic technologie :

When applying a continuous electrical current to a steel conductor, a magnetic field is created :



We can reverse the magnetic field by switching the polarity on the coil :



The magnetic field is generated by the activated coil. By sending continuous current, the inductor (the part that is being coiled) wraps itself in a magnetic field.

No current goes through the coil,

So there is no magnetic field and the part is free :



When sending a continuous current to the coil, We create a magnetic field and the part is held :

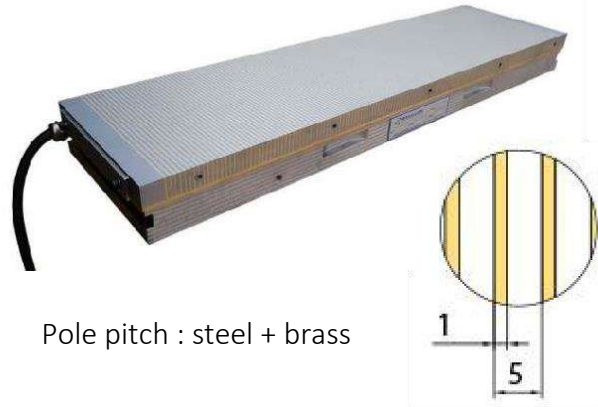


MAGNETIC CHUCKS FOR THE GRINDING MACHINES

Electromagnetic* chucks for grinding :

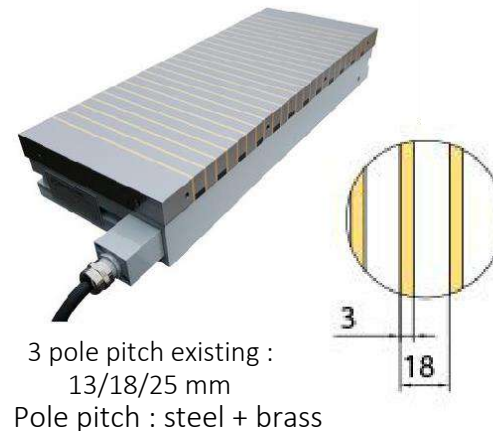
**Less security: In the event of a power supply failure, the part is not held and may be ejected*

REF. 10.24 Type EMU



The EMU chuck has a lower profile and somewhat different pole pattern offering a slightly better holding power in case of thin and small work piece. The maximum dimensions are 2000x500mm. Pole pitch can be transverse and longitudinal.

REF. 10.22 Type ICA



With a coarse, transverse, through going pole pattern of 15 mm steel and 5mm brass or 20 mm of steel and 5 mm of brass. The ICA chuck is a general purpose grinding chuck offering a good holding power on medium and large size components. Minimum work piece size is approximately 45x20x10 mm.

REF. 10.21 Type BJP



Multicoil electromagnetic system with uniform and strong magnetic field over the whole surface. The BJP chuck is an universal chuck for small, medium and large size work pieces. This chuck is more expensive than the others.

MAGNETIC CHUCKS FOR THE GRINDING MACHINES

Electromagnetic* circular chucks for grinding :

**Less security: In the event of a power supply failure, the part is not held and may be ejected*

REF. 11.10 Type ERC



With a radial poles for holding individual ring shaped components. The top plate can be provide with T- or swallow tail grooves to accommodate **pole shoes to raise** the component above the surface of the chuck and allow for a clearance for the tool. Number of poles depends of the workpiece

REF. 11.11 Type BC



With concentric polpitch
This chuck is for general applications. It's hold medium and large size components, either individually or nested together away from the center. The polpitch is 9 mm (5mm of steel and 4 mm of brass), or 16 mm (11 mm of steel and 4 mm of brass).

REF. 11.12 Type ERP



With fine parallel poles. This chuck has the same properties as the EMU and is especially suited for the holding of small and thin components for mass production

MAGNETIC CHUCKS FOR THE GRINDING MACHINES

Electro-permanent technologie:

Full demagnetization system

The ALNICO magnet is inactive.
It is not at all magnetized :



By sending a continuous electrical pulse to the coil.
The part is then magnetized and held firmly :



Compensated System

The magnetic flux locks itself inside the chuck and the part is released and free :



By sending an electrical pulse to the coil. We change the magnetic direction of the ALNICO magnet. This allows the magnetic flux to go through the part itself. The part is then held. To release the part, we send an inverted electrical pulse To the coil that enables the polar direction to change :




MAGNETIC CHUCKS FOR THE GRINDING MACHINES


The principal advantages :

BRAILLON MAGNETICS, inventor of Electro-Permanent technology, provides a range of powerful, reliable and waterproof Electro-Permanent magnetic chucks for all surface grinding applications.


The advantages of Electro-Permanent technology are unquestionable :

- 


SAFETY :

 - . The holding force is maintained even in case of power supply failure.
 - . Safety through interlock connection with the machine.
- 

PRECISION :

 - . Without heating, the magnetic chuck keeps its geometry.
 - . No temperature rise = high precision.
- 

ECOLOGICAL AND ECONOMICAL :

 - . No continuous energy consumption.
 - . No moving parts, no continuously powered coils = no wear.
- 

CONTROL OF THE FORCE :

 - . Possible to have a variable force.
 - . Full demagnetization = no residual magnetism

MAGNETIC CHUCKS FOR THE GRINDING MACHINES

Electro-permanent magnetic chucks for grinding :

EPT / EPTZ / POWERFINE

Electro-Permanent magnetic chuck for clamping of medium thick to thick elements.

Work piece type	Minimum thickness 8 mm
Pole pitch	14 + 8 mm
Construction	Steel+resin or steel+brass
Surface wear	5 mm
Accessories	End stops in both directions
Options	Through-going holes, air-blow system

EPICA

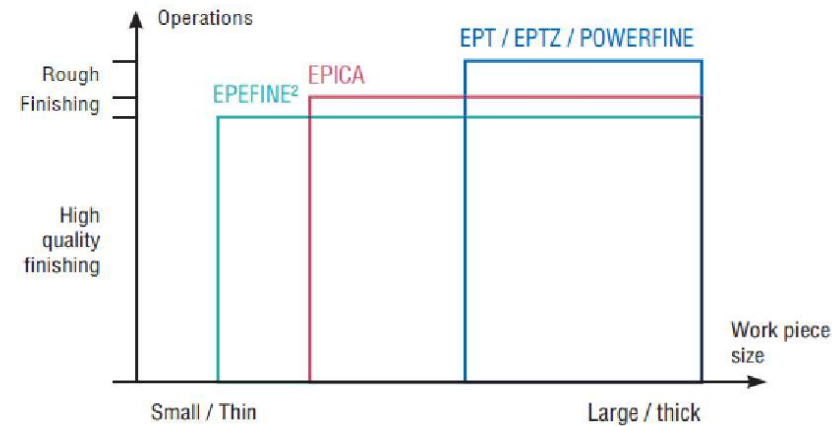
Universal Electro-Permanent magnetic chuck for clamping of standard work piece.

Work piece type	Minimum thickness 6 mm
Pole pitch	13 mm / 18 mm / 25 mm
Construction	Steel and brass, with top plate
Surface wear	6 mm
Accessories	End stops in both directions

EPEFINE²

Universal Electro-Permanent magnetic chuck with extra thin pole pitch, can be used for EDM applications. Ideal for clamping of very thin elements.

Work piece type	Minimum thickness 2 mm
Pole pitch	4 mm + 1 mm
Construction	Steel and brass, with top plate
Surface wear	6 mm
Accessories	End stops in both directions
Options	Through-going holes



MAGNETIC CHUCKS FOR THE GRINDING MACHINES

Electro-permanent magnetic chucks for grinding :

REF. 10.26.11 Type POWERFINE



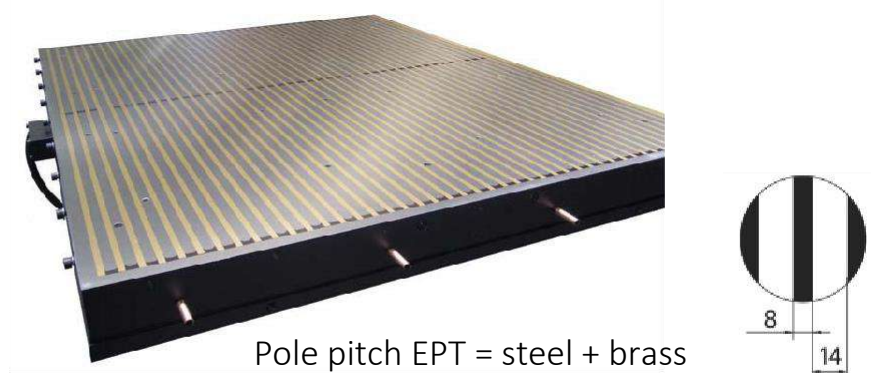
Pole pitch = steel + epoxy resin

- Relatively thin pole pitch for medium work pieces
- Minimum thickness of the pieces : 4mm
- Economical construction, without top plate.

Options :

- Compressed air holes

REF. 10.26.22 Type EPT/EPTZ



Pole pitch EPT = steel + brass

Pole pitch EPTZ = steel + Epoxy resin

- The brass air gaps offers a better resistance (less wear)
- For medium and large size work pieces (XX x 40 x 8 mm)
- Economical construction, without top plate.

Options :

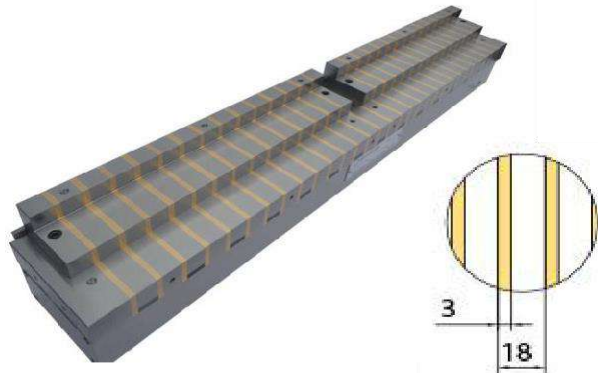
- Compressed air holes

No size limitations



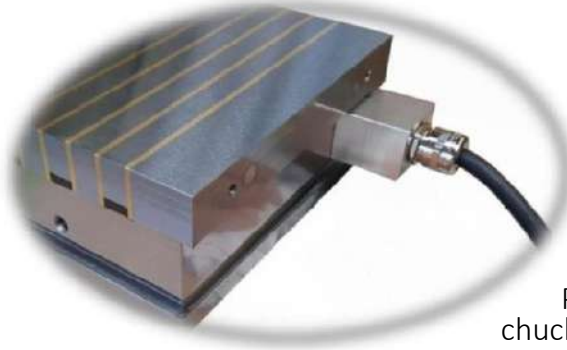
MAGNETIC CHUCKS FOR THE GRINDING MACHINES

Electro-permanent magnetic chucks for grinding :



Pole pitch = steel + brass

REF. 10.23 Type EPICA



Ideal for big tables and tall workpieces size : Heavy duty construction

Parallel transversal pole pitch throughout the whole width of the chuck

- 3 different pole pitches : 13/18/25 mm : This chuck answers at most grinding application
- Uniform and strong magnetic field (Magnetic field height : 5/8/10mm)
- Extremely stable construction

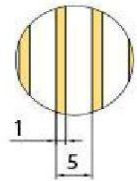
Options :Compressed air holes

MAGNETIC CHUCKS FOR THE GRINDING MACHINES

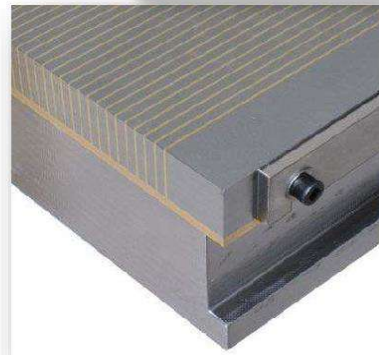
Electro-permanent magnetic chucks for grinding :



REF. 10.25 Type EPEFINE2



Pole pitch = steel + brass



The maximum dimensions
are 2000 x 900 mm

- Parallel transversal pole pitch throughout the whole width of the chuck
- Ideal for the small and thin workpieces (minimum of thickness 2mm), this chuck is universal chuck
- Uniform and strong magnetic field (Magnetic field height : 5

Options :

- Compressed air holes

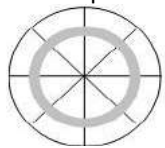
MAGNETIC CHUCKS FOR THE GRINDING MACHINES

Electro-Permanent circular chucks for grinding and turning :

REF. 11.14 Type EPERC



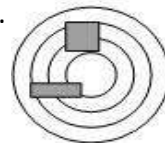
With a radial poles for holding individual ring shaped components. The top plate can be provide with T- or swallow tail grooves to accommodate **pole shoes to raise** the component above the surface of the chuck and allow for a clearance for the tool. Number of poles depends of the workpiece



REF. 11.16 Type EPBC



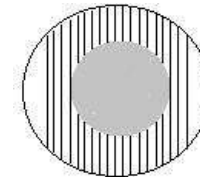
With concentric polpitch
This chuck is for general applications. It's hold medium and large size components, either individually or nested together away from the center. The polpitch is 9 mm (5mm of steel and 4 mm of brass), or 16 mm (11 mm of steel and 4 mm of brass).



REF. 11.17 Type EPERU

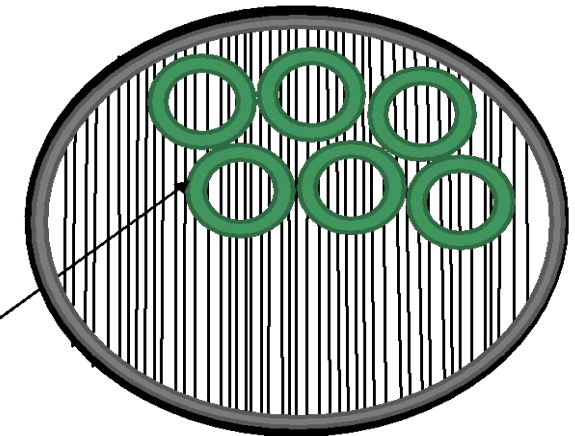
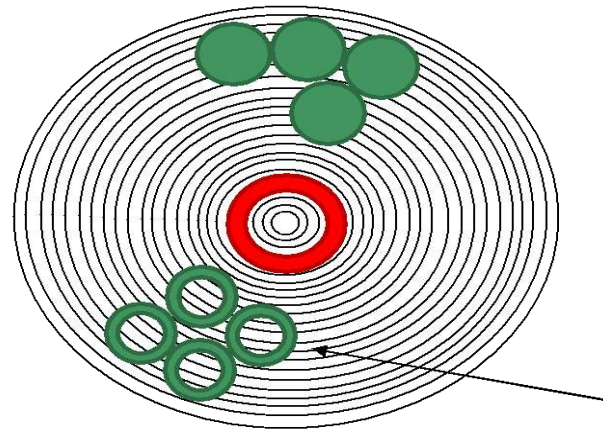
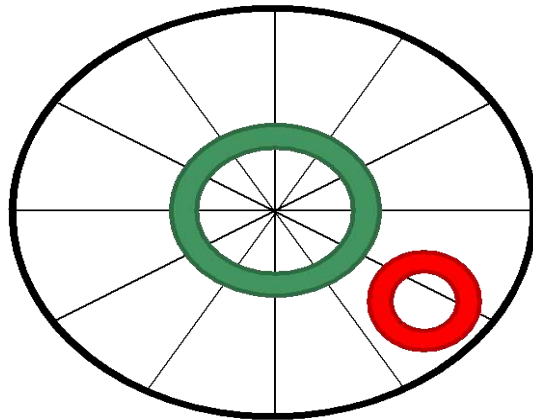


With fine parallel poles. This chuck has the same properties as the EMU and is especially suited for the holding of small and thin components for mass production



MAGNETIC CHUCKS FOR THE GRINDING MACHINES

Position of workpieces on the circular chucks :

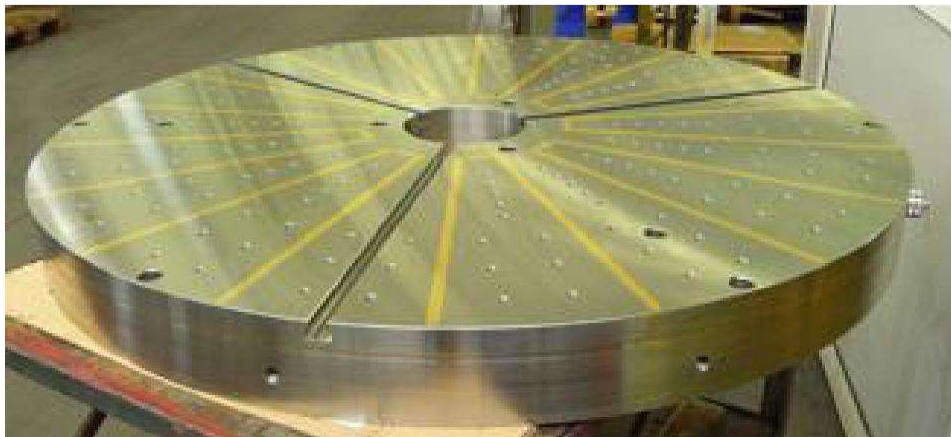


Red color = bad position

In this case the thickness of ring is very important.

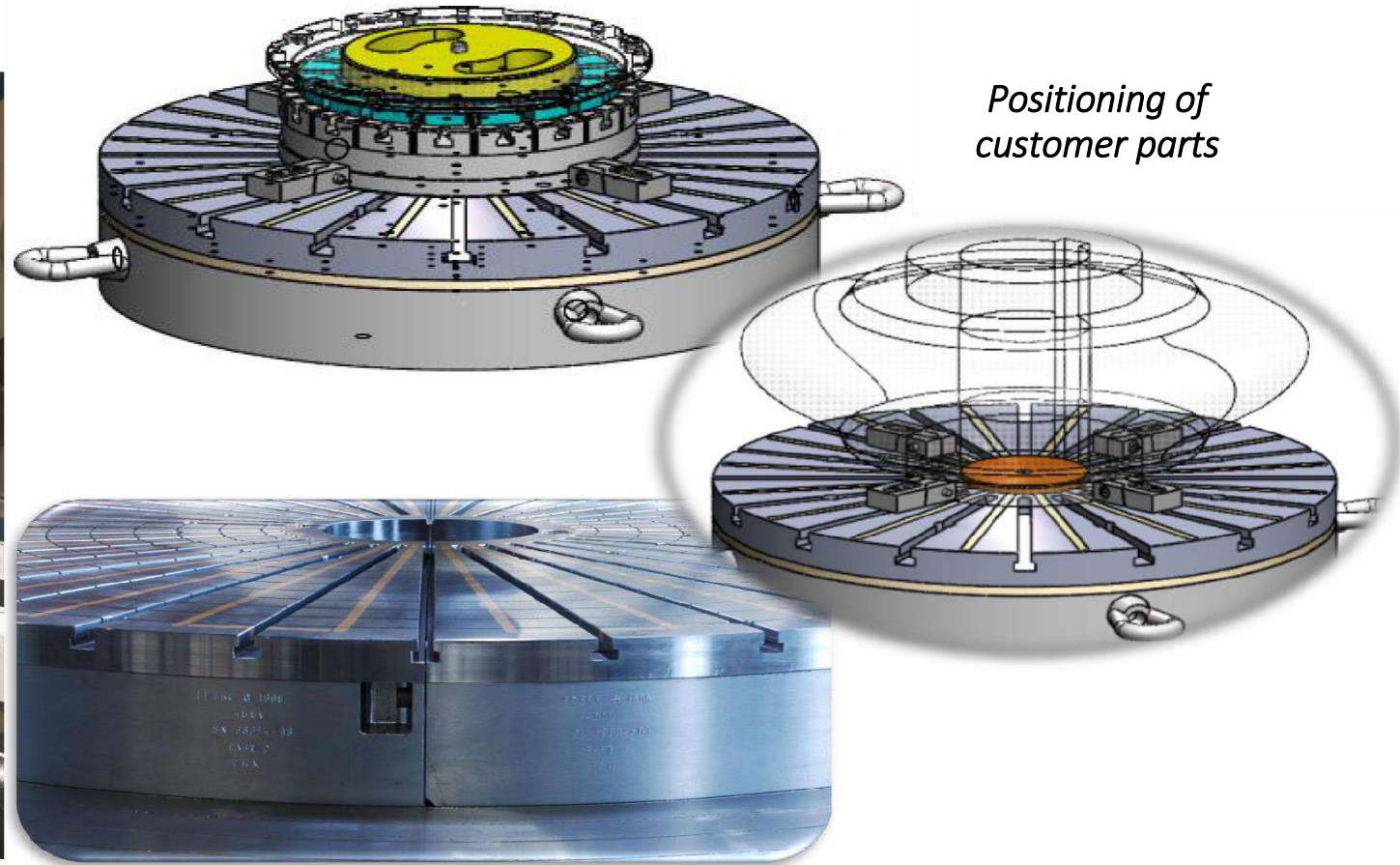
MAGNETIC CHUCKS FOR THE GRINDING MACHINES

Some example of our achievements :




MAGNETIC CHUCKS FOR THE GRINDING MACHINES

Some example of our achievements :




MAGNETIC CHUCKS FOR THE GRINDING MACHINES

Control unit engineered for electro-permanent and electromagnetic chucks :



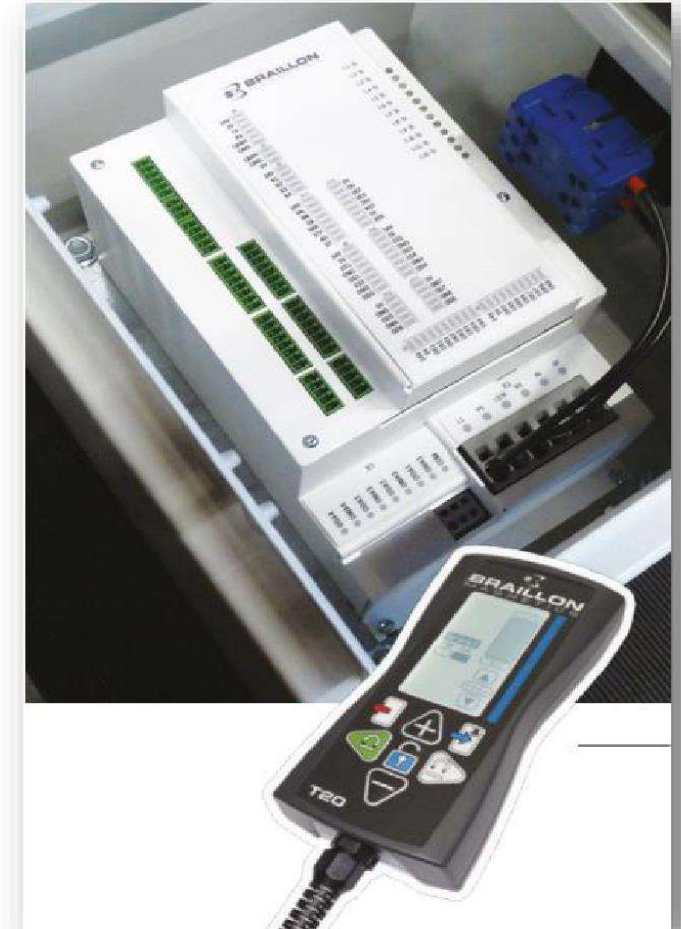
Control unit MC20

- Will control up to 8 Magnetic chucks
- Operate up to 4 work zone
- Capable of managing multiple size chucks, for magnetizing and demagnetizing
- Will work with Brailion made chucks and multiple other chuck brands, available for both electro-permanent and electromagnetic type chucks
- Total demagnetization
- Machine interface
- Off-site Remote Assistance
- Parameter setting with a simple USB key



Remote control T20

- Set the minimum safety threshold to allow machine operation
- Precise adjustment of magnetization force
- Tip off function
- Up to 10 custom demagnetization programs
- Several language options
- History of the completed actions



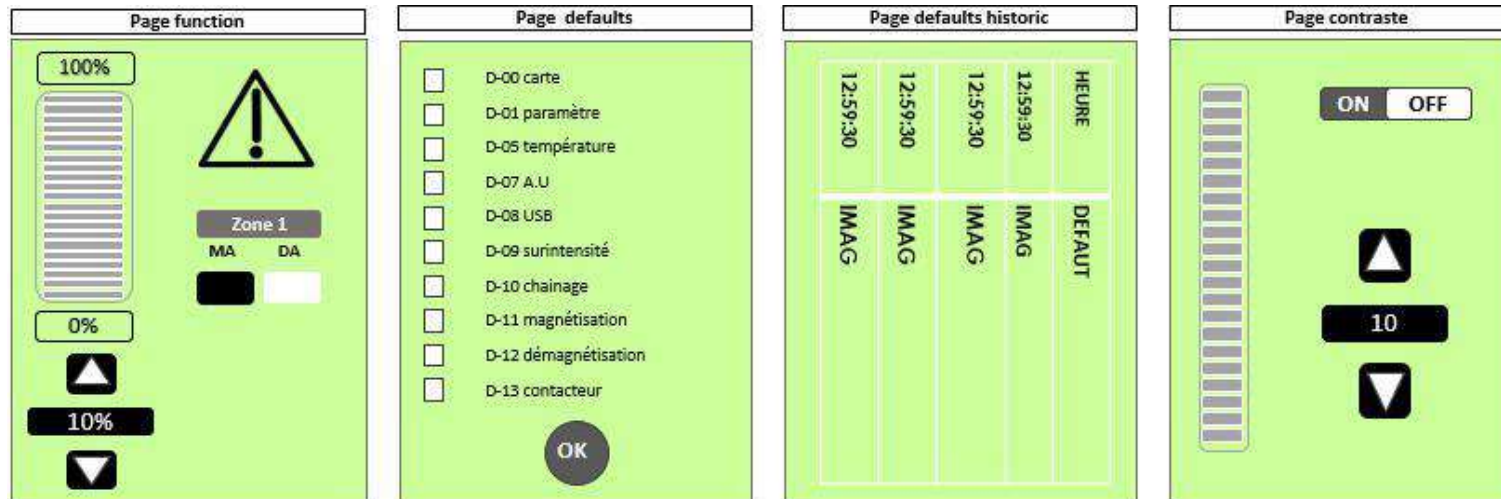
MAGNETIC CHUCKS FOR THE GRINDING MACHINES

Presentation of the various pages of the T20 remote control :

<p>Start page</p> <p>03/07/19 FR 13:14:24</p> <p>BRAILLON MAGNETICS</p> <p>Version soft</p>	<p>Page 1 parameters</p> <p>1-Zone selection 2-Minimum threshold 3-N° of programm 4-Control 5-Défaults 6-Defaults historic</p>	<p>Page 2 parameters</p> <p>1-Language 2-Date/hour 3-Contraste 4-Backlight</p>	<p>Page 3 parameters</p> <p>1-Variable force down</p>	<p>Page selection zone</p> <p>Zone 1 ON OFF Zone 2 ON OFF Zone 3 ON OFF Zone 4 ON OFF</p>								
<p>Page function</p> <p>100%</p> <p>Zone 1 MA DA Zone 2 MA DA Zone 3 MA DA Zone 4 MA DA</p> <p>0%</p> <p>10%</p>	<p>Page setting threshold level</p> <p>10%</p>	<p>Page programs</p> <ul style="list-style-type: none"> <input type="checkbox"/> -P0 <input type="checkbox"/> -P1 <input checked="" type="checkbox"/> -P2 <input type="checkbox"/> -P3 <input type="checkbox"/> -P4 <input type="checkbox"/> -P5 <input type="checkbox"/> -P6 <input type="checkbox"/> -P7 <input type="checkbox"/> -P8 <input type="checkbox"/> -P9 	<p>Language choice page</p> <ul style="list-style-type: none"> <input checked="" type="checkbox"/> -English <input type="checkbox"/> -French <input type="checkbox"/> -German <input type="checkbox"/> -Spain <input type="checkbox"/> -Italian <input type="checkbox"/> -Portuguese <input type="checkbox"/> -Japanese 	<p>Page control</p> <p>Ampers</p> <table border="1"> <tr> <th>TH1</th> <th>TH2</th> </tr> <tr> <td>125</td> <td>125</td> </tr> <tr> <td>145</td> <td>145</td> </tr> <tr> <td>160</td> <td>160</td> </tr> </table> <p>Frequency</p> <p>49,5 HZ</p> <p>Voltage control</p> <p>38,9V</p>	TH1	TH2	125	125	145	145	160	160
TH1	TH2											
125	125											
145	145											
160	160											

MAGNETIC CHUCKS FOR THE GRINDING MACHINES

Presentation of the various pages of the T20 remote control :



Options :

- Special voltages : On request, from 200 to 480 VAC.
- Radio remote control : This option makes the remote pendant wireless
- Footswitch remote control : This makes the control unid hands
- QMC EUROMAP INTERFACE : This provides standardized signals for quick mould change applications
- Cooling system : Available for warm environments
- Parking socket : Prohibits the start of the machine if the cable is plugged into the chuck : Turning or paletizing applications
- PLC Machine or T20 : Possible to choose the machine interface or T20 remote control.

FILTERS FOR THE GRINDING MACHINES

Magnetic drum separators :



REF. 60.51 Type MD

The magnetic separators with rotating drum MD allow to purify all the ferrous and abrasive impurities of the coolant coming from the machining of machine tools. A special scraper blade is used to remove excess sludge and convey it to the special collection box.

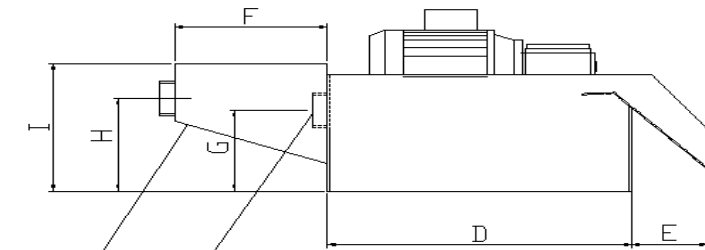
But that's not all : it is also an excellent pre-filter to combine with paper filters, to create a double action of filtering by considerably reducing the consumption of filter paper.

All this also makes it possible to obtain a better purification of the coolant and to keep its characteristics physical and mechanical intact, with reduced maintenance and fluid replacement costs.

Good lubricant quality ensures maximum accuracy in the work of the machine tool.

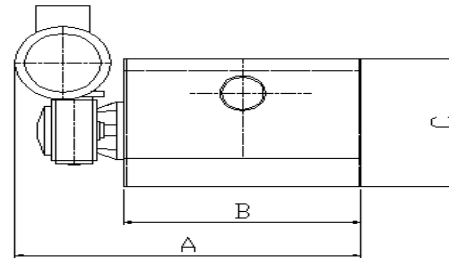
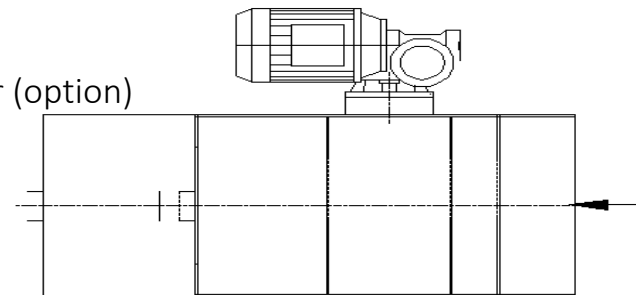
FILTERS FOR THE GRINDING MACHINES

Magnetic drum separators :



Connection sleeve

Aerator (option)



Note: The flow rates mentioned in the table correspond for a water / oil emulsified liquid, for a liquid containing only oil, the dimensions and capacities of the tank can change.

REF.	CAPACITY L/MIN	CONNECTION SLEEVE	A	B	C	D	E	F	G	H	I	Kg
60.51.50	50	2 "	364	164	225	380	100	200	140	170	230	35
60.51.100	100	2 "	436	236	225	380	100	200	140	170	230	45
60.51.150	150	3 "	544	344	225	380	100	200	140	170	230	55
60.51.200	200	3 "	616	416	225	380	100	200	140	170	230	60
60.51.250	250	3 "	724	524	225	380	100	200	140	185	265	75
60.51.300	300	3 "	832	632	225	380	100	200	140	185	265	85
60.51.350	350	3 "	1012	812	225	380	100	200	140	185	265	110
60.51.400	400	3 "	1228	1028	225	360	100	200	140	185	265	135

Left Right

FILTERS FOR THE GRINDING MACHINES

Magnetic drum separators : Electrical characteristics

MAGNETIC DRUM SEPARATORS TYPE MD				
MODELE	POWER (KW)	VOLTAGE/FREQUENCY	SPEED	RATIO
60.51.50	0,12	230-400 V / 50 Hz Tree phase	1400 rpm. – 4 poles	1/600
60.51.100	0,12	230-400 V / 50 Hz Tree phase	1400 rpm. – 4 poles	1/600
60.51.150	0,12	230-400 V / 50 Hz Tree phase	1400 rpm. – 4 poles	1/600
60.51.200	0,12	230-400 V / 50 Hz Tree phase	1400 rpm. – 4 poles	1/600
60.51.250	0,12	230-400 V / 50 Hz Tree phase	1400 rpm. – 4 poles	1/600
60.51.300	0,12	230-400 V / 50 Hz Tree phase	1400 rpm. – 4 poles	1/600
60.51.350	0,12	230-400 V / 50 Hz Tree phase	1400 rpm. – 4 poles	1/600
60.51.400	0,12	230-400 V / 50 Hz Tree phase	1400 rpm. – 4 poles	1/600

Alimentation - 400 V / 50 Hz			
MODELE	VOLTAGE FREQUENCY	POWER (KW)	CURRENT (A)
60.51.50	400V/50Hz Tree phase	0.12	0.47
60.51.100	400V/50Hz Tree phase	0.12	0.47
60.51.150	400V/50Hz Tree phase	0.12	0.47
60.51.200	400V/50Hz Tree phase	0.12	0.47
60.51.250	400V/50Hz Tree phase	0.12	0.47
60.51.300	400V/50Hz Tree phase	0.12	0.47
60.51.350	400V/50Hz Tree phase	0.12	0.47
60.51.400	400V/50Hz Tree phase	0.18	0.47

Alimentation - 230 V / 50 Hz			
MODELE	VOLTAGE FREQUENCY	POWER (KW)	CURRENT (A)
60.51.50	230V/50Hz Tree phase	0.12	0.82
60.51.100	230V/50Hz Tree phase	0.12	0.82
60.51.150	230V/50Hz Tree phase	0.12	0.82
60.51.200	230V/50Hz Tree phase	0.12	0.82
60.51.250	230V/50Hz Tree phase	0.12	0.82
60.51.300	230V/50Hz Tree phase	0.12	0.82
60.51.350	230V/50Hz Tree phase	0.12	0.82
60.51.400	230V/50Hz Tree phase	0.18	0.82

FILTERS FOR THE GRINDING MACHINES

Paper filters :



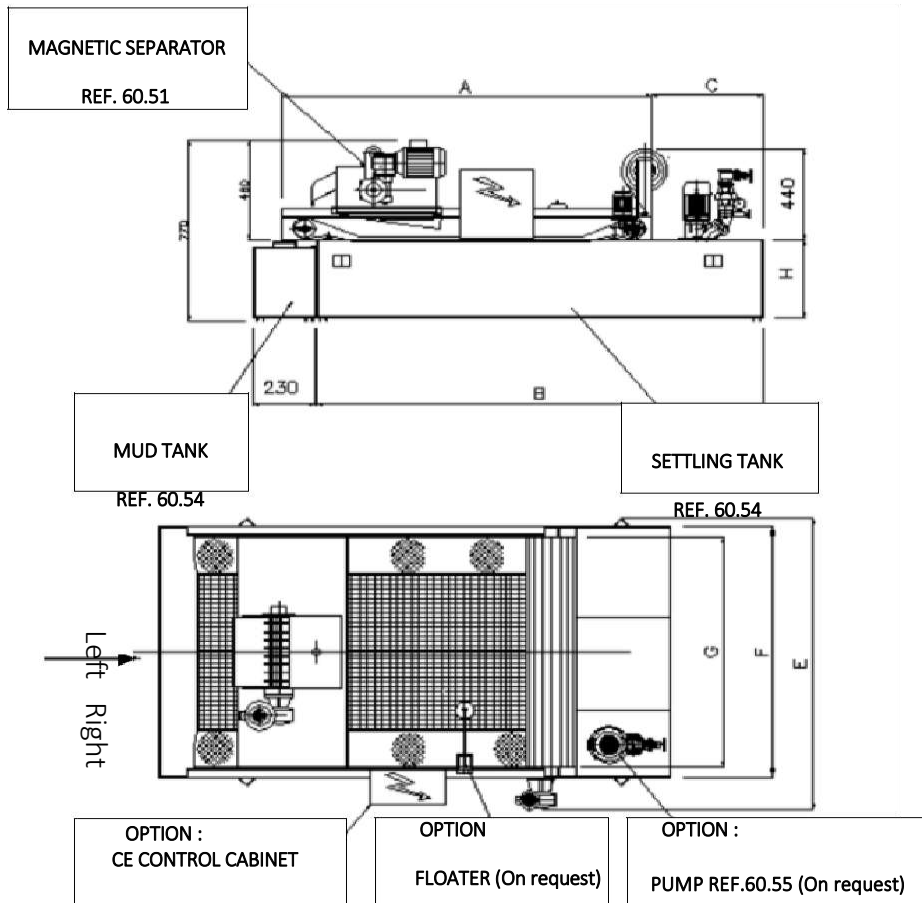
REF. 60.52 Type P

Paper filters of this type are particularly suitable for the purification of coolant lubricants with a high content of ferrous particles used on machine tools for large removals such as grinding machines, machining centers, lapping machines, etc.

The automatic paper filters unwinding are devices in which the filtration takes place by gravity at through filter paper. The liquid to be purified is conveyed via a diffuser into a mud tank (sold separately - optional) where the treatment sludge is deposited. The liquid thus purified is then collected in the retention tank (sold separately - optional). This filtration system is suitable for all machine tools for chip removal, which also allows great flexibility in the choice of filter paper and therefore the degree of filtration. P type paper unwinding filters can be easily combined with magnetic disc filters type MD, thus allowing double filtration and reducing the consumption of filter paper.

FILTERS FOR THE GRINDING MACHINES

Paper filters :



Note: The flow rates mentioned in the table correspond for a water / oil emulsified liquid, for a liquid containing only oil, the dimensions and capacities of the tank can change.

REF.	CAPACITY L/MIN	CAPACITY OF TANK IN LITERS	A	B	C	D	E	F	G
60.52.50	50	200	1250	1400	300	300	730	580	500
60.52.100	100	320	1400	1600	350	300	930	780	700
60.52.150	150	470	1500	1700	350	300	1230	1080	1000
60.52.200	200	620	2000	2200	350	300	1230	1080	1000
60.52.250	250	760	2500	2700	350	300	1230	1080	1000
60.52.300	300	900	3000	3200	350	300	1230	1080	1400
60.52.400	400	1300	3100	3350	400	300	1630	1500	1400

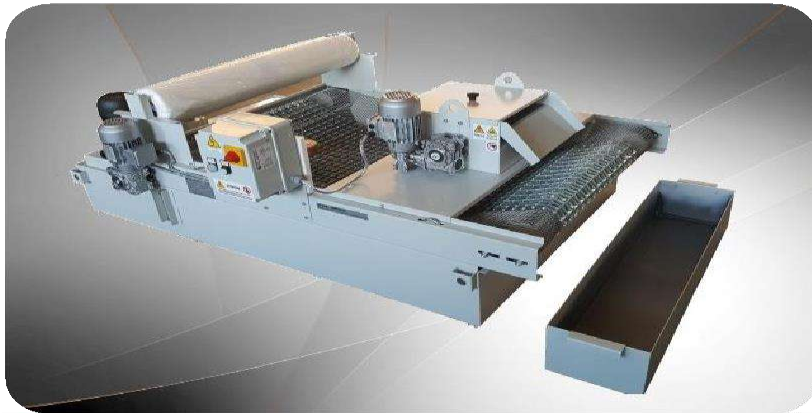
FILTERS FOR THE GRINDING MACHINES

Paper filters : Electrical characteristics

PAPER FILTERS TYPE P			
MODELE	POWER (KW)	VOLTAGE FREQUENCY	SPEED
60.52.50	0,12	230-400 V / 50 Hz Tree phase	1400 rpm. – 4 poles
60.52.100	0,12	230-400 V / 50 Hz Tree phase	1400 rpm. – 4 poles
60.52.150	0,12	230-400 V / 50 Hz Tree phase	1400 rpm. – 4 poles
60.52.200	0,12	230-400 V / 50 Hz Tree phase	1400 rpm. – 4 poles
60.52.250	0,12	230-400 V / 50 Hz Tree phase	1400 rpm. – 4 poles
60.52.300	0,12	230-400 V / 50 Hz Tree phase	1400 rpm. – 4 poles
60.52.400	0,12	230-400 V / 50 Hz Tree phase	1400 rpm. – 4 poles

FILTERS FOR THE GRINDING MACHINES

Complete filter : Paper filters + Magnetic drum separator



REF. 60.53

The liquid resulting from the treatment, after having passed through the magnetic separator which eliminates the ferrous particles, passes through the filter cloth which retains all the remaining particles of any kind still in suspension, the ferrous mud attracted by the magnetic separator is evacuated in the zone front end of the filter onto the already clogged filter cloth.

The inclination of the filter bed towards the interior of the device facilitates their drainage.

When the filter cloth is clogged, the liquid can no longer pass through it and collects in the filter bag until a level sensor is activated which causes the automatic advance of the filter bed.

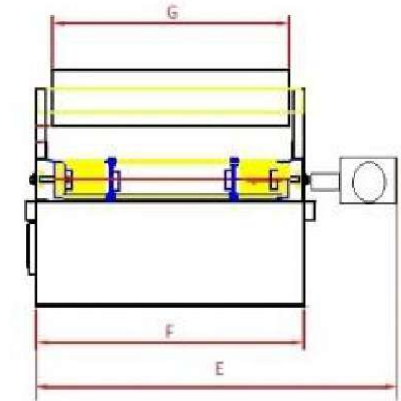
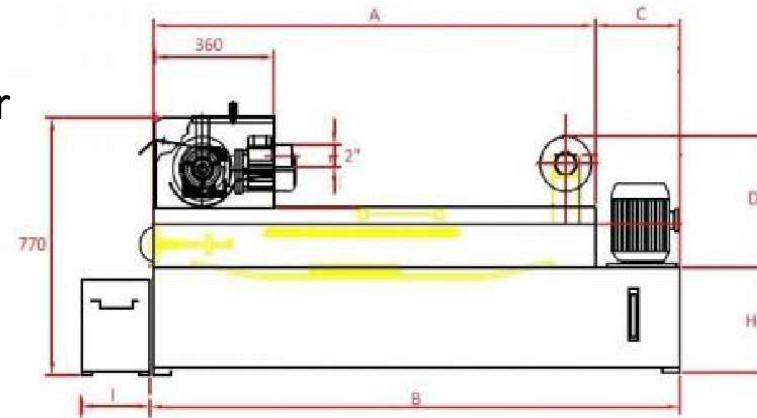
The sludge and the filter cloth on which it is deposited thus fall into the special collection container.

Replacing a section of filter cloth causes the liquid level in the filter bag to drop, which stops its advancement.

The specially calculated gear motor ensures optimum travel speed to minimize the consumption of the filter cloth and facilitate sludge removal.

FILTERS FOR THE GRINDING MACHINES

Complete filter : Paper filters + Magnetic drum separator



REF.	CAPACITY L/MIN	A	B	C	D	E	F	G	H	I
60.53.50	50	1250	1400	280	440	720	580	500	300	230
60.53.100	100	1400	1600	280	440	930	780	700	300	230
60.53.150	150	1500	1700	300	440	1230	1080	1000	300	230
60.53.200	200	2000	2200	300	440	1230	1080	1000	300	230
60.53.250	250	2500	2700	300	440	1230	1080	1000	300	230
60.53.300	300	3000	3200	350	440	1230	1080	1000	300	230
60.53.350	350	3000	3250	350	440	1230	1080	1000	300	230
60.53.400	400	3100	3350	350	440	1630	1500	1400	300	230
60.53.500	500	3600	3850	350	440	1630	1500	1400	300	230
60.53.600	600	4100	4550	350	440	1630	1500	1400	300	230

DEMAGNETIZATION SYSTEMS AFTER THE GRINDING OPERATION

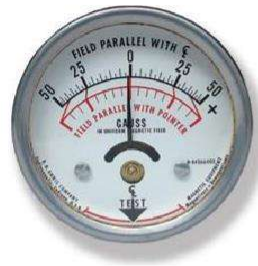
Measure accessories : 3 types of devices

Any workpieces that are machined on magnetic chucks retain a certain residual magnetism, the degree of which essentially depends on the composition of the steel.

Mild steels are hardly remanent at all, whereas alloy steels, and particularly those containing high proportions of chrome, cobalt tungsten, etc. (which cannot always be completely demagnetized on our electromagnetic chucks) are just the opposite.

This residual magnetism can be troublesome in, for exemple, components that are subjected to friction or sliding.

16.07.MGMR



Analogue Mini Gaussmeter type MGMR

16.07.MGMD



Digital Mini Gaussmeter type GM DIGIT

16.06.HGMs



Tesla-meter with hall effect probe type HGMs

DEMAGNETIZATION SYSTEMS AFTER THE GRINDING OPERATION

Hand demagnetizers :



16.03.TOOL

Hand demagnetizer type



16.03.HD

Hand demagnetizer type



16.03.M1

Hand demagnetizer type

DEMAGNETIZATION SYSTEMS AFTER THE GRINDING OPERATION

Plate demagnetizers :

- Extremely efficient automatic adjustment of magnetic field intensity depending on workpiece size
- Use for up to 50 mm thick workpieces
- For bigger workpieces we recommend to use tunnel demagnetizers
- Coil protected by aluminium housing
- During the demagnetization cycle the workpiece should be moved at low and constant speed through the alternative field of demagnetizer (recommended speed: 0,05 to 0.2 m/sec.)



Standard plates type DM3, DM4, DM5



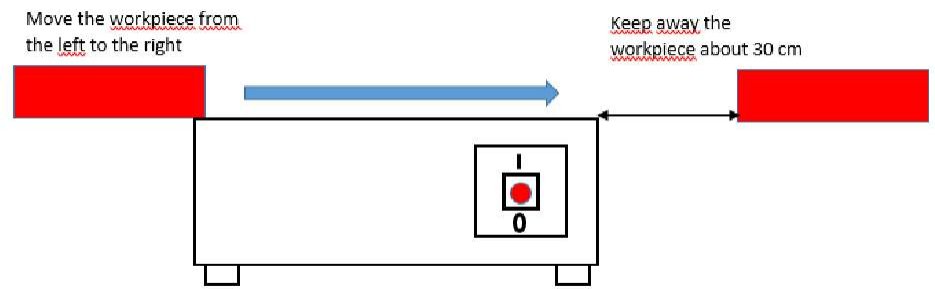
Reinforced plates type DP

DEMAGNETIZATION SYSTEMS AFTER THE GRINDING OPERATION

Plate demagnetizers :



Type	Size (mm)	Active width (mm)	Power (VA)	Weight (Kg)
DM3	250x180x87	150	700	9
DM4	280x266x87	250	700	14
DM5	400x306x87	280	700	19



DP160	278x148x121	160	850	22
DP250	368x148x121	250	1380	30
DP400	518x148x121	400	2050	46

DEMAGNETIZATION SYSTEMS AFTER THE GRINDING OPERATION

Tunnel demagnetizers :

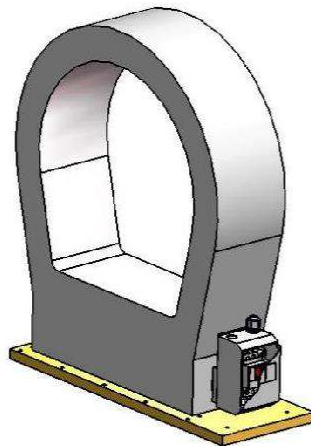
REF. 16.04.T and 16.04.DT

A tunnel demagnetizer is used to demagnetize steel work pieces. The device produces an alternating magnetic field which disorientates the magnetic domains in the work piece.

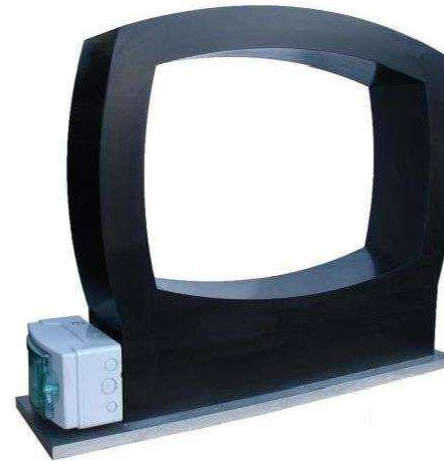
In order to obtain a good demagnetization, the field intensity must be slowly reduced. This is obtained by moving the work piece slowly and gradually through the opening of the tunnel and removing it slowly from the tunnel up to a certain minimum distance.



T1 and T2



T4



T5



Tunnel type DT

The choice of tunnel depends on the size of the parts to be demagnetized

DEMAGNETIZATION SYSTEMS AFTER THE GRINDING OPERATION

Conveyor of demagnetization :

REF. 16.05

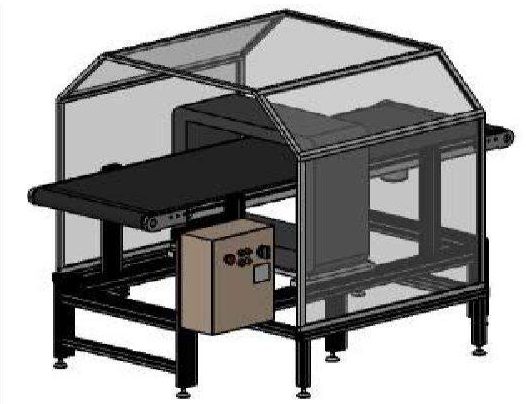


Tunnel type T4 with belt roll conveyor conveyor

Tunnel type DT with belt conveyor for bulk parts



Tunnel type T5 with manual



The systems of demagnetization BRAILLON are equipped with an (optional) fairing to take away the staff of the source of the electromagnetic filed.

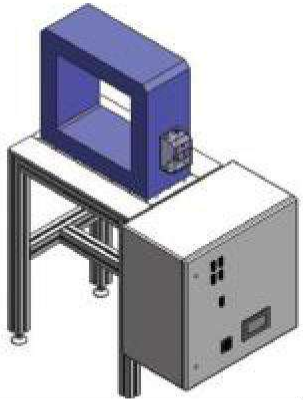
DEMAGNETIZATION SYSTEMS AFTER THE GRINDING OPERATION

Conveyor of demagnetization : Some of our achievements

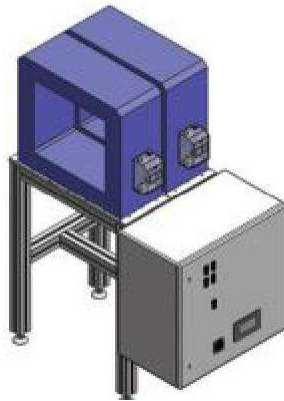


DEMAGNETIZATION SYSTEMS AFTER THE GRINDING OPERATION

Complexe demagnetization : Static demagnetizer with pulse controller



Single or double demagnetizer tunnel with pulse controller



Pulse demagnetization

The method is characterized by the precise control of voltage and frequency to provide an optimally tailored AC current pulse flowing through the demag coil. The demag coils are designed to provide maximum performance with the controlled current pulse. The parts to be demagnetized are placed within the effective range of the coil and the pulse is triggered. The pulse parameters are controlled by a modern PLC. The decaying alternating field profile required for demagnetization is highly reproducible and independent of the operator of the system.

The power module constantly feeds current during the decaying field phase according to a programmed demagnetizing curve. The demagnetizing process is thus largely independent of the load of the coil and can be realized with any number of decreasing polarity reversals. As a further advantage, high field strength can be generated by this technology. The heating of the coils is kept under control when operating in pulse mode (short duty cycle at high power).

The **progressive frequency pulse demagnetization method** offers decisive technological advantages:

- Reduced safety distance with regard to personal protection
- High penetration depth of the demagnetizing effect
- Short demagnetization pulse duration

Our power modules are only equipped with industrially proven components. The PLC software and the programming of the current sources is our own know-how. This technical concept allows the demagnetizing pulse to be mastered down to the smallest detail and thus allows us to optimally design it for your application.

The coils and power modules are coordinated with each other by means of a calculation based simulation. This ensures the greatest possible demagnetizing effect and a long lifetime of the machine.

If the requirements should once change, an already delivered demagnetization machine is easily adapted to a new situation by readjusting software and programming.

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