

ReUse MAE: Miscellaneous / other

Proceedings / MAE (Operation / Process)

MAE manufacturer (MAE manufacturer)

Machine type (Machine type)

Serial No. (Serial No.)

Year of construction (Year of manufacture)

Inventory number (Equipment number)

CE conformity (CE certificate)

documentation (Documentation)

Cell stack press and Laser welding
(pressing cell stack and laser welding=)

Aumann Limbach- Oberfrohn GmbH

Automatic station within one assembly line (automatic station within an assembly line)

61658_20.05.2022_Station 040

2023

205264755

Yes (yes)

German (German)

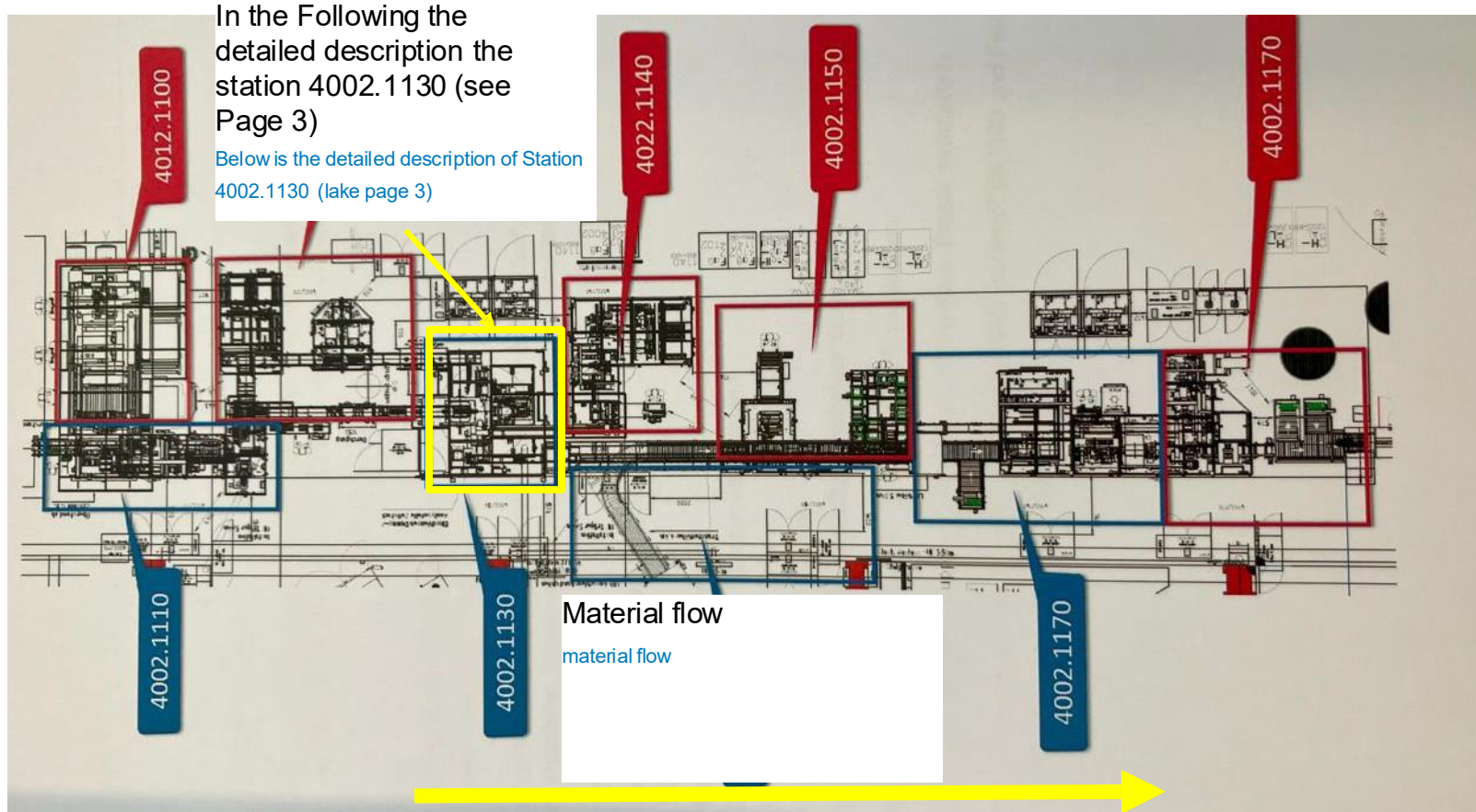


In the following document is in case of doubt the German version valid

(In the following document, the German version is valid in case of doubt)

ReUse MAE: Miscellaneous / other

Embedding station in Line network/integration of the station into the line



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Work positions St.4002.1120/Workposition St.4002.1130



General A notice:

Through Safety sensors the Pilz & IFM becomes ensured that it none contact between the components gives

Safety sensors from Pilz & IFM ensure that there is no contact between the components

station incl. not OK Rejection and Buffer spaces

station including not OK reject chutes and buffer spaces

ReUse MAE: Miscellaneous / other

Pictures Station overview / Pictures station

o



Operator side

operator side



portal to Material provision from St. 4022.1140

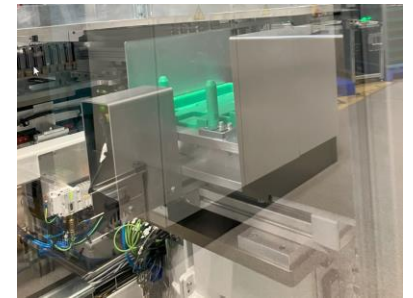
portal for material commission from St. 4022.1140

Buffer position Workpiece carrier

buffer position for workpiece carriers

Reject drawer

reject drawer.

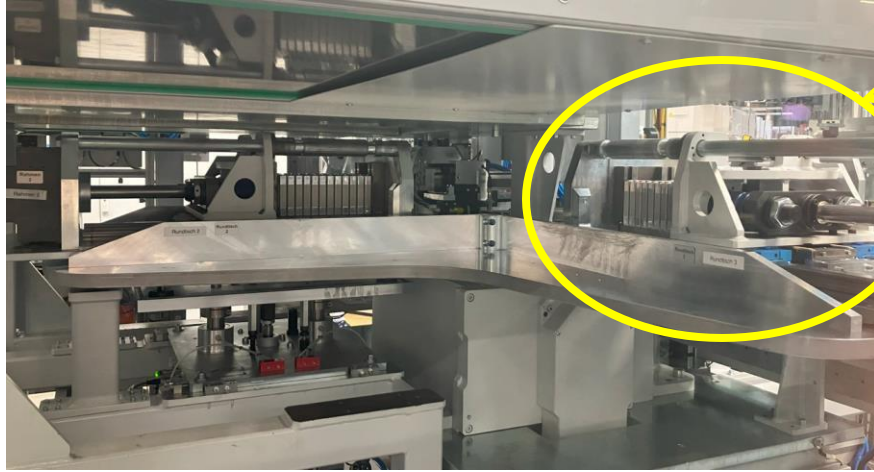


Interior view -
Reject drawer

view from the inside - reject
drawer.

ReUse MAE: Miscellaneous / other **images** Round table / **Pictures**

rotary table



Tension frame for
pressed cells

clamping frame for pressed
cells.

Round
table

rotary table



12- fold gripper
Cell handling

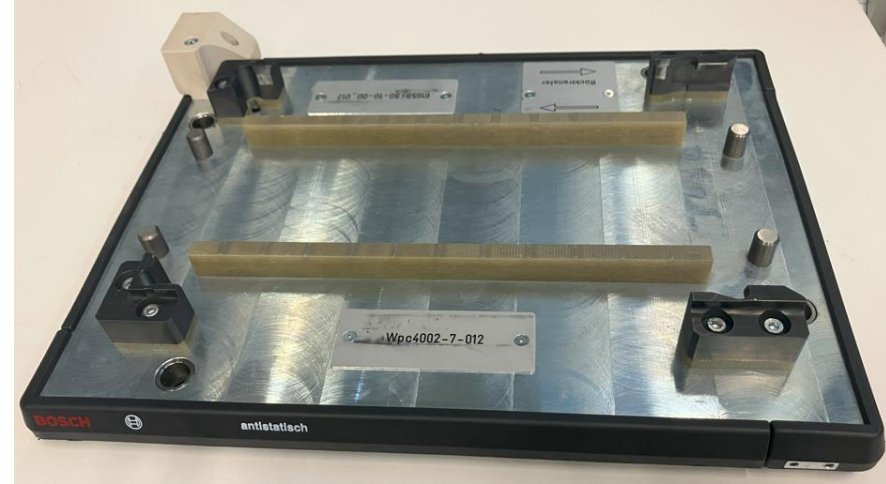
12- fold gripper cell handling

ReUse MAE: Miscellaneous / other **images / Pictures**



gripper Cell
stack for filling in
workpiece
carrier

Gripper for cell stack for
placement in workpiece
carriers



Workpiece
carrier
(workpiece carrier)

ReUse- MAE: Miscellaneous / other [images](#) [Kistler press](#) / [Pictures](#)

[Kistler press](#)



Kistler press [Kisler press](#)

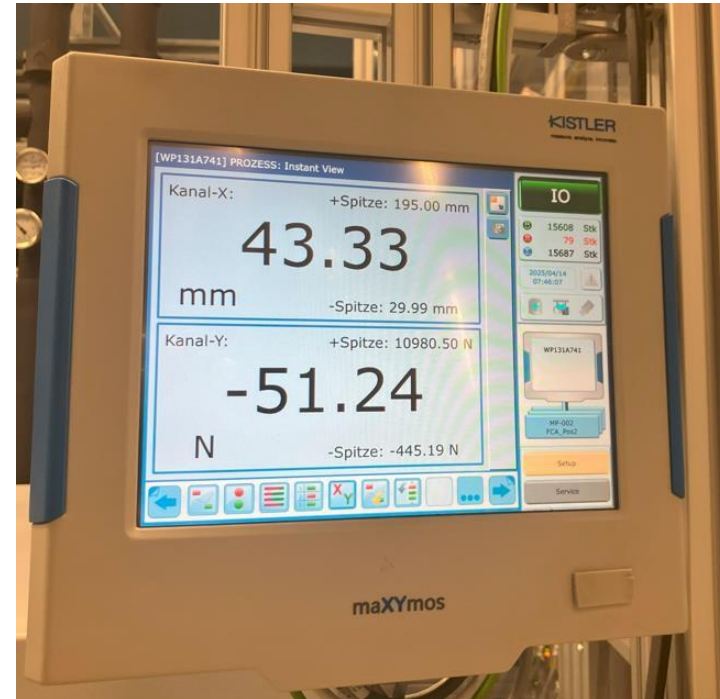
Type : 2151815022001

Model : NCFH 15 200 300 B H C G

Serial No. : H2-

01336 Nominal

Force : 15kN

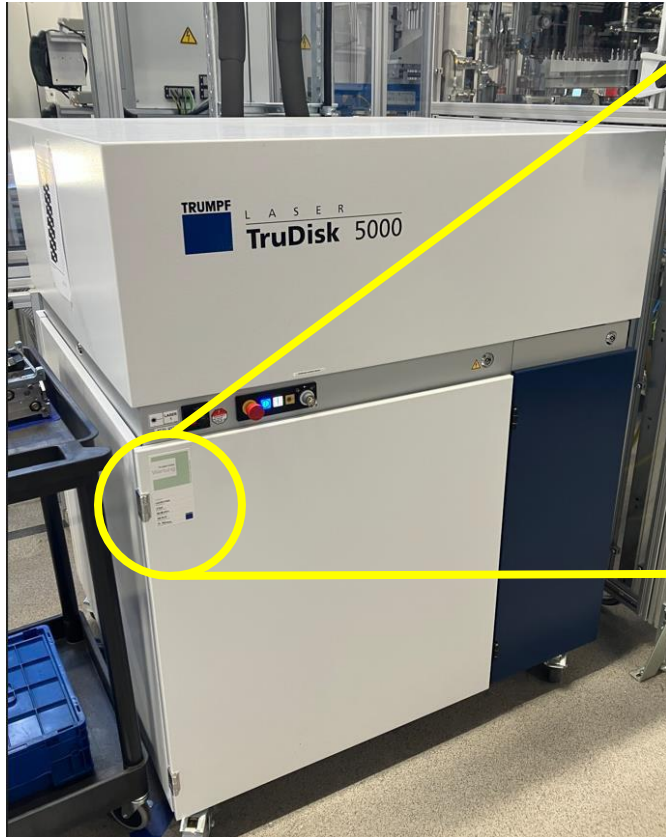


Visualization press

[visualization press](#)

ReUse MAE: Miscellaneous / other images Trump Laser / Pictures

Trump laser

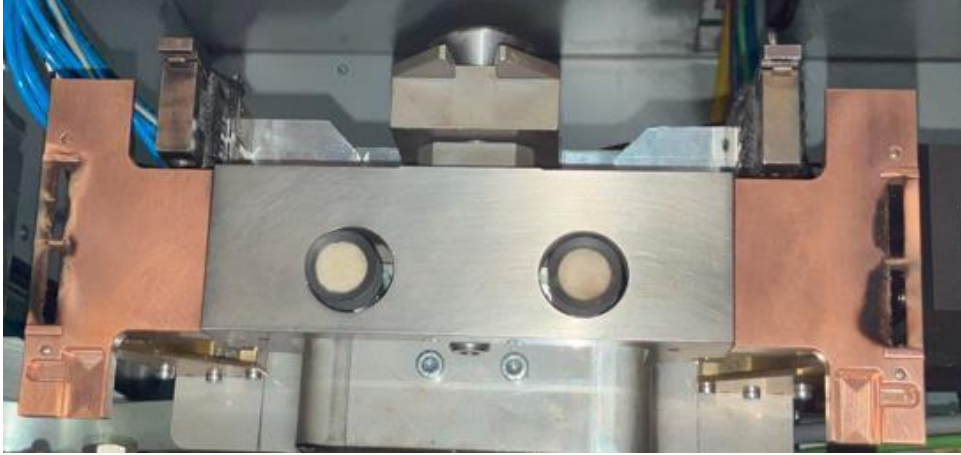


Visualization
visualization

station incl. laser power
load cells

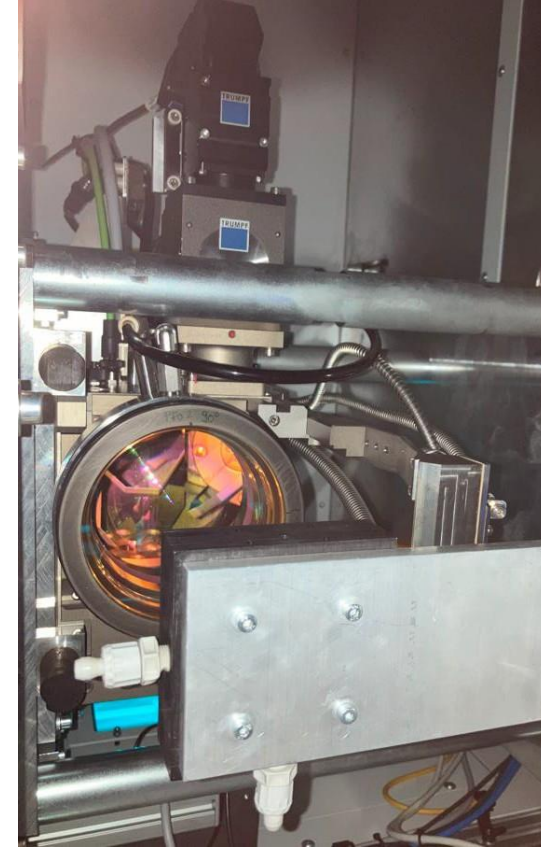
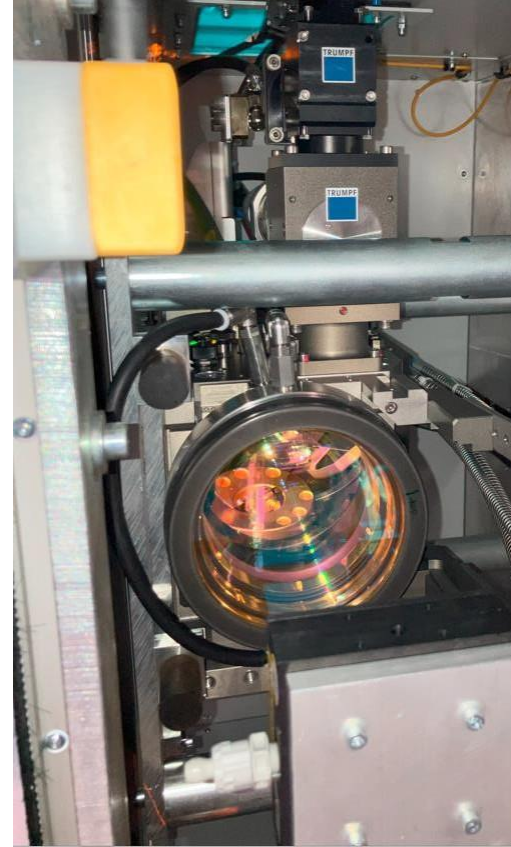
- station including laser power measurement
devices

ReUse MAE: Miscellaneous / other [images](#) / [Pictures](#)



welding mask

[welding mask](#)



Laser
optics

[welding optics](#)

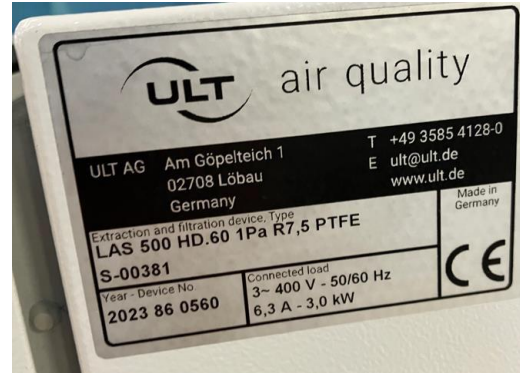
ReUse MAE: Miscellaneous / other

Pictures ULT Laser extraction / Pictures ULT laser extraction

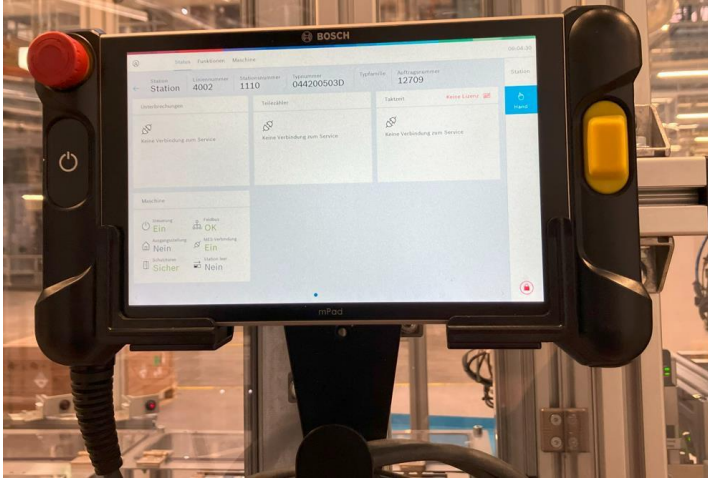


back ULT

Back side ULT

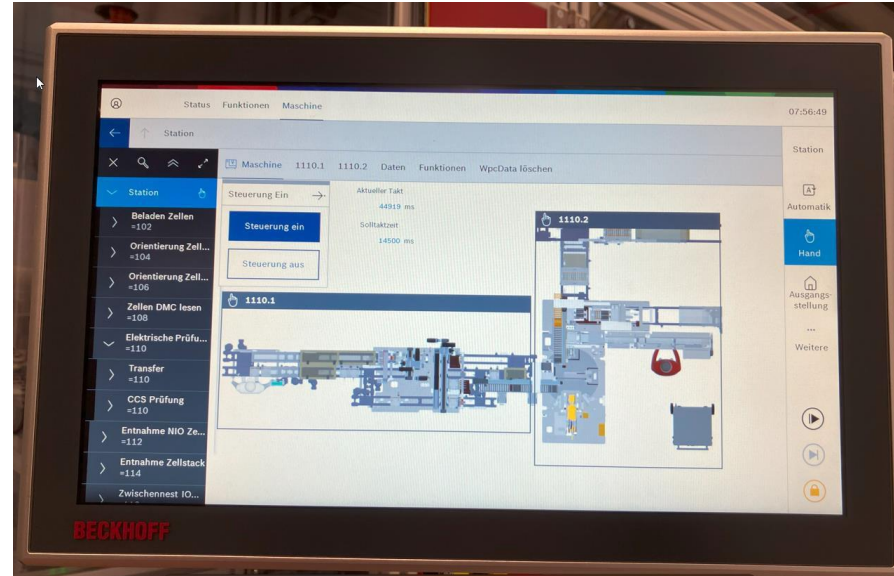


ReUse MAE: Miscellaneous / other images / Pictures



Mobile control panel ("mPad")
with
two Connection points

mobile control panel ('mPad') with two connection
points



Inpatient control panel

Steering: PLC (Rexroth VPB40.4)

Visualization: "HMI modulo" of
the BOSCH Standards
"NEXEED"

Stationary control panel

Control: PLC (Rexroth VPB40.4)

Visualization: 'HMI modulo' of the BOSCH standard 'NEXEED'



Main control column
with limited
functionality incl.
"easyPanel"

Main control column with limited
functionality including 'easyPanel'

ReUse MAE: Miscellaneous / other **images** / Pictures



Nameplate + Inventory number

(Type plate + Inventory number)



ReUse MAE: Miscellaneous / other Technical Data/Technical Data

4.4 Technische Daten	
Zeitliche Grenze	
Konstruktion ausgelegt auf Lebensdauer v.	10 Jahre
Aufstellbedingungen	
Sauberraum	ja
Hallen-Temperatur	20 °C bis max. 35 °C
Luftfeuchtigkeit	max. 70% (nicht kondensierend)
Hallen-Boden	<ul style="list-style-type: none"> Betonfläche, min. Qualität B25 mit der entsprechenden Tragfähigkeit für das Maschinengewicht zugelassen und geeignet für Bodenverdübelung mit Spreizankern
Vibration	geringfügig
Stabilität der Aufstellfläche:	schwingungsarm
Mechanische Daten	
Abmessungen (L x B x H)	6840x3820x4720 mm
Platzbedarf (L x B) inkl Funktionsflächen	6840x4250 mm
Gewicht	ca. 8000 kg
Layoutnummer	61658-20-00-00
Elektrische Daten	
Betriebsspannung	3x 400V / 50Hz
Steuerspannung	24V DC
Leistungsaufnahme	3,42 kVA
Netzsicherung bauseits	max. 25A
Druckluft-Versorgung	
Luftdruck	6 bar
Luft-Qualität	ungeölt ISO 8573-1
	Feststoffe Klasse 5
	Wassergehalt Klasse 4
	Ölgehalt Klasse 3
Zusätzliche Geräte	
Emissionen	
Lärm (Schalldruck)	max. 75 dB(A), gemessen in 1 m Abstand
EMV	entsprechend der EMV-Richtlinie und den EMV-Normen für den Einsatz im Industriebereich

Tab. 3- Technische Daten

Kühlwasseranschluss:	
Druck:	6 bar
Temperatur Zulauf:	+5°C ... +28,2°C
Außengewinde:	1,25 Zoll
Mindestwasserbedarf:	Gem. Aufstellungsbedingungen TruDisk 5001
Wasserqualität:	<p>Kühlturmwater gem. VDI 3803, Anh. B, Tab. B3</p> <p>Bei stark verschmutztem Wasser muss ein Vorfilter bis 0,135 mm (Filterstufe im Gerät 0,250 mm) installiert werden.</p>