SINTERLEGHE

Your needs. Our quality.

Cutters Catalogue / EN

WHO WE ARE

SINTERLEGHE is world leader in ***design***, ***manufacturing*** and ***sale*** of ***tip dressers***, ***electrode tip changers*** and ***metal cutters*** for resistance welding electrodes, ***supplying*** major car manufacturers.

SINTERLEGHE is specialized in the design and manufacturing of tip dressers, electrode tip changers and metal cutters for spot welding electrodes tip dressing.

Founded in 1989 by ***Eugenio Tedeschi***, the company developed its know-how, which allowed it to grow and differentiate its offer by reaching ***high qualitative standards***.

The tenacity and perseverance attaining its goals allowed **SINTERLEGHE** to conceive new ***design solutions*** that ultimately have become ***patents***. This is an added value to a company that made innovation and technology evolution its strength. Today **SINTERLEGHE** is a key partner for big international groups involved in car manufacturing.

Since 1992 its products, made in the factory of Anzola d'Ossola (VB), have been known all over the world with the brand **Ravitex®** and sold in 4 continents and 23 countries.

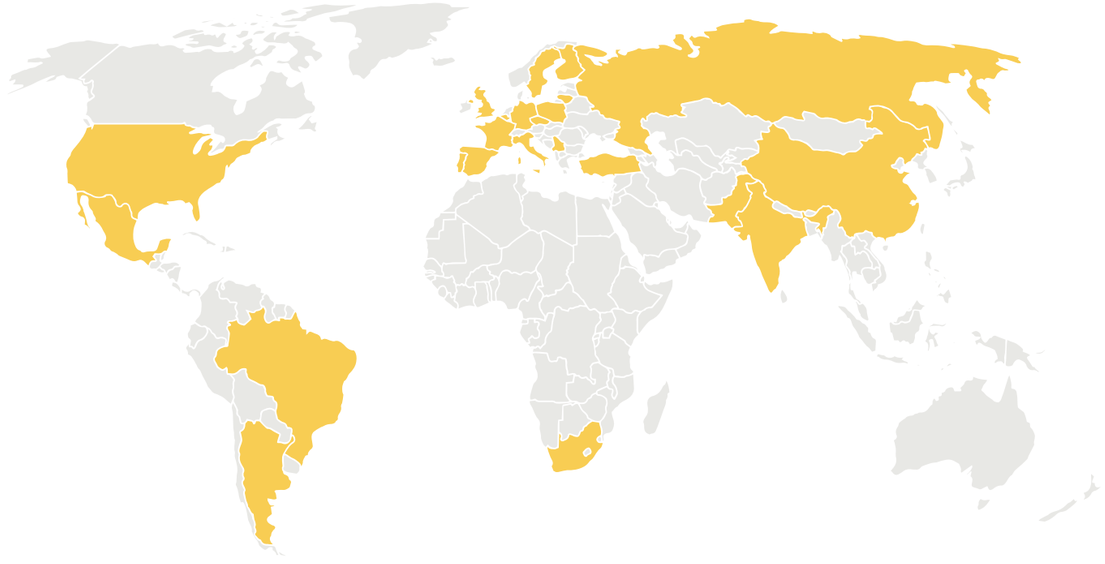
With offices in Marburg, Germany, and in Sao Paulo, Brazil, and its ***partnership*** networks (including an agreement with Shanghai Faith Co., Ltd. for the chinese market), **SINTERLEGHE** controls and supplies the European, Asian, US and South American markets.

RAVITEX®

OUR CUSTOMERS

Audi · BAIC Group · FCA Fiat Chrysler Automobiles · Ford · GM · Iveco · MA · PSA Groupe · Skoda · Tower International · Volkswagen · Volvo · Geely

OUR PRODUCTS ARE INSTALLED IN 4 CONTINENTS AND 23 COUNTRIES



OUR QUALITY

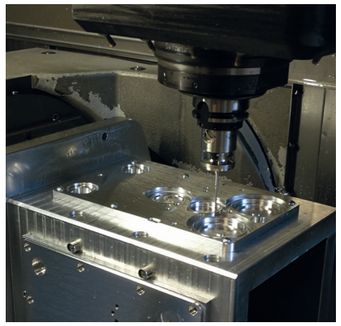
SINTERLEGHE has developed business and organisational strategies targeted to improve ***quality***, ***competitiveness*** and ***productivity of the company*** acting on the innovation of the processes on the constant growth of the key skills.

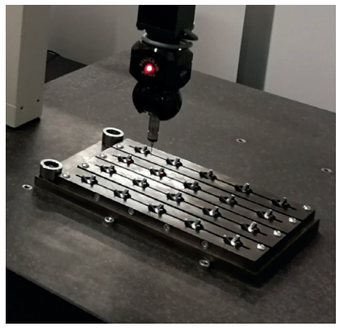
SINTERLEGHE operates to improve the products and the processes according to the standard ISO EN 9001-2008. In 1998 the company introduced a quality management system for its internal processes in compliance with the certified and internationally recognised model.

Quality and development targets are pursued both through a constant review of the products and processes and through the professional growth of human resources. In 2016 **SINTERLEGHE** started a training programme with FESTO Consulting, main international consulting company,, for the development of individual skills required at different organisational levels.

The application of working methods and standards oriented to Total Quality Management, together with the implementation of a new management model based on processes, are directed to obtain better performances in terms of productivity, flexibility, responsiveness and reliability.

The higher empowerment and the active involvement of the staff in company's decisions through targeted actions and plans are a strategic element to achieve growth and development targets.





WHY SINTERLEGHE

SINTERLEGHE puts its ***expertise***, ***ability*** and ***professionalism*** at the service of its customers. The goal is to satisfy the most advanced needs in the tip dressing and electrode tip changing segments by developing a ***business process of re-engineering*** and ***redesign*** going through ***technology innovation*** and steady product and process development.

Technology innovation

SINTERLEGHE's design ideas have turned into patents, as an important guarantee for consumers, certifying the **originality** and **quality** of **Ravitex®** know-how.

Expertise and know-how

The collaboration with major automotive players worldwide allowed **SINTERLEGHE** to develop a strong **know-how** and an **in-depth knowledge** of the target market.

Superior quality

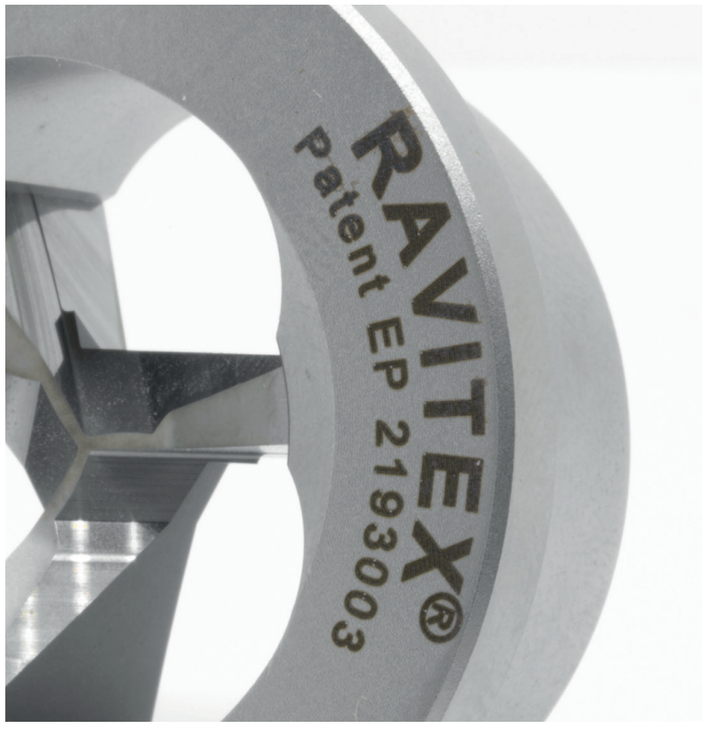
Ravitex® products meet the needs of the most advanced production lines, accomplishing ambitious goals in terms of process cost reduction, production capacity increase, quality and environmental friendliness.

Customer care

Ravitex® products result from a careful analysis of clients' needs and requirements. The care for clients prior and after the purchase and their satisfaction are absolute priorities.

RAVITEX® PRODUCTS

The characteristics of Ravitex® products are guided by the needs of worldwide customers. Their performances are the result of intellectual innovations and quality processes.



All mechanical processing are performed in the plant of Anzola d'Ossola thanks to CNC machines with high productivity. The processes are managed and controlled by a single management software.
An air-conditioned metrological room ensures the full dimensional control over the entire manufacturing range.

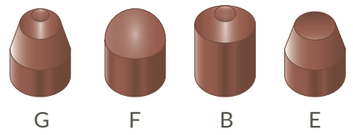
SINTERLEGHE's manufacturing capacity has grown to become more and more flexible over the years thanks to **Lean Production and TPS** organizational and production methods.

This approach brought to internal and outsourcing optimised processes, reducing the lead times.

RX CUTTERS PATENT EP2193003

Industrialized and commercialized at the end of 2010, the three-blades hard metal RX cutters patent EP2193003 manufactured by SINTERLEGHE allow to:

- Double electrode's life reducing their costs as well as any other costs incurred for poduction line stops needed for their replacement.needed for replacement
- Dress electrodes of different shapes or special electrodes with one single model of cutter



- In the 120° version improve the cooling of the electrodes to prevent the decay of their chemical and mechanical properties
- Have a vibration-free cutter that can completely clean the electrode through a single dressing cycle.
- Keep a constant removal from electrodes by the cutter according to the variation of the closing force of the welding gun and electrode's hardness
- Reduce costs of spare cutters, reduce replacement and maintenance frequency thanks to the high durability of the hard metal blades
- Be used on different brands of dressers

For inquiries about cutterm, if the electrodes do not correspond to ISO 5821 B-E-F-G, send the drawings of the welding gun and of the electrodes in one of the following formats: step, igs, xt, sat, catpart, dwg, dxf.

PRODUCT PLUS

Optimization of ***quality of the welding spot***

50% ***reduction*** of ***stops in welding line***

1 ***single cutter*** for multiple electrode types (***ISO 5821 model G,F,B,E***)

50% ***reduction*** of ***costs in spare electrodes*** and ***cutter***

List of brands compatible with Ravitex® cutter RX PATENT EP 2193003

EUROPE	SINTERLEGHE	AEG	BRAUER	LUTZ	ABB	WEDO	GEM	AMDP	EXROD	ROTEC-TOOLING
US	SEMTORQ	STILLWATER								
JAPAN	KYOKUTOH	OBARA								
BRASIL	KAPPEN									
KOREA	KDC									

How to compare different cutters available on the market

Performance	RX Patent EP 2193003	Single blade
Material removed from each electrode in each dressing cycle of 1 second with closing force of the welding gun 120 daN	0,037 mm/sec	0,08 mm/sec
No. of possible dressing cycles available	~ 70	~ 20
Dressing time	~ 1,0 sec.	~ 1,0 sec.
No. of welding spots made with a couple of electrodes (electrode life)	~ 10.000	~ 5.000
Possible cycles (cutter life)	60.000	10.000
Time required for electrode change every 10,000 welding spots	3 min	6 min
Time required for electrode change every 200 days/year	600 min	1200 min
Achievable production increase *Note: with an estimated 10,000-spot electrode life the electrode change can be scheduled at the shift change*	600 min	

Picture of copper shavings removal 0.037 mm/sec with cutter RX Patent EP 2193003

Picture of copper shavings removal 0,08 mm/sec with single blade cutters

Besides comparing the performances of the cutters RX Patent EP 2193003, SINTERLEGHE focused its attention on costs and defined the L.C.C.A.

Life Cycle Cost Analysis comparative with single blade cutters (cost generated by spare parts).

With the cutter Patent EP 2193003 there are no spare blades, it must be entirely replaced.

Performance	CUTTER RX Patent EP 2193003	CUTTER Single blade	CUTTER Double blade
Copper removed during each dressing cycle	0,037 mm/sec	0,08 mm/sec	0,05 mm/sec
No. of possible dressing cycles available	70÷ 90	20÷30	30÷40
Dressing time	~ 1,0 sec.	~ 1,0 sec.	~ 1,0 sec.
No. of welding spots obtainable with a couple of electrodes	~10.000	5.000	~ 5.000
Consumables parts costs: cutter + electrodes			
Cost of No. 02 electrodes	1.00 €	1.00 €	1.00 €
Electrodes cost per No. 10,000 welding spots	1.0 €	2.00 €	2.00 €
Annual cost of electrodes in case of 2,000,000 welding spots/year	200.00 €	400.00 €	400.00 €
Cutter cost	300,00 €	150.00 €	250,00 €
No. of possible dressing cycles (cutter lifetime)	60.000	10.000	10.000
Annual cost of spare blade	0,00 €	(No.4 x 60,00 €) = 240.00 €	(No. 4 x 110,00 €) = 440,00 €
Maintenance cost for cutter/blade replacement = €1 x min	1min = 1,00 €	4 x 3 min = 12,00 €	4 x 5 min = 20,00 €
Total annual cost: cutter + electrodes	501,00 €	802,00 €	1.110,00 €
Total cost for each welding gun (8 years)	(501,00x8) = 4.008,00 €	(802,00x8) = 6.416,00 €	(1.110,00x8) = 8.880,00 €
Total cost for No. 100 welding guns	400,800,00 €	641.600,00 €	888.000,00 €
Difference on costs for spare parts of cutter/electrodes		+ 240.800,00 €	+ 487.200,00 €

Data source collection / processing

Removal in mm/sec:

- Cutter removal comparative tests performed at 120 daN
- Technical data found on the catalogues and websites of dresser cutter manufacturers worldwide
- Copper shaving thickness detection as produced by different cutter types

Cutter/electrodes life:

- Detected during the visits to about 90 plants worldwide
- Cutter's reordering frequency

TECHNICAL DETAILS
CUTTERS RX Patent EP 2193003

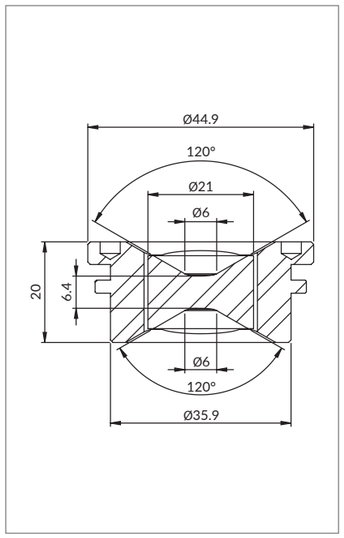
- Blades material: high-strength hard metal
- Blades hardness: ≥ 90 HRA
- Blades per cutter: 3 lateral and 3 frontal
- Bush material = Stainless Steel AISI 303
- Blades mounting process: interference
- Mounting: any bush connection
- Shavings passage area for suction system > 60% cutter surface
- Applicable closing force: from 80 daN to 350 daN
- Electrodes centering: self - centering through the 3 - blades
- Electrode types dressed with the same standard cutter: B-E-F-G ISO 5821
- Electrodes shape after dressing: side angles according to ISO 8166-2003, diameter on Ø 6mm on contact surface r = 40 mm
- Diameters of the electrodes to be dressed: from Ø 8,00 to Ø 21,00 mm

CUTTERS INDEX

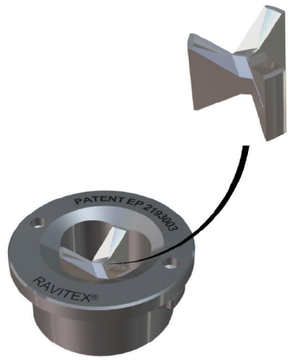
Cutters RX Patent ***EP 2193003***

Order number
070101000007

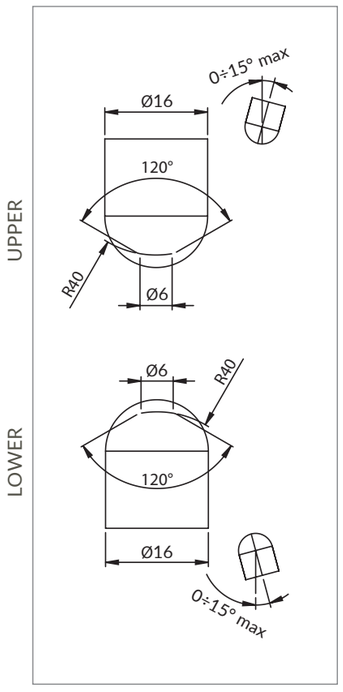
Description
Cutter RFRW 120 P6 RX
Patent EP 2193003



3-blades self-centering in hard metal / stainless steel bush



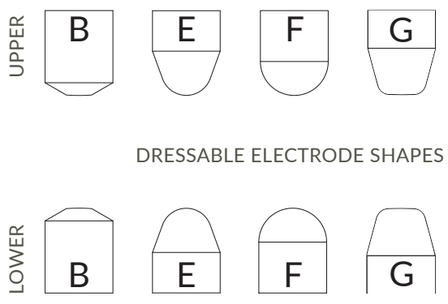
SUITABLE FOR DRESSERS: SINTERLEGHE, BRÄUER



ELECTRODE SHAPES
New
Dressed

RECOMMENDED OPERATING PARAMETERS

ELECTRODES	Ø16	Ø20
FIRST DRESSING	2÷5 sec or 6÷18 cutter turns	2÷5 sec or 6÷18 cutter turns
CYCLE DRESSING	1÷3 sec or 3÷10 cutter turns	1÷3 sec or 3÷10 cutter turns
WELDING GUNS CLOSING FORCE	150±20 daN	180±20 daN
MATERIAL REMOVAL WITH α=120°	0.037±0.004mm/s	0.037±0.004mm/s
DRESSING FREQUENCY	100±20 welding points	100±20 welding points



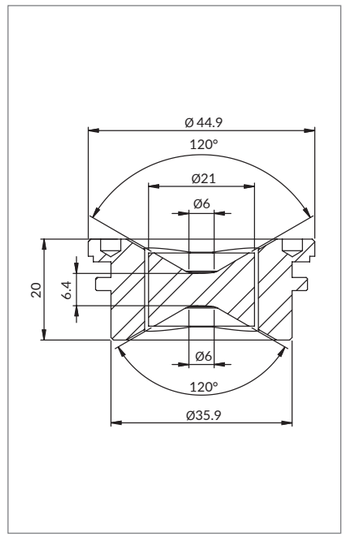
DRESSABLE ELECTRODE SHAPES

If the electrodes do not correspond to ISO 5821 B-E-F-G, send the welding gun and electrode drawings with the offer request in one of the following formats: step, igs, xt, sat, catpart, dwg, dxf.

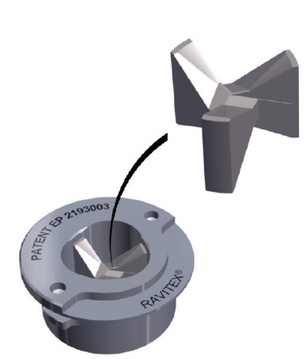
Cutters RX Patent ***EP 2193003***

Order number
070101000042

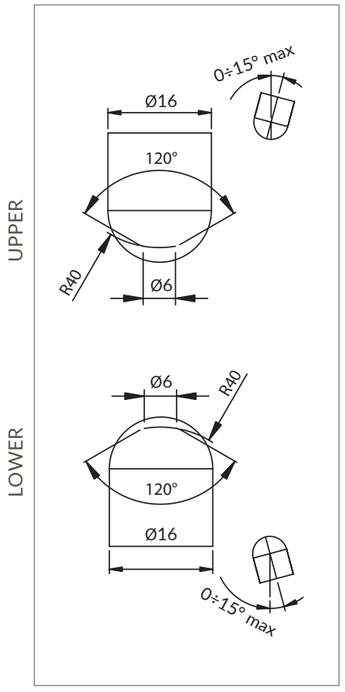
Description
Cutter RFRW 120 P6 1s RX
Patent EP 2193003



3-blades self-centering in hard metal / stainless steel bush



SUITABLE FOR DRESSERS: SINTERLEGHE, BRÄUER, AEG, LUTZ



ELECTRODE SHAPES
New
Dressed

RECOMMENDED OPERATING PARAMETERS

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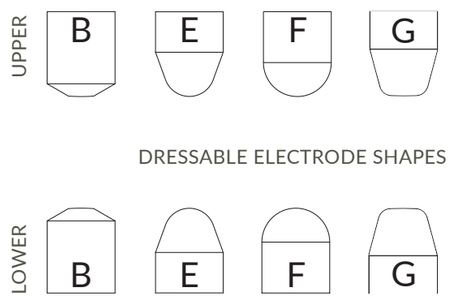
DRESSING FREQUENCY	100±20 welding points	100±20 welding points



DRESSABLE ELECTRODE SHAPES

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Cutters RX Patent ***EP 2193003***

Order number
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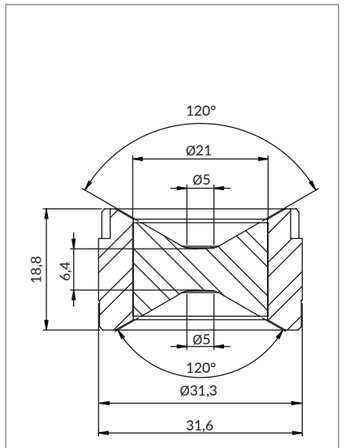
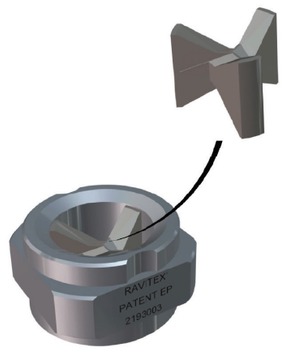
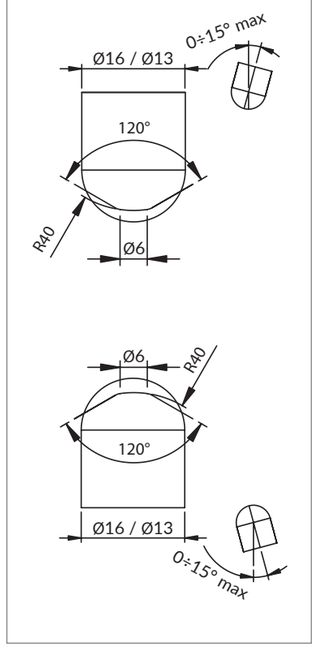
Description
Cutter RFST 120 P5 RX
Patent EP 2193003



3-blades self-centering in hard metal / stainless steel bush



SUITABLE FOR DRESSERS: STILLWATER



ELECTRODE SHAPES
New
Dressed

RECOMMENDED OPERATING PARAMETERS

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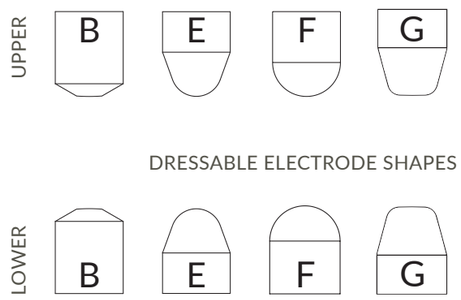

DRESSABLE ELECTRODE SHAPES

If the electrodes do not correspond to ISO 5821 B-E-F-G, send the welding gun and electrode drawings with the offer request in one of the following formats: step, igs, xt, sat, catpart, dwg, dxf.

Cutters RX Patent ***EP 2193003***

Order number
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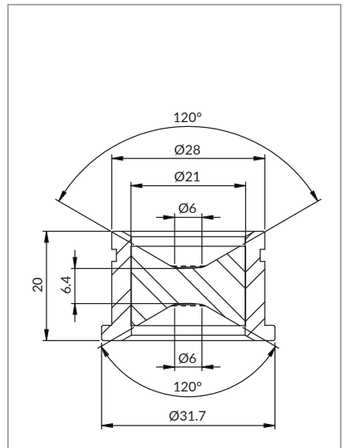
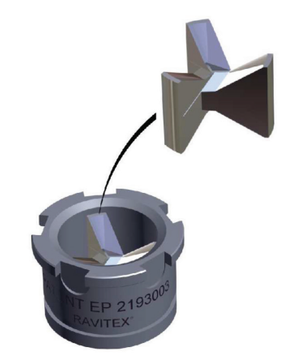
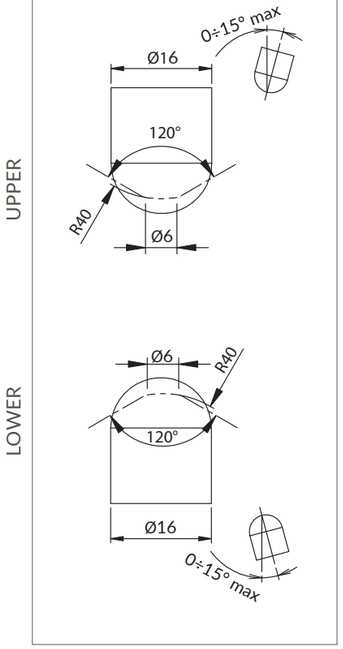
Description
Cutter RFA 120 P6 RX
Patent EP 2193003



3-blades self-centering in hard metal / stainless steel bush



SUITABLE FOR DRESSERS: SINTERLEGHE, AMDP, EXROD



ELECTRODE SHAPES
New
Dressed

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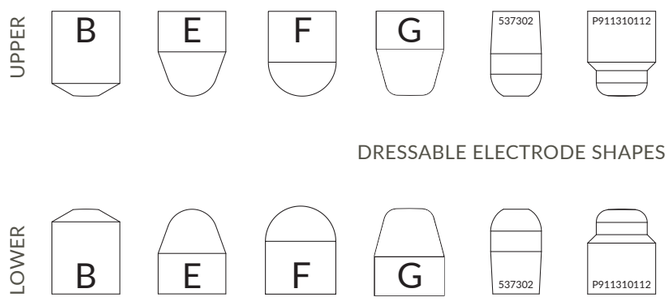

DRESSABLE ELECTRODE SHAPES

If the electrodes do not correspond to ISO 5821 B-E-F-G, send the welding gun and electrode drawings with the offer request in one of the following formats: step, igs, xt, sat, catpart, dwg, dxf.

Cutters RX Patent ***EP 2193003***

Order number
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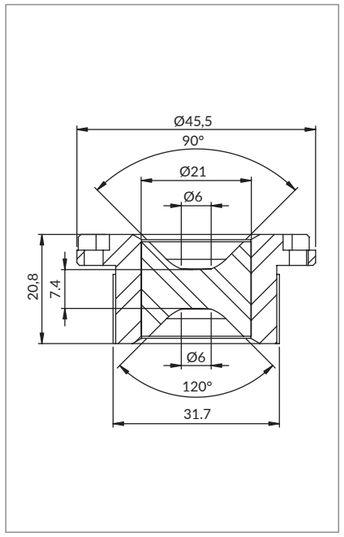
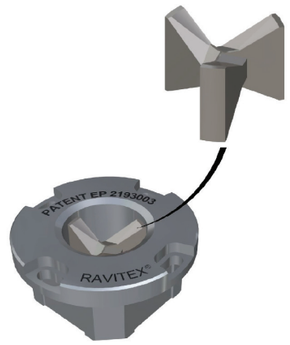
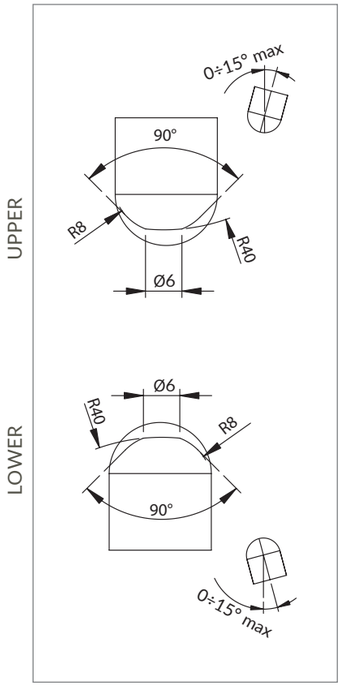
Description
Cutter RFMT 90 R8 P6 (R40)
RX Patent EP 2193003



3-blades self-centering in hard metal / stainless steel bush



SUITABLE FOR DRESSERS: SINTERLEGHE, OBARA, KYOKUTOH



ELECTRODE SHAPES
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Dressed

RECOMMENDED OPERATING PARAMETERS

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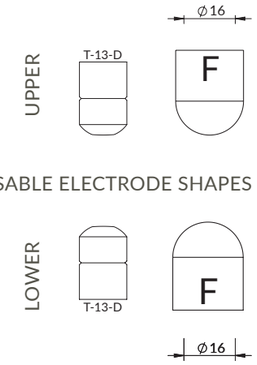
CYCLE DRESSING	1÷3 sec or 3÷10 cutter turns	1÷3 sec or 3÷10 cutter turns
WELDING GUNS CLOSING FORCE	150±20 daN	180±20 daN
MATERIAL REMOVAL WITH α=90°	0.050±0.004mm/s	0.050±0.004mm/s
DRESSING FREQUENCY	100±20 welding points	100±20 welding points

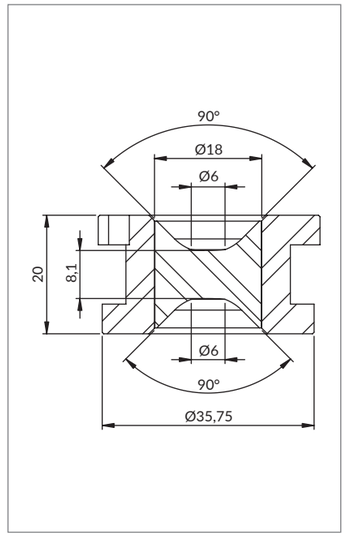


If the electrodes do not correspond to ISO 5821 B-E-F-G, send the welding gun and electrode drawings with the offer request in one of the following formats: step, igs, xt, sat, catpart, dwg, dxf.

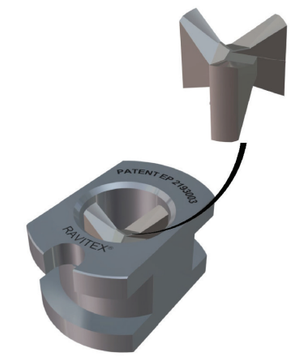
Cutters RX Patent ***EP 2193003***

Order number
070110000003

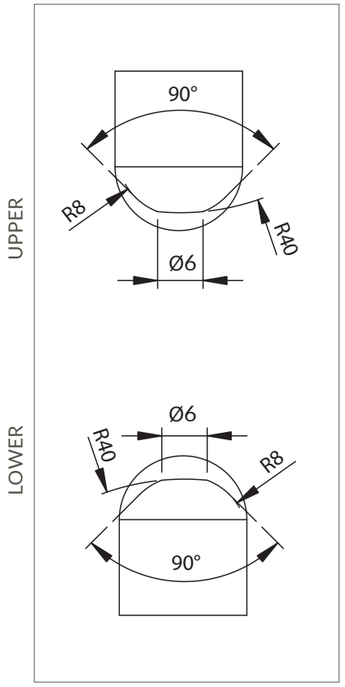
Description
Cutter RFK 90 R8 P6 (R40) D18
RX Patent EP 2193003



3-blades self-centering in hard metal / stainless steel bush



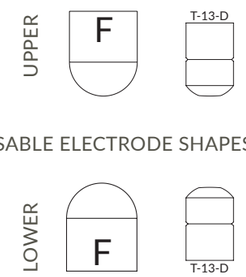
SUITABLE FOR DRESSERS: KYOKUTOH



ELECTRODE SHAPES
New
Dressed

RECOMMENDED OPERATING PARAMETERS

ELECTRODES	Ø16	Ø20
FIRST DRESSING	2÷5 sec or 6÷18 cutter turns	2÷5 sec or 6÷18 cutter turns
CYCLE DRESSING	1÷3 sec or 3÷10 cutter turns	1÷3 sec or 3÷10 cutter turns
WELDING GUNS CLOSING FORCE	150±20 daN	180±20 daN
MATERIAL REMOVAL WITH α=90°	0.050±0.004mm/s	0.050±0.004mm/s
DRESSING FREQUENCY	100±20 welding points	100±20 welding points

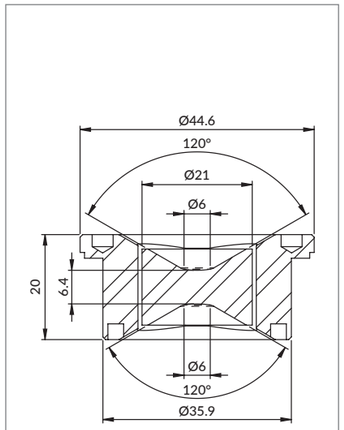


If the electrodes do not correspond to ISO 5821 B-E-F-G, send the welding gun and electrode drawings with the offer request in one of the following formats: step, igs, xt, sat, catpart, dwg, dxf.

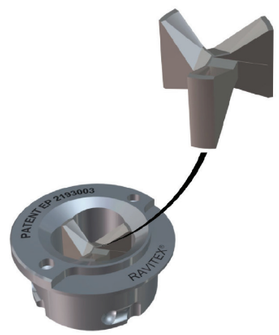
Cutters RX Patent ***EP 2193003***

Order number
070111000001

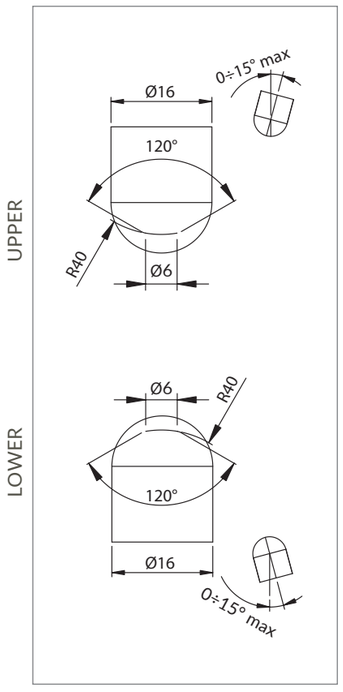
Description
Cutter RFL 120 P6 Ø45 1s
RX Patent EP 2193003



3-blades self-centering in hard metal / stainless steel bush



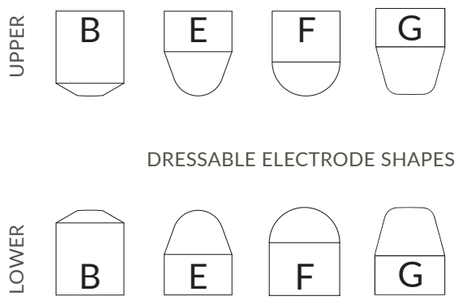
SUITABLE FOR DRESSERS: LUTZ KAPPEN



ELECTRODE SHAPES
New
Dressed

RECOMMENDED OPERATING PARAMETERS

ELECTRODES	Ø16	Ø20
FIRST DRESSING	2÷5 sec or 6÷18 cutter turns	2÷5 sec or 6÷18 cutter turns
CYCLE DRESSING	1÷3 sec or 3÷10 cutter turns	1÷3 sec or 3÷10 cutter turns
WELDING GUNS CLOSING FORCE	150±20 daN	180±20 daN
MATERIAL REMOVAL WITH α=120°	0.037±0.004mm/s	0.037±0.004mm/s
DRESSING FREQUENCY	100±20 welding points	100±20 welding points



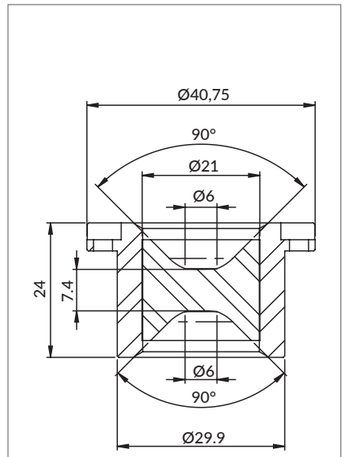
DRESSABLE ELECTRODE SHAPES

If the electrodes do not correspond to ISO 5821 B-E-F-G, send the welding gun and electrode drawings with the offer request in one of the following formats: step, igs, xt, sat, catpart, dwg, dxf.

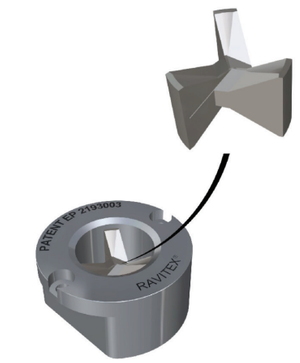
Cutters RX Patent ***EP 2193003***

Order number
070115000006

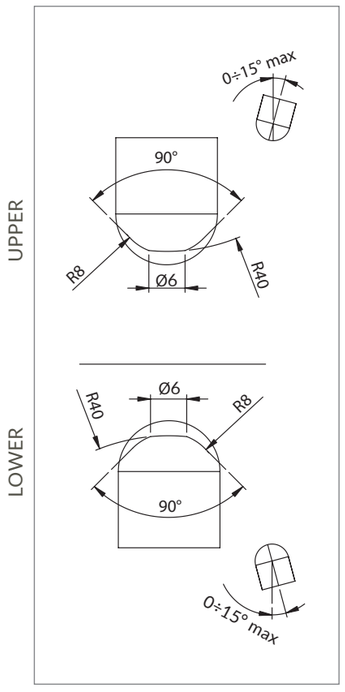
Description
Cutter ROA 90 R8 P6 (R40)
RX Patent EP 2193003



3-blades self-centering in hard metal / stainless steel bush



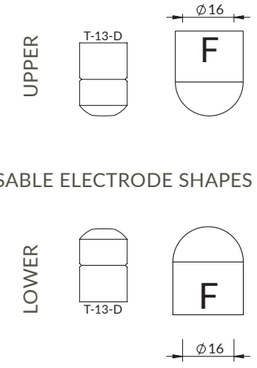
SUITABLE FOR DRESSERS: SINTERLEGHE, OBARA, KYOKUTOH



ELECTRODE SHAPES
New
Dressed

RECOMMENDED OPERATING PARAMETERS

ELECTRODES	Ø16	Ø20
FIRST DRESSING	2÷5 sec or 6÷18 cutter turns	2÷5 sec or 6÷18 cutter turns
CYCLE DRESSING	1÷3 sec or 3÷10 cutter turns	1÷3 sec or 3÷10 cutter turns
WELDING GUNS CLOSING FORCE	150±20 daN	180±20 daN
MATERIAL REMOVAL WITH α=90°	0.050±0.004mm/s	0.050±0.004mm/s
DRESSING FREQUENCY	100±20 welding points	100±20 welding points



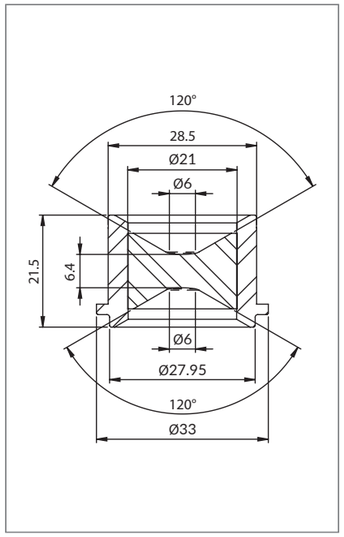
DRESSABLE ELECTRODE SHAPES

If the electrodes do not correspond to ISO 5821 B-E-F-G, send the welding gun and electrode drawings with the offer request in one of the following formats: step, igs, xt, sat, catpart, dwg, dxf.

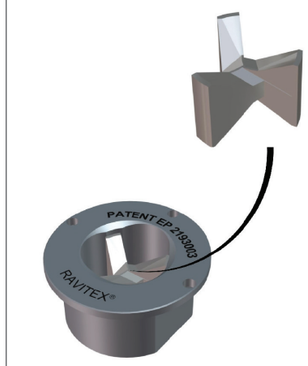
Cutters RX Patent ***EP 2193003***

Order number
070116000006

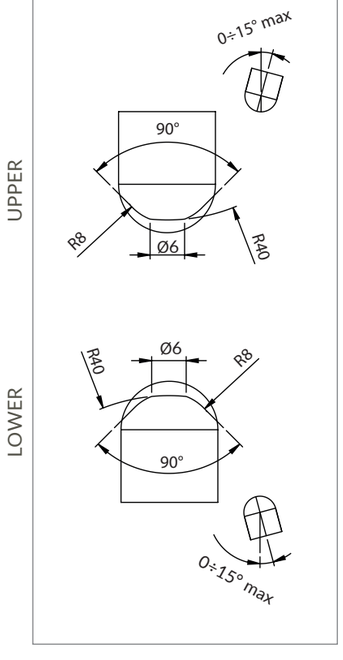
Description
Cutter ROB 90 R8 P6(R40) RX
Patent EP 2193003



3-blades self-centering in hard metal / stainless steel bush



SUITABLE FOR DRESSERS: OBARA, kYOKUTOH



ELECTRODE SHAPES
New
Dressed

RECOMMENDED OPERATING PARAMETERS

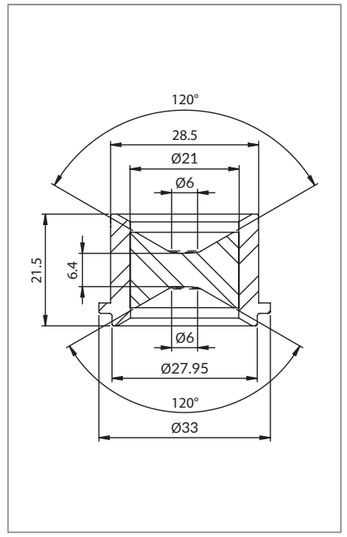
ELECTRODES	Ø16	Ø20
FIRST DRESSING	2÷5 sec or 6÷18 cutter turns	2÷5 sec or 6÷18 cutter turns
CYCLE DRESSING	1÷3 sec or 3÷10 cutter turns	1÷3 sec or 3÷10 cutter turns
WELDING GUNS CLOSING FORCE	150±20 daN	180±20 daN
MATERIAL REMOVAL WITH α=90°	0.050±0.004mm/s	0.050±0.004mm/s
DRESSING FREQUENCY	100±20 welding points	100±20 welding points

If the electrodes do not correspond to ISO 5821 B-E-F-G, send the welding gun and electrode drawings with the offer request in one of the following formats: step, igs, xt, sat, catpart, dwg, dxf.

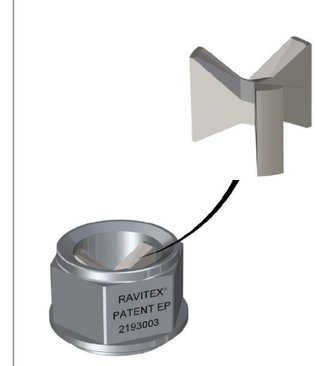
Cutters RX Patent ***EP 2193003***

Order number
070117000006

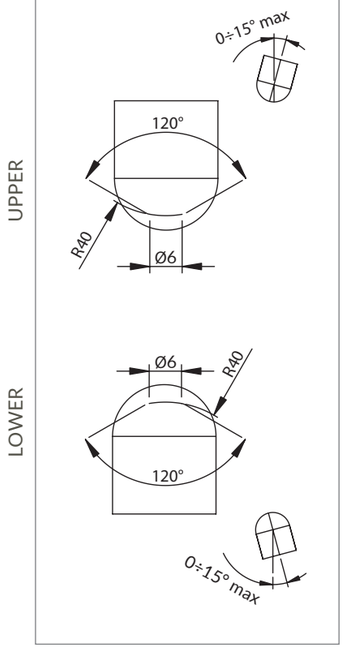
Description
Cutter RFS 120 P6 RX
Patent EP 2193003



3-blades self-centering in hard metal / stainless steel bush



SUITABLE FOR DRESSERS: SEMTORQ



ELECTRODE SHAPES
New
Dressed

RECOMMENDED OPERATING PARAMETERS

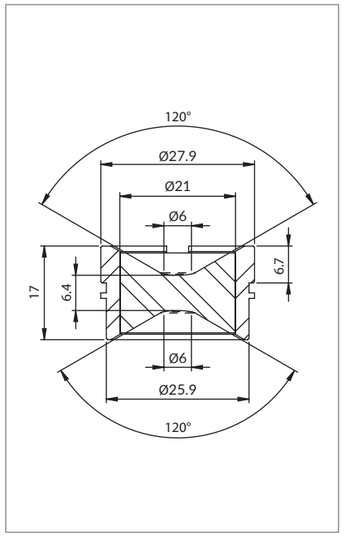
ELECTRODES	Ø16	Ø20
FIRST DRESSING	2÷5 sec or 6÷18 cutter turns	2÷5 sec or 6÷18 cutter turns
CYCLE DRESSING	1÷3 sec or 3÷10 cutter turns	1÷3 sec or 3÷10 cutter turns
WELDING GUNS CLOSING FORCE	150±20 daN	180±20 daN
MATERIAL REMOVAL WITH α=120°	0.037±0.004mm/s	0.037±0.004mm/s
DRESSING FREQUENCY	100±20 welding points	100±20 welding points

If the electrodes do not correspond to ISO 5821 B-E-F-G, send the welding gun and electrode drawings with the offer request in one of the following formats: step, igs, xt, sat, catpart, dwg, dxf.

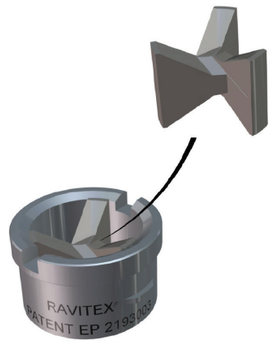
Cutters RX Patent ***EP 2193003***

Order number
070119000003

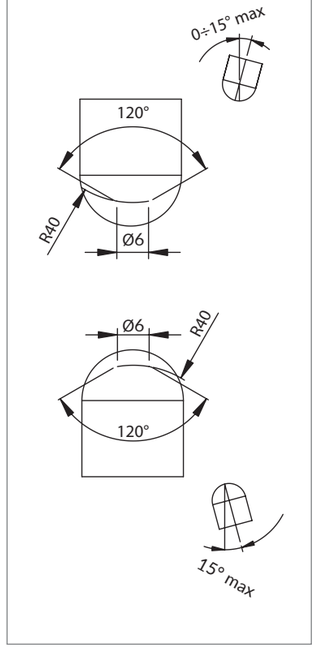
Description
Cutter RFLP 120 P6 RX
Patent EP 2193003



3-blades self-centering in hard metal / stainless steel bush



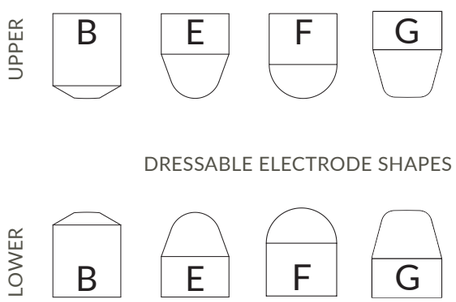
SUITABLE FOR DRESSERS: LUTZ, KAPPEN



ELECTRODE SHAPES
New
Dressed

RECOMMENDED OPERATING PARAMETERS

ELECTRODES	Ø16	Ø20
FIRST DRESSING	2÷5 sec or 6÷18 cutter turns	2÷5 sec or 6÷18 cutter turns
CYCLE DRESSING	1÷3 sec or 3÷10 cutter turns	1÷3 sec or 3÷10 cutter turns
WELDING GUNS CLOSING FORCE	150±20 daN	180±20 daN
MATERIAL REMOVAL WITH α=120°	0.037±0.004mm/s	0.037±0.004mm/s
DRESSING FREQUENCY	100±20 welding points	100±20 welding points



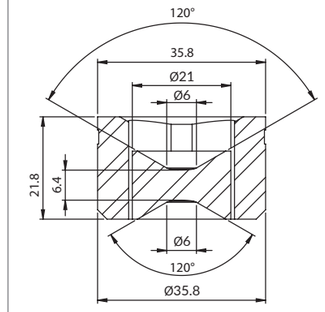
DRESSABLE ELECTRODE SHAPES

If the electrodes do not correspond to ISO 5821 B-E-F-G, send the welding gun and electrode drawings with the offer request in one of the following formats: step, igs, xt, sat, catpart, dwg, dxf.

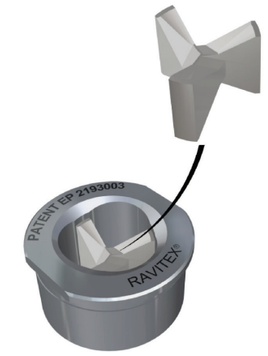
Cutters RX Patent ***EP 2193003*** cutters

Order number
070121000002

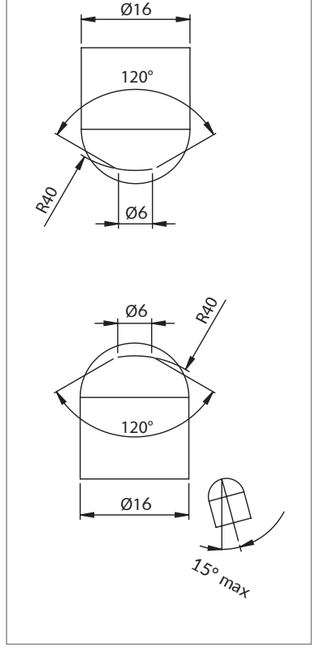
Description
Cutter RAA 120 P6 CH36 RX
Patent EP 2193003



3-blades self-centering in hard metal / stainless steel bush



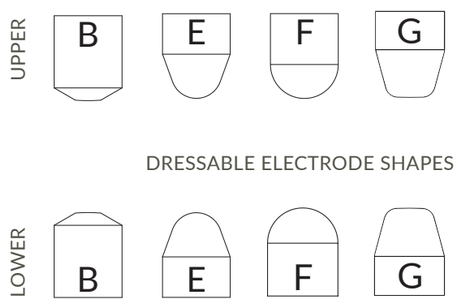
SUITABLE FOR DRESSERS: ABB



ELECTRODE SHAPES
New
Dressed

RECOMMENDED OPERATING PARAMETERS

ELECTRODES	Ø16	Ø20
FIRST DRESSING	2÷5 sec or 6÷18 cutter turns	2÷5 sec or 6÷18 cutter turns
CYCLE DRESSING	1÷3 sec or 3÷10 cutter turns	1÷3 sec or 3÷10 cutter turns
WELDING GUNS CLOSING FORCE	150±20 daN	180±20 daN
MATERIAL REMOVAL WITH α=120°	0.037±0.004mm/s	0.037±0.004mm/s
DRESSING FREQUENCY	100±20 welding points	100±20 welding points



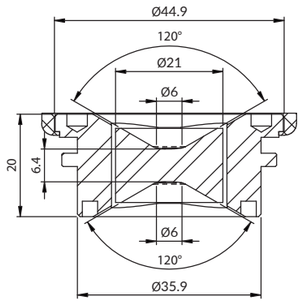
DRESSABLE ELECTRODE SHAPES

If the electrodes do not correspond to ISO 5821 B-E-F-G, send the welding gun and electrode drawings with the offer request in one of the following formats: step, igs, xt, sat, catpart, dwg, dxf.

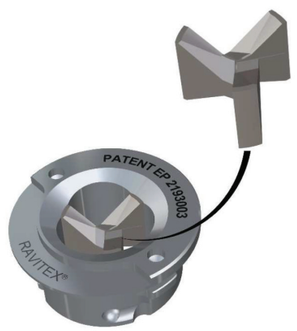
Cutters RX Patent ***EP 2193003***

Order number
070122000004

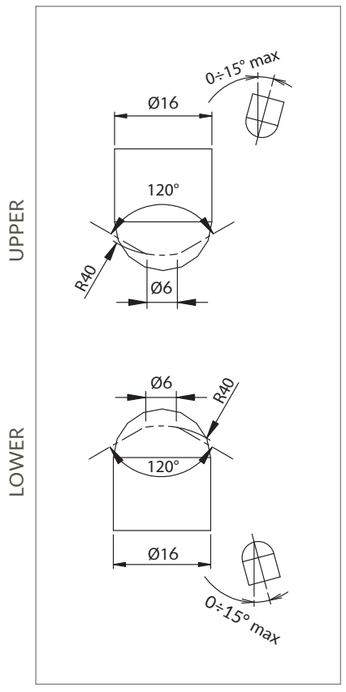
Description
Cutter RFLW 120 P6 Ø45 1s RX
Patent EP 2193003



3-blades self-centering in hard metal / stainless steel bush



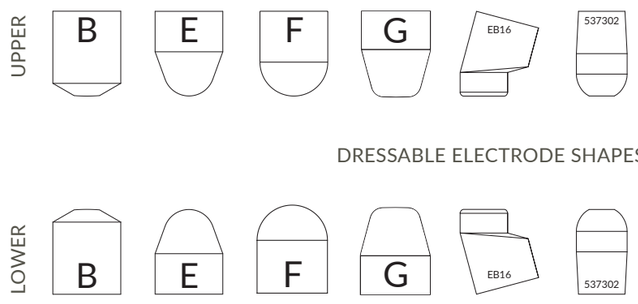
SUITABLE FOR DRESSERS: SINTERLEGHE, BRÄUER, AEG, LUTZ, KAPPEN, WEDO, LASKA



ELECTRODE SHAPES
New
Dressed

RECOMMENDED OPERATING PARAMETERS

ELECTRODES	Ø16	Ø20
FIRST DRESSING	2÷5 sec or 6÷18 cutter turns	2÷5 sec or 6÷18 cutter turns
CYCLE DRESSING	1÷3 sec or 3÷10 cutter turns	1÷3 sec or 3÷10 cutter turns
WELDING GUNS CLOSING FORCE	150±20 daN	180±20 daN
MATERIAL REMOVAL WITH α=120°	0.037±0.004mm/s	0.037±0.004mm/s
DRESSING FREQUENCY	100±20 welding points	100±20 welding points

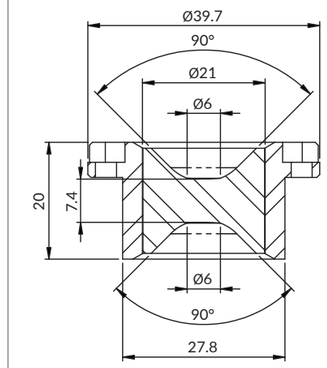


If the electrodes do not correspond to ISO 5821 B-E-F-G, send the welding gun and electrode drawings with the offer request in one of the following formats: step, igs, xt, sat, catpart, dwg, dxf.

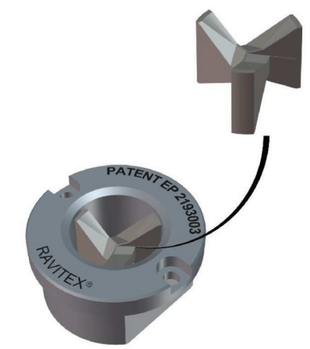
Cutters RX Patent ***EP 2193003***

Order number
070123000004

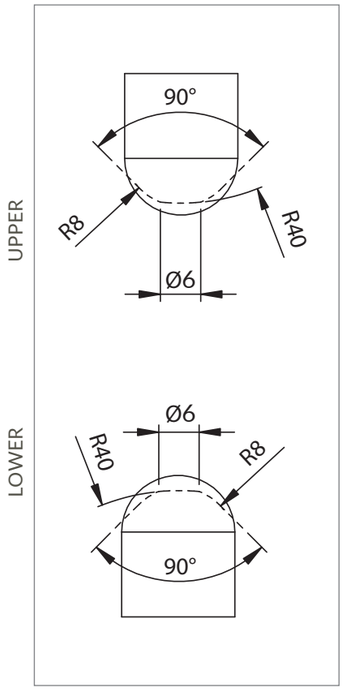
Description
Cutter ROBA 90 R8 P6(R40)
RX Patent EP 2193003



3-blades self-centering in hard metal / stainless steel bush



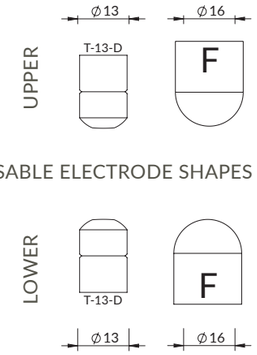
SUITABLE FOR DRESSERS: SINTERLEGHE, OBARA, KYOKUTOH



ELECTRODE SHAPES
New
Dressed

RECOMMENDED OPERATING PARAMETERS

ELECTRODES	Ø16	Ø20
FIRST DRESSING	2÷5 sec or 6÷18 cutter turns	2÷5 sec or 6÷18 cutter turns
CYCLE DRESSING	1÷3 sec or 3÷10 cutter turns	1÷3 sec or 3÷10 cutter turns
WELDING GUNS CLOSING FORCE	150±20 daN	180±20 daN
MATERIAL REMOVAL WITH α=90°	0.050±0.004mm/s	0.050±0.004mm/s
DRESSING FREQUENCY	100±20 welding points	100±20 welding points

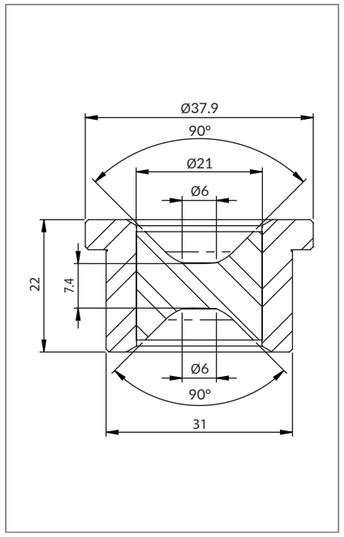


If the electrodes do not correspond to ISO 5821 B-E-F-G, send the welding gun and electrode drawings with the offer request in one of the following formats: step, igs, xt, sat, catpart, dwg, dxf.

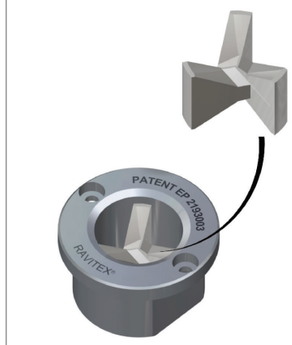
Cutters RX Patent ***EP 2193003***

Order number
070125000001

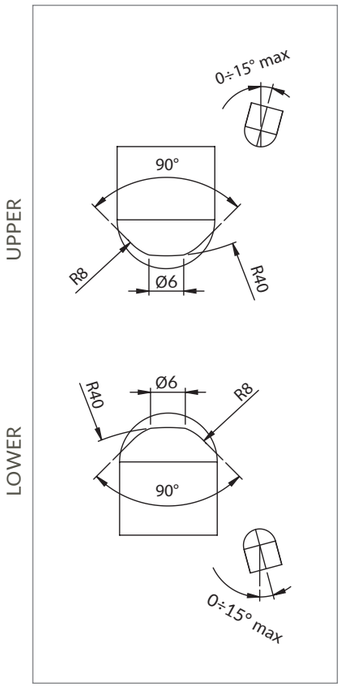
Description
Cutter ROBE 90 R8 P6 (R40)
RX Patent EP 2193003



3-blades self-centering in hard metal / stainless steel bush



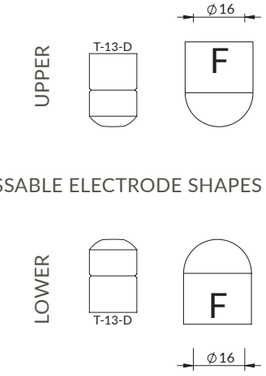
SUITABLE FOR DRESSERS: KYOKUTOH



ELECTRODE SHAPES
New
Dressed

RECOMMENDED OPERATING PARAMETERS

ELECTRODES	Ø16	Ø20
FIRST DRESSING	2÷5 sec or 6÷18 cutter turns	2÷5 sec or 6÷18 cutter turns
CYCLE DRESSING	1÷3 sec or 3÷10 cutter turns	1÷3 sec or 3÷10 cutter turns
WELDING GUNS CLOSING FORCE	150±20 daN	180±20 daN
MATERIAL REMOVAL WITH α=90°	0.050±0.004mm/s	0.050±0.004mm/s
DRESSING FREQUENCY	100±20 welding points	100±20 welding points



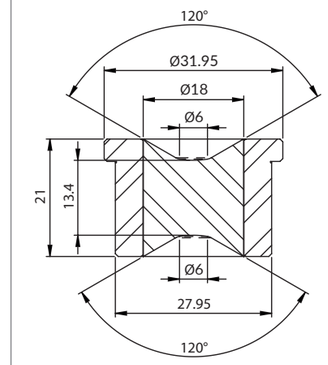
DRESSABLE ELECTRODE SHAPES

If the electrodes do not correspond to ISO 5821 B-E-F-G, send the welding gun and electrode drawings with the offer request in one of the following formats: step, igs, xt, sat, catpart, dwg, dxf.

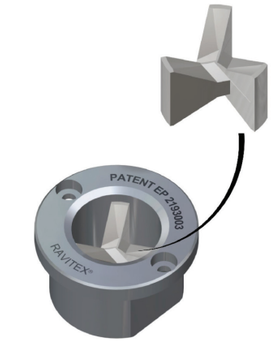
Cutters RX Patent ***EP 2193003***

Order number
070126000002

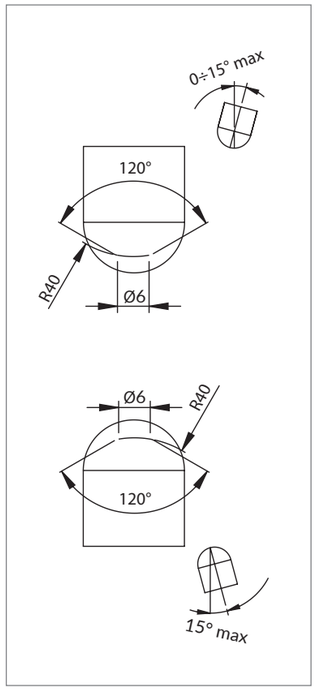
Description
Cutter ROBS 120 P6 D18 2N RX
Patent EP 2193003



3-blades self-centering in hard metal / stainless steel bush



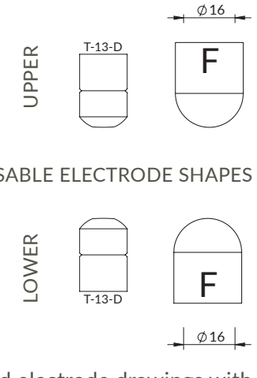
SUITABLE FOR DRESSERS: OBARA



ELECTRODE SHAPES
New
Dressed

RECOMMENDED OPERATING PARAMETERS

ELECTRODES	Ø16	Ø20
FIRST DRESSING	2÷5 sec or 6÷18 cutter turns	2÷5 sec or 6÷18 cutter turns
CYCLE DRESSING	1÷3 sec or 3÷10 cutter turns	1÷3 sec or 3÷10 cutter turns
WELDING GUNS CLOSING FORCE	150±20 daN	180±20 daN
MATERIAL REMOVAL WITH α=120°	0.037±0.004mm/s	0.037±0.004mm/s
DRESSING FREQUENCY	100±20 welding points	100±20 welding points

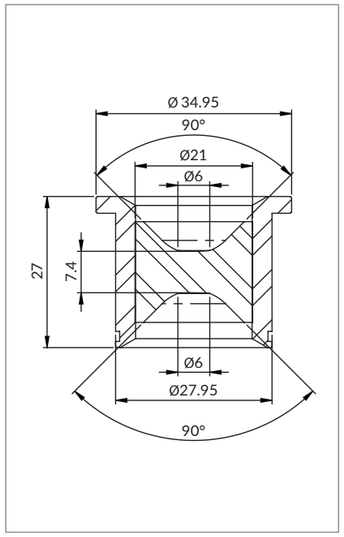


DRESSABLE ELECTRODE SHAPES

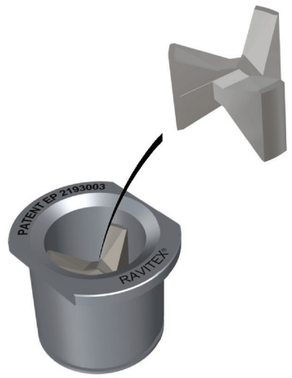
If the electrodes do not correspond to ISO 5821 B-E-F-G, send the welding gun and electrode drawings with the offer request in one of the following formats: step, igs, xt, sat, catpart, dwg, dxf.

Order number
070127000001

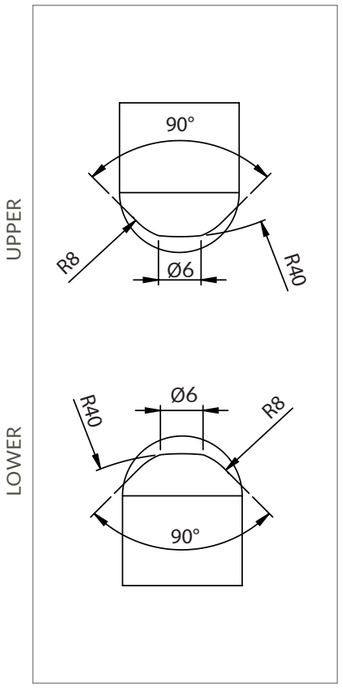
Description
Cutter ROBT 90 R8 P6 (R40)
RX Patent EP 2193003



3-blades self-centering in hard metal / stainless steel bush



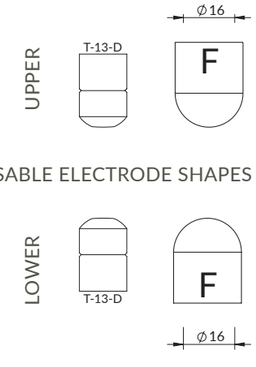
SUITABLE FOR DRESSERS: OBARA



ELECTRODE SHAPES
New
Dressed

RECOMMENDED OPERATING PARAMETERS

ELECTRODES	Ø16	Ø20
FIRST DRESSING	2÷5 sec or 6÷18 cutter turns	2÷5 sec or 6÷18 cutter turns
CYCLE DRESSING	1÷3 sec or 3÷10 cutter turns	1÷3 sec or 3÷10 cutter turns
WELDING GUNS CLOSING FORCE	150±20 daN	180±20 daN
MATERIAL REMOVAL WITH α =90°	0.050±0.004mm/s	0.050±0.004mm/s
DRESSING FREQUENCY	100±20 welding points	100±20 welding points



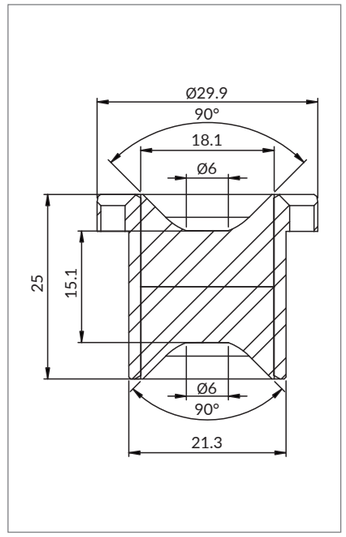
DRESSABLE ELECTRODE SHAPES

If the electrodes do not correspond to ISO 5821 B-E-F-G, send the welding gun and electrode drawings with the offer request in one of the following formats: step, igs, xt, sat, catpart, dwg, dxf.

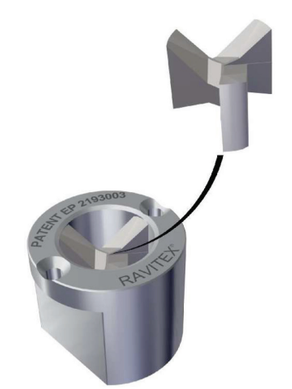
Cutters RX Patent ***EP 2193003***

Order number
070128000002

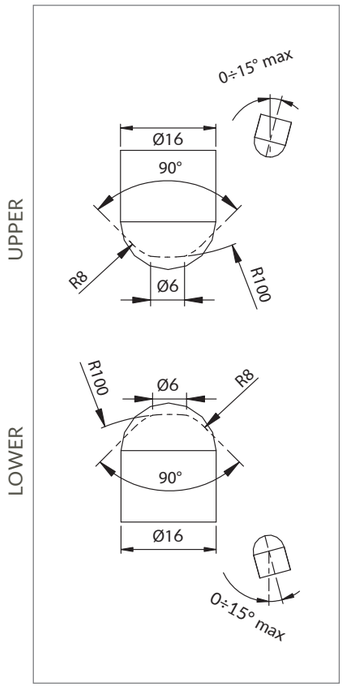
Description
Fresa ROAS 90 R8 P6(R100) D18
RX Patent EP 2193003



3-blades self-centering in hard metal / stainless steel bush



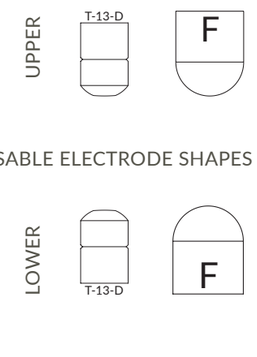
SUITABLE FOR DRESSERS: KYOKUTOH



ELECTRODE SHAPES
New
Dressed

RECOMMENDED OPERATING PARAMETERS

ELECTRODES	Ø16	Ø20
FIRST DRESSING	2÷5 sec or 6÷18 cutter turns	2÷5 sec or 6÷18 cutter turns
CYCLE DRESSING	1÷3 sec or 3÷10 cutter turns	1÷3 sec or 3÷10 cutter turns
WELDING GUNS CLOSING FORCE	150±20 daN	180±20 daN
MATERIAL REMOVAL WITH α=90°	0.050±0.004mm/s	0.050±0.004mm/s
DRESSING FREQUENCY	100±20 welding points	100±20 welding points



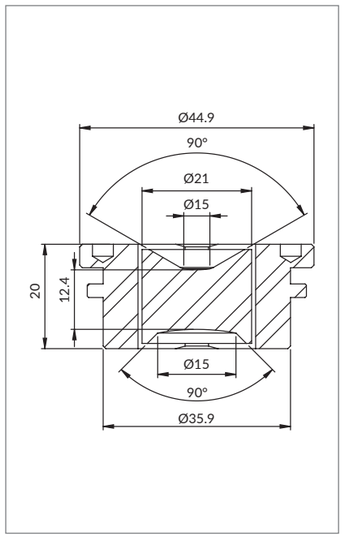
DRESSABLE ELECTRODE SHAPES

If the electrodes do not correspond to ISO 5821 B-E-F-G, send the welding gun and electrode drawings with the offer request in one of the following formats: step, igs, xt, sat, catpart, dwg, dxf.

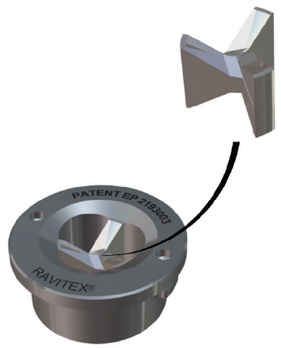
Cutters RX Patent ***EP 2193003*** for exposed welding spots

Order number
070101000037

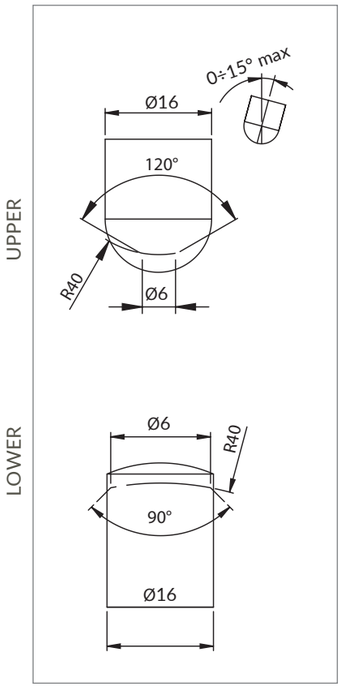
Description
Cutter RFRW 120 P6 R40 (16)
RX Patent EP 2193003



3-blades self-centering in hard metal / stainless steel bush



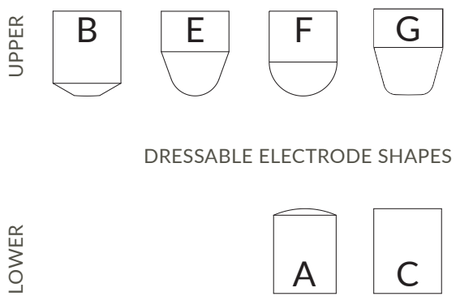
SUITABLE FOR DRESSERS: SINTERLEGHE, BRÄUER



ELECTRODE SHAPES
New ——————
Dressed - - - - - - - - - - - - - - - -

RECOMMENDED OPERATING PARAMETERS

ELECTRODES	Ø16	Ø20
FIRST DRESSING	2÷5 sec or 6÷18 cutter turns	2÷5 sec or 6÷18 cutter turns
CYCLE DRESSING	1÷3 sec or 3÷10 cutter turns	1÷3 sec or 3÷10 cutter turns
WELDING GUNS CLOSING FORCE	150±20 daN	180±20 daN
MATERIAL REMOVAL WITH α =120°	0.037±0.004mm/s	0.037±0.004mm/s
DRESSING FREQUENCY	100±20 welding points	100±20 welding points



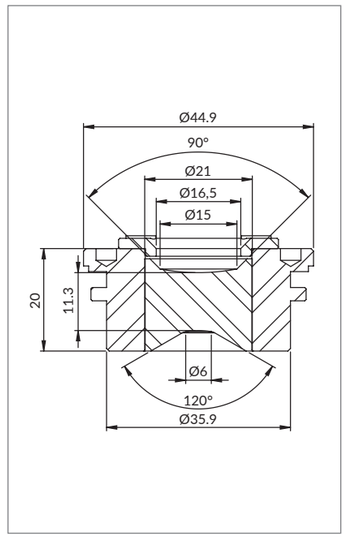
DRESSABLE ELECTRODE SHAPES

If the electrodes do not correspond to ISO 5821 B-E-F-G, send the welding gun and electrode drawings with the offer request in one of the following formats: step, igs, xt, sat, catpart, dwg, dxf.

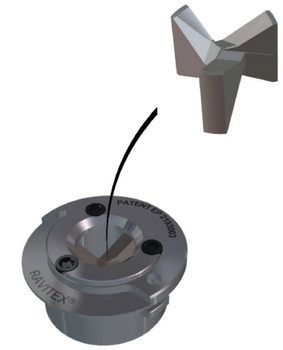
Cutters RX Patent ***EP 2193003*** for exposed welding spots

Order number
070101000136

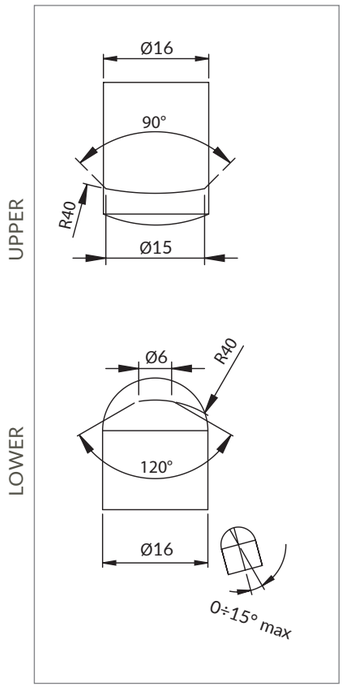
Description
Cutter RFRW R40 (16)
+C16.5 120 P6 1s RX
Patent EP 2193003



3-blades self-centering in hard metal / stainless steel bush



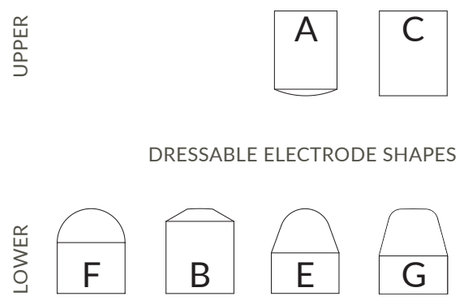
SUITABLE FOR DRESSERS: SINTERLEGHE, BRÄUER, AEG



ELECTRODE SHAPES
New ——————
Dressed - - - - - - - - - - - - - - - -

RECOMMENDED OPERATING PARAMETERS

ELECTRODES	Ø16	Ø20
FIRST DRESSING	2÷5 sec or 6÷18 cutter turns	2÷5 sec or 6÷18 cutter turns
CYCLE DRESSING	1÷3 sec or 3÷10 cutter turns	1÷3 sec or 3÷10 cutter turns
WELDING GUNS CLOSING FORCE	150±20 daN	180±20 daN
MATERIAL REMOVAL WITH α =90°	0.050±0.004mm/s	0.050±0.004mm/s
DRESSING FREQUENCY	100±20 welding points	100±20 welding points



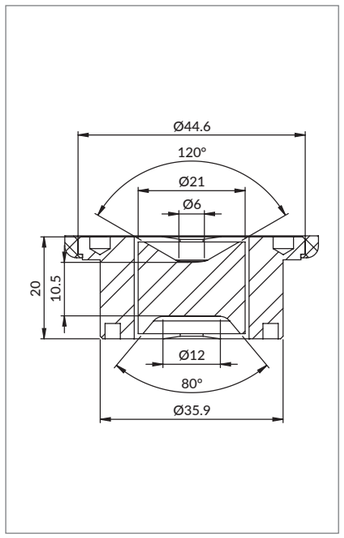
DRESSABLE ELECTRODE SHAPES

If the electrodes do not correspond to ISO 5821 B-E-F-G, send the welding gun and electrode drawings with the offer request in one of the following formats: step, igs, xt, sat, catpart, dwg, dxf.

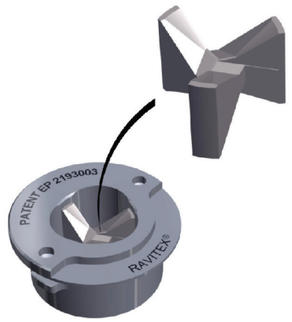
Cutters RX Patent ***EP 2193003*** for exposed welding spots

Order number
070111000003

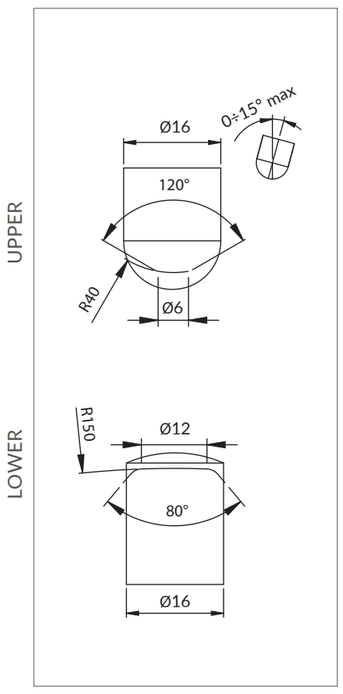
Description
Cutter RFL 120 P6
R150(16) 1s RX
Patent EP 2193003



3-blades self-centering in hard metal / stainless steel bush



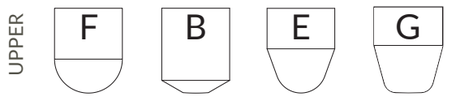
SUITABLE FOR DRESSERS: LUTZ, KAPPEN



ELECTRODE SHAPES
New
Dressed

RECOMMENDED OPERATING PARAMETERS

ELECTRODES	Ø16	Ø20
FIRST DRESSING	2÷5 sec or 6÷18 cutter turns	2÷5 sec or 6÷18 cutter turns
CYCLE DRESSING	1÷3 sec or 3÷10 cutter turns	1÷3 sec or 3÷10 cutter turns
WELDING GUNS CLOSING FORCE	150±20 daN	180±20 daN
MATERIAL REMOVAL WITH α =120°	0.037±0.004mm/s	0.037±0.004mm/s
DRESSING FREQUENCY	100±20 welding points	100±20 welding points



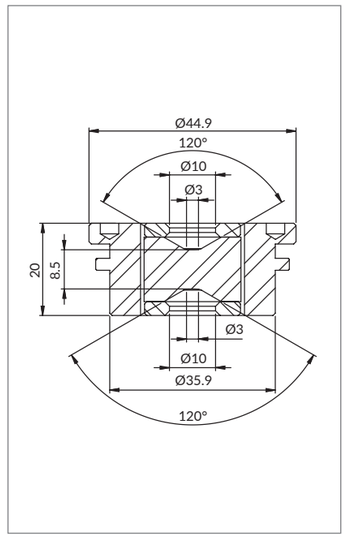
DRESSABLE ELECTRODE SHAPES

If the electrodes do not correspond to ISO 5821 B-E-F-G, send the welding gun and electrode drawings with the offer request in one of the following formats: step, igs, xt, sat, catpart, dwg, dxf.

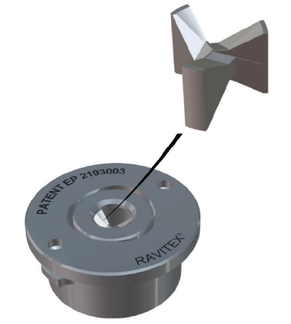
Cutters RX Patent ***EP 2193003*** special

Order number
070101000070

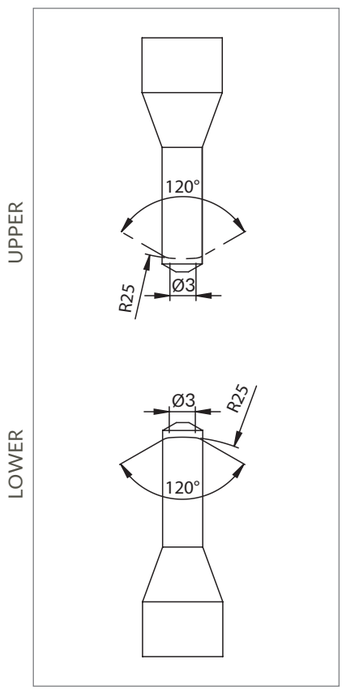
Description
Cutter RFRW 120
P3 ±C10 RX
Patent EP 2193003



3-blades self-centering in hard metal / stainless steel bush



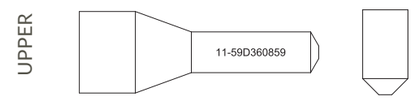
SSUITABLE FOR DRESSERS: SINTERLEGHE, BRÄUER



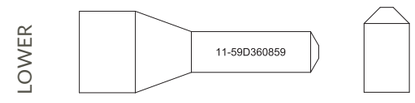
ELECTRODE SHAPES
New
Dressed

RECOMMENDED OPERATING PARAMETERS

ELECTRODES	Ø16	Ø20
FIRST DRESSING	2÷5 sec or 6÷18 cutter turns	2÷5 sec or 6÷18 cutter turns
CYCLE DRESSING	1÷3 sec or 3÷10 cutter turns	1÷3 sec or 3÷10 cutter turns
WELDING GUNS CLOSING FORCE	150±20 daN	180±20 daN
MATERIAL REMOVAL WITH α =120°	0.037±0.004mm/s	0.037±0.004mm/s
DRESSING FREQUENCY	100±20 welding points	100±20 welding points



DRESSABLE ELECTRODE SHAPES

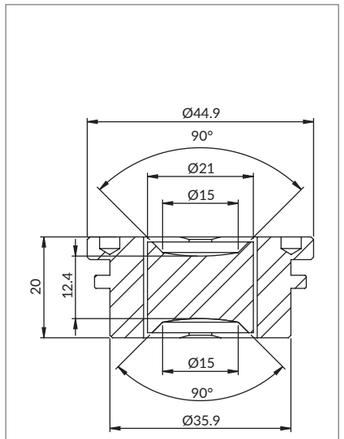


If the electrodes do not correspond to ISO 5821 B-E-F-G, send the welding gun and electrode drawings with the offer request in one of the following formats: step, igs, xt, sat, catpart, dwg, dxf.

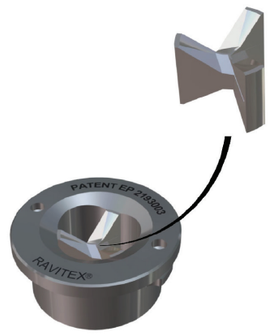
Cutters RX Patent ***EP 2193003*** for aluminium sheets

Order number
070101000033

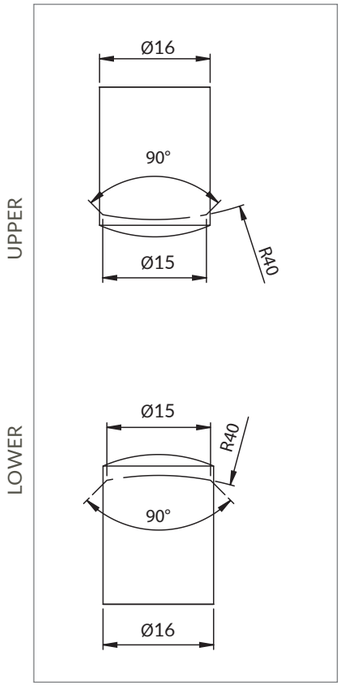
Description
Cutter RFRW R40 (16)
RX Patent EP 2193003



3-blades self-centering in hard metal / stainless steel bush



SUITABLE FOR DRESSERS: SINTERLEGHE, BRÄUER

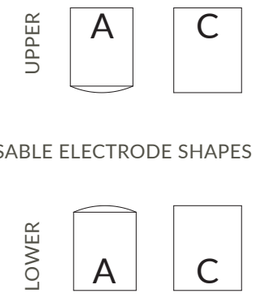


ELECTRODE SHAPES
New
Dressed

RECOMMENDED OPERATING PARAMETERS

ELECTRODES	Ø16	Ø20
FIRST DRESSING	2÷5 sec or 6÷18 cutter turns	2÷5 sec or 6÷18 cutter turns
CYCLE DRESSING	1÷3 sec or 3÷10 cutter turns	1÷3 sec or 3÷10 cutter turns
WELDING GUNS CLOSING FORCE	150±20 daN	180±20 daN
MATERIAL REMOVAL WITH α =90°	0.050±0.004mm/s	0.050±0.004mm/s
DRESSING FREQUENCY	100±20 welding points	100±20 welding points

DRESSABLE ELECTRODE SHAPES

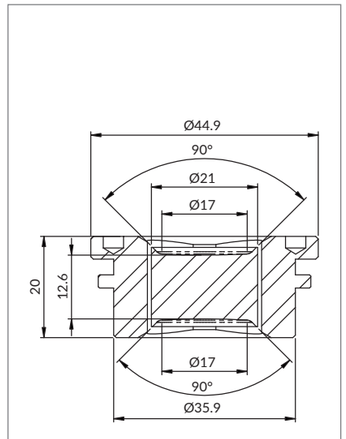


If the electrodes do not correspond to ISO 5821 B-E-F-G, send the welding gun and electrode drawings with the offer request in one of the following formats: step, igs, xt, sat, catpart, dwg, dxf.

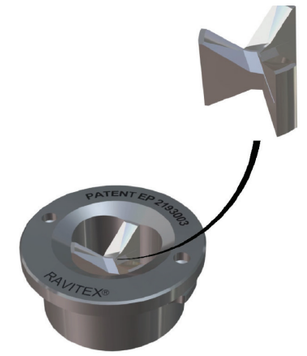
Cutters RX Patent ***EP 2193003*** for aluminium sheets

Order number
070101000074

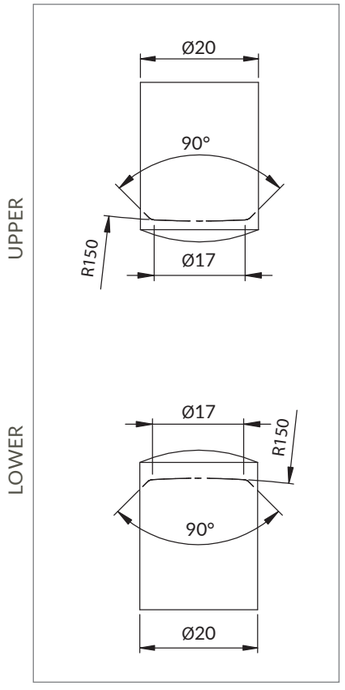
Description
Cutter RFRW R150 (20)
RX Patent EP 2193003



3-blades self-centering in hard metal / stainless steel bush



SSUITABLE FOR DRESSERS: SINTERLEGHE, BRÄUER

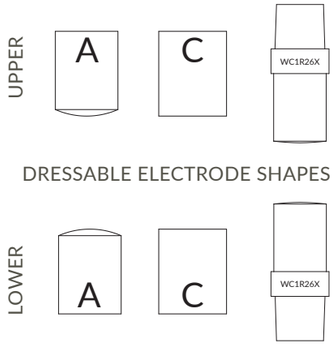


ELECTRODE SHAPES
New
Dressed

RECOMMENDED OPERATING PARAMETERS

ELECTRODES	Ø16	Ø20
FIRST DRESSING	2÷5 sec or 6÷18 cutter turns	2÷5 sec or 6÷18 cutter turns
CYCLE DRESSING	1÷3 sec or 3÷10 cutter turns	1÷3 sec or 3÷10 cutter turns
WELDING GUNS CLOSING FORCE	150±20 daN	180±20 daN
MATERIAL REMOVAL WITH α =90°	0.050±0.004mm/s	0.050±0.004mm/s
DRESSING FREQUENCY	100±20 welding points	100±20 welding points

DRESSABLE ELECTRODE SHAPES

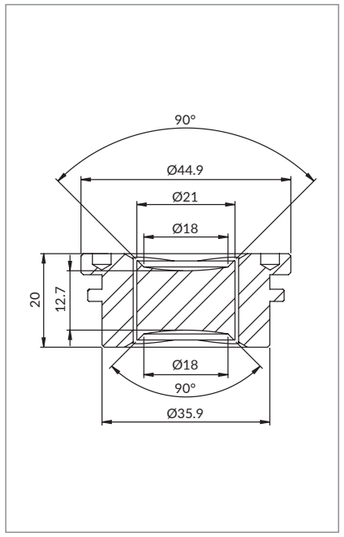


If the electrodes do not correspond to ISO 5821 B-E-F-G, send the welding gun and electrode drawings with the offer request in one of the following formats: step, igs, xt, sat, catpart, dwg, dxf.

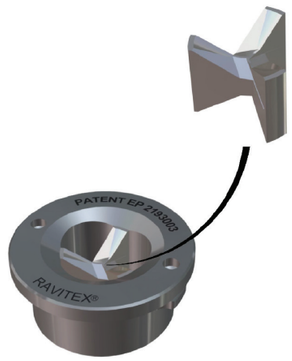
Cutters RX Patent ***EP 2193003*** for aluminium sheets

Order number
070101000087

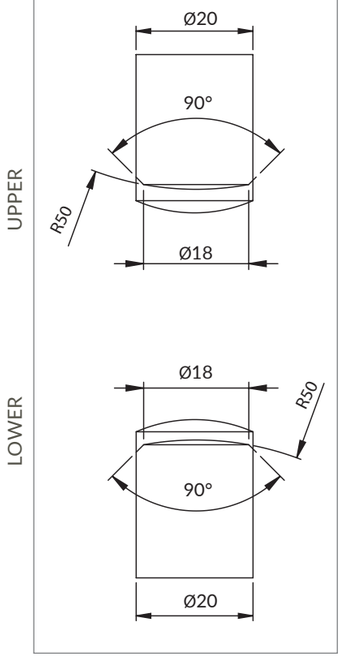
Description
Cutter RFRW R50 (20)
RX Patent EP 2193003



3-blades self-centering in hard metal / stainless steel bush



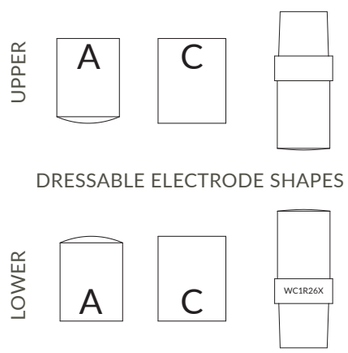
SUITABLE FOR DRESSERS: SINTERLEGHE, BRÄUER



ELECTRODE SHAPES
New
Dressed

RECOMMENDED OPERATING PARAMETERS

ELECTRODES	Ø16	Ø20
FIRST DRESSING	2÷5 sec or 6÷18 cutter turns	2÷5 sec or 6÷18 cutter turns
CYCLE DRESSING	1÷3 sec or 3÷10 cutter turns	1÷3 sec or 3÷10 cutter turns
WELDING GUNS CLOSING FORCE	150±20 daN	180±20 daN
MATERIAL REMOVAL WITH α =90°	0.050±0.004mm/s	0.050±0.004mm/s
DRESSING FREQUENCY	100±20 welding points	100±20 welding points



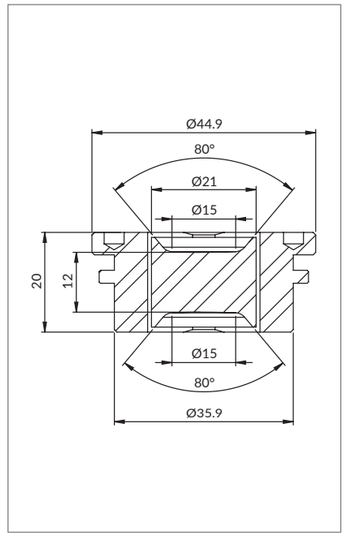
DRESSABLE ELECTRODE SHAPES

If the electrodes do not correspond to ISO 5821 B-E-F-G, send the welding gun and electrode drawings with the offer request in one of the following formats: step, igs, xt, sat, catpart, dwg, dxf.

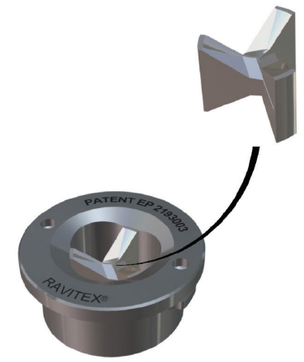
Cutters RX Patent ***EP 2193003*** for aluminium sheets

Order number
070101000098

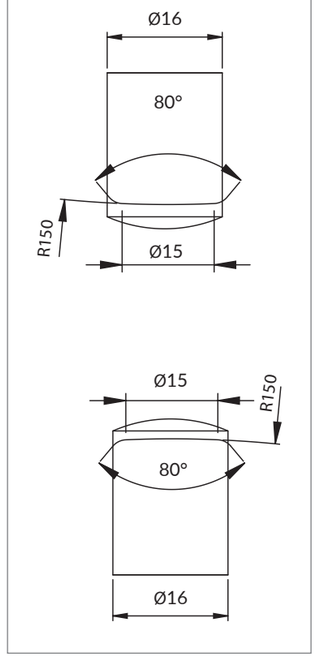
Description
Cutter RFRW R150 (16)
RX Patent EP 2193003



3-blades self-centering in hard metal / stainless steel bush



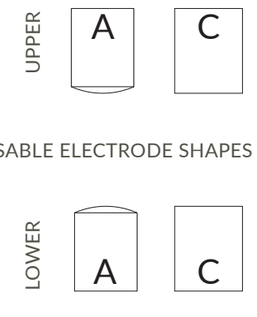
SUITABLE FOR DRESSERS: SINTERLEGHE, BRÄUER



ELECTRODE SHAPES
New
Dressed

RECOMMENDED OPERATING PARAMETERS

ELECTRODES	Ø16	Ø20
FIRST DRESSING	2÷5 sec or 6÷18 cutter turns	2÷5 sec or 6÷18 cutter turns
CYCLE DRESSING	1÷3 sec or 3÷10 cutter turns	1÷3 sec or 3÷10 cutter turns
WELDING GUNS CLOSING FORCE	150±20 daN	180±20 daN
MATERIAL REMOVAL WITH α =80°	0.050±0.004mm/s	0.050±0.004mm/s
DRESSING FREQUENCY	100±20 welding points	100±20 welding points



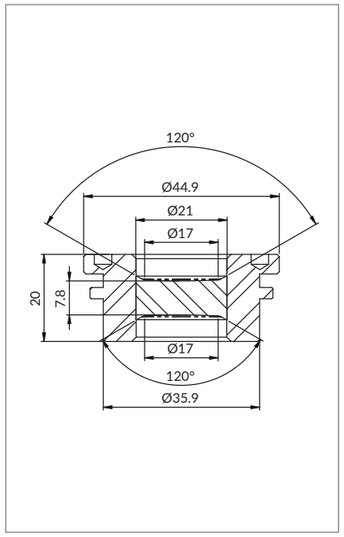
DRESSABLE ELECTRODE SHAPES

If the electrodes do not correspond to ISO 5821 B-E-F-G, send the welding gun and electrode drawings with the offer request in one of the following formats: step, igs, xt, sat, catpart, dwg, dxf.

Cutters RX Patent ***EP 2193003*** for aluminium sheets

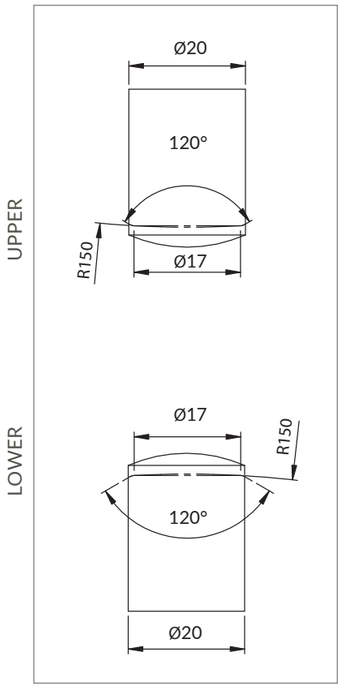
Order number
070101000121

Description
Cutter RFRW 120 R150 (20)
H10 SS RX Patent EP 2193003



3-blades self-centering in hard metal / stainless steel bush

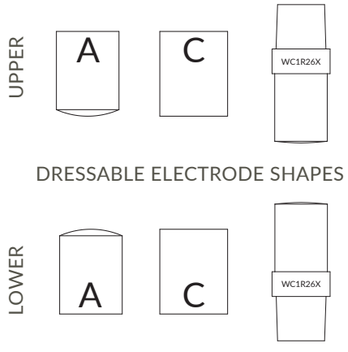
SUITABLE FOR DRESSERS: SINTERLEGHE, BRÄUER



ELECTRODE SHAPES
New
Dressed

RECOMMENDED OPERATING PARAMETERS

ELECTRODES	Ø16	Ø20
FIRST DRESSING	2÷5 sec or 6÷18 cutter turns	2÷5 sec or 6÷18 cutter turns
CYCLE DRESSING	1÷3 sec or 3÷10 cutter turns	1÷3 sec or 3÷10 cutter turns
WELDING GUNS CLOSING FORCE	150±20 daN	180±20 daN
MATERIAL REMOVAL WITH α =120°	0.037±0.004mm/s	0.037±0.004mm/s
DRESSING FREQUENCY	100±20 welding points	100±20 welding points

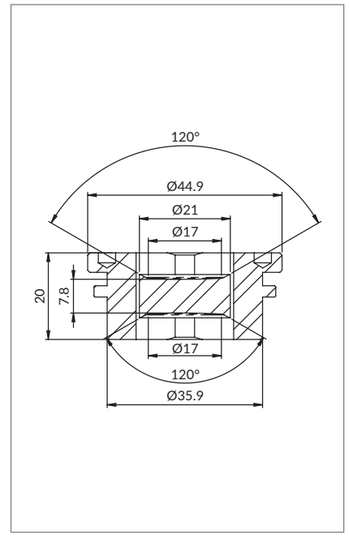


If the electrodes do not correspond to ISO 5821 B-E-F-G, send the welding gun and electrode drawings with the offer request in one of the following formats: step, igs, xt, sat, catpart, dwg, dxf.

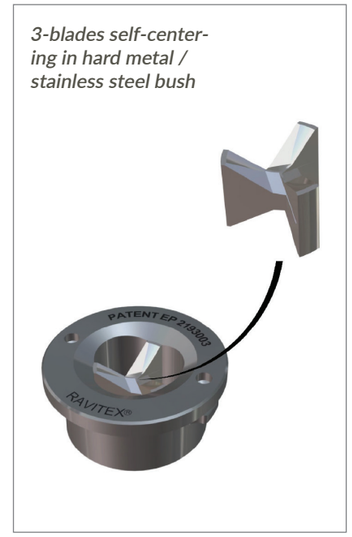
Cutters RX Patent ***EP 2193003*** for aluminium sheets

Order number
070101000142

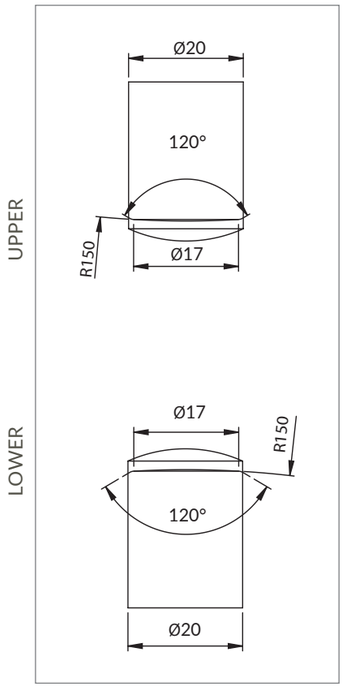
Description
Cutter RFRW 120 R150 (20)
H10 RX Patent EP 2193003



3-blades self-centering in hard metal / stainless steel bush



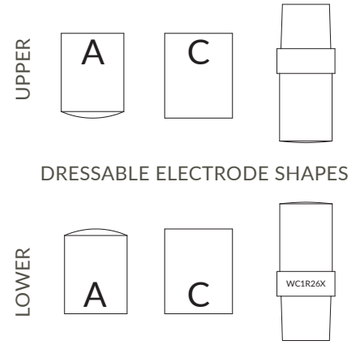
SUITABLE FOR DRESSERS: SINTERLEGHE, BRÄUER



ELECTRODE SHAPES
New
Dressed

RECOMMENDED OPERATING PARAMETERS

ELECTRODES	Ø16	Ø20
FIRST DRESSING	2÷5 sec or 6÷18 cutter turns	2÷5 sec or 6÷18 cutter turns
CYCLE DRESSING	1÷3 sec or 3÷10 cutter turns	1÷3 sec or 3÷10 cutter turns
WELDING GUNS CLOSING FORCE	150±20 daN	180±20 daN
MATERIAL REMOVAL WITH α =120°	0.037±0.004mm/s	0.037±0.004mm/s
DRESSING FREQUENCY	100±20 welding points	100±20 welding points

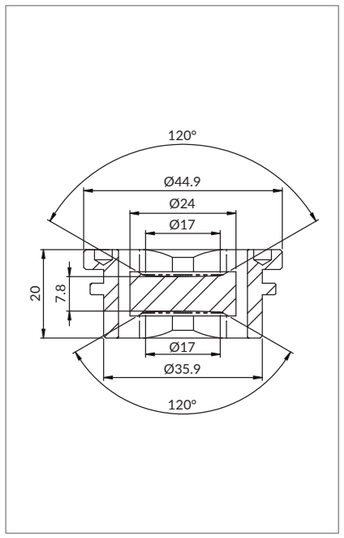


If the electrodes do not correspond to ISO 5821 B-E-F-G, send the welding gun and electrode drawings with the offer request in one of the following formats: step, igs, xt, sat, catpart, dwg, dxf.

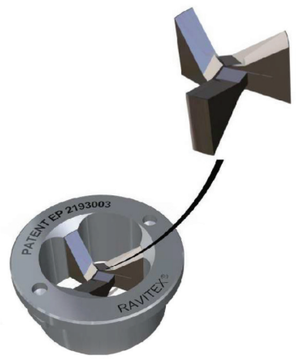
Cutters RX Patent ***EP 2193003*** for aluminium sheets

Order number
070101000143

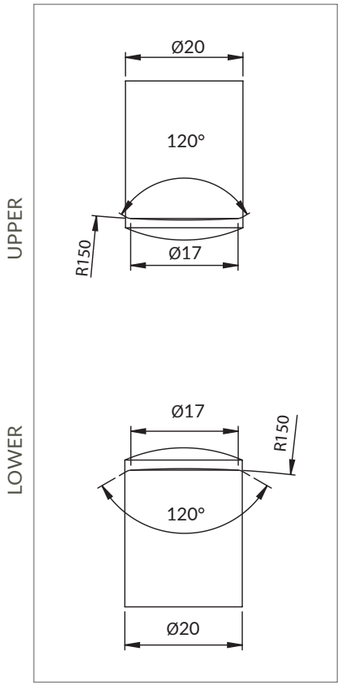
Description
Cutter RFRW 120 R150 (20)
H10 D24 RX Patent EP 2193003



3-blades self-centering in hard metal / stainless steel bush



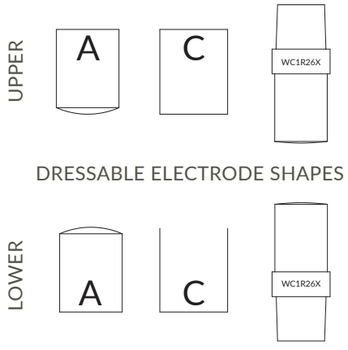
SUITABLE FOR DRESSERS: SINTERLEGHE, BRÄUER



ELECTRODE SHAPES
New
Dressed

RECOMMENDED OPERATING PARAMETERS

ELECTRODES	Ø16	Ø20
FIRST DRESSING	2÷5 sec or 6÷18 cutter turns	2÷5 sec or 6÷18 cutter turns
CYCLE DRESSING	1÷3 sec or 3÷10 cutter turns	1÷3 sec or 3÷10 cutter turns
WELDING GUNS CLOSING FORCE	150±20 daN	180±20 daN
MATERIAL REMOVAL WITH α =120°	0.037±0.004mm/s	0.037±0.004mm/s
DRESSING FREQUENCY	100±20 welding points	100±20 welding points

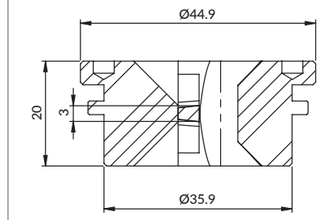


If the electrodes do not correspond to ISO 5821 B-E-F-G, send the welding gun and electrode drawings with the offer request in one of the following formats: step, igs, xt, sat, catpart, dwg, dxf.

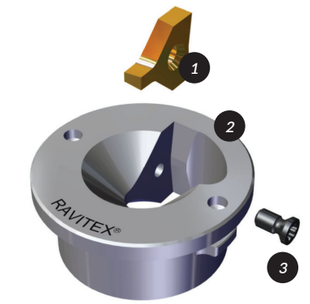
Single blade cutters

Order number
070201000001

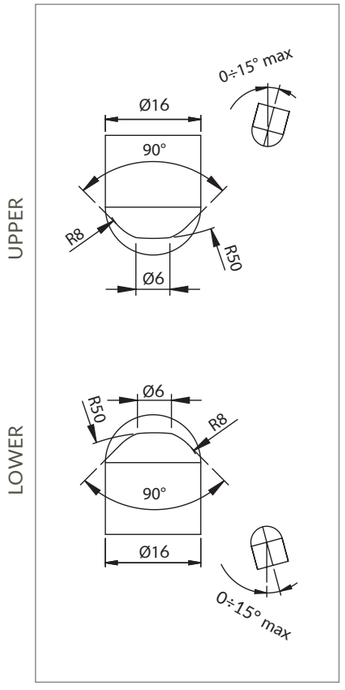
Description
Single blade cutter
RFRW 90 R8 P6



1. Cod. 030901000004
2. Cod. 030801000032
3. Cod. 100100000039



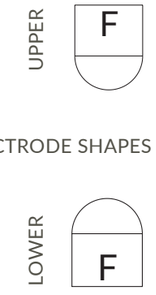
SUITABLE FOR DRESSERS: SINTERLEGHE, BRÄUER



ELECTRODE SHAPES
New
Dressed

RECOMMENDED OPERATING PARAMETERS

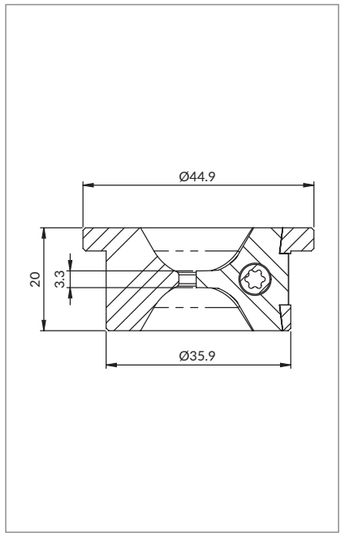
ELECTRODES	Ø16	Ø20
FIRST DRESSING	1÷3 sec or 3÷10 cutter turns	3÷5 sec or 10÷18 cutter turns
CYCLE DRESSING	0.5÷1 sec or 1÷3 cutter turns	1÷1.5 sec or 3÷5 cutter turns
WELDING GUNS CLOSING FORCE	115±15 daN	130±20 daN



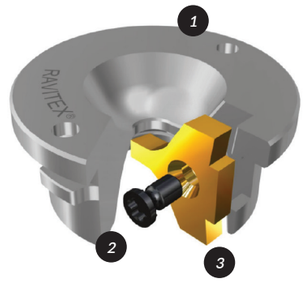
If the electrodes do not correspond to ISO 5821 B-E-F-G, send the welding gun and electrode drawings with the offer request in one of the following formats: step, igs, xt, sat, catpart, dwg, dxf.

Order number
070201000002

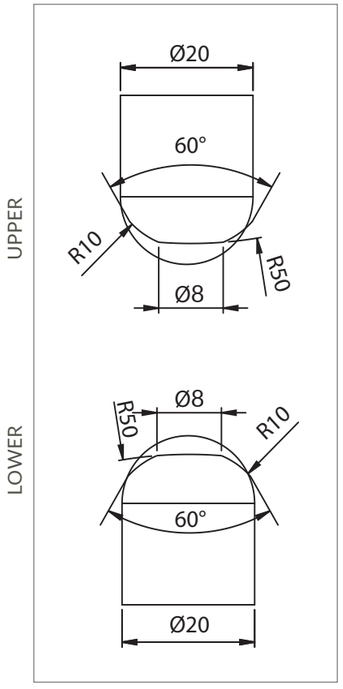
Description
Single blade cutter
RFRW 60 R10 P8



1. Cod. 030801000042
2. Cod. 100100000039
3. Cod. 030901000007



SUITABLE FOR DRESSERS: SINTERLEGHE, BRÄUER



ELECTRODE SHAPES
New
Dressed

RECOMMENDED OPERATING PARAMETERS

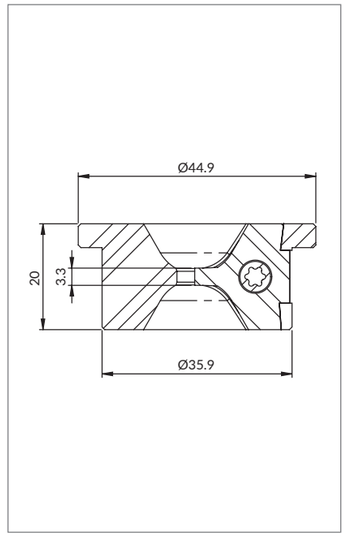
ELECTRODES	Ø16	Ø20
FIRST DRESSING	1÷3 sec or 3÷10 cutter turns	3÷5 sec or 10÷18 cutter turns
CYCLE DRESSING	0.5÷1 sec or 1÷3 cutter turns	1÷1.5 sec or 3÷5 cutter turns
WELDING GUNS CLOSING FORCE	115±15 daN	130±20 daN

DRESSABLE ELECTRODE SHAPES

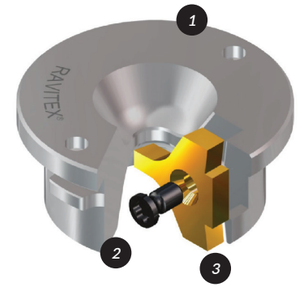
If the electrodes do not correspond to ISO 5821 B-E-F-G, send the welding gun and electrode drawings with the offer request in one of the following formats: step, igs, xt, sat, catpart, dwg, dxf.

Order number
070201000003

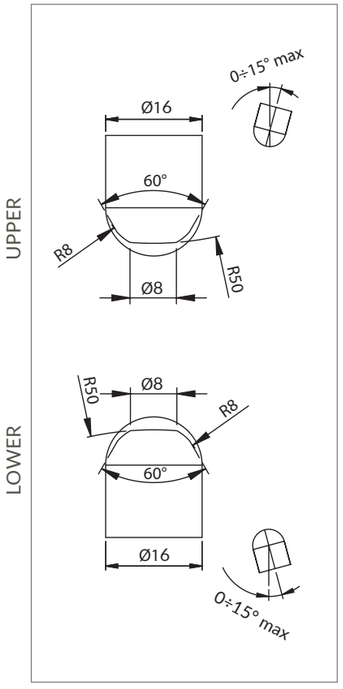
Description
Single blade cutter
RFRW 60 R8 P8



1. Cod. 030801000040
2. Cod. 100100000039
3. Cod. 030901000005



SUITABLE FOR DRESSERS: SINTERLEGHE, BRÄUER



ELECTRODE SHAPES
New
Dressed

RECOMMENDED OPERATING PARAMETERS

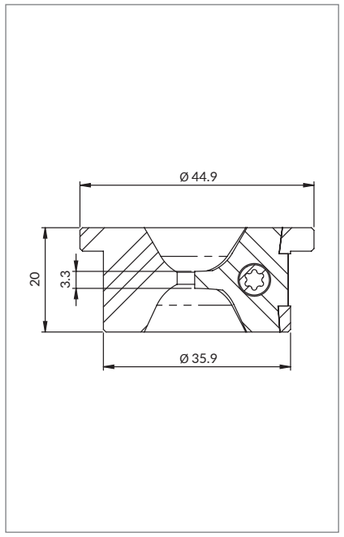
ELECTRODES	Ø16	Ø20
FIRST DRESSING	1÷3 sec or 3÷10 cutter turns	3÷5 sec or 10÷18 cutter turns
CYCLE DRESSING	0.5÷1 sec or 1÷3 cutter turns	1÷1.5 sec or 3÷5 cutter turns
WELDING GUNS CLOSING FORCE	115±15 daN	130±20 daN

DRESSABLE ELECTRODE SHAPES

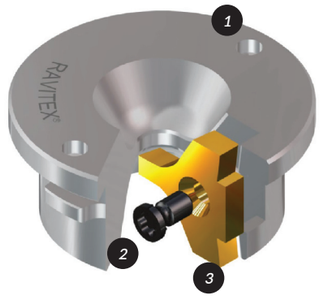
If the electrodes do not correspond to ISO 5821 B-E-F-G, send the welding gun and electrode drawings with the offer request in one of the following formats: step, igs, xt, sat, catpart, dwg, dxf.

Order number
070201000005

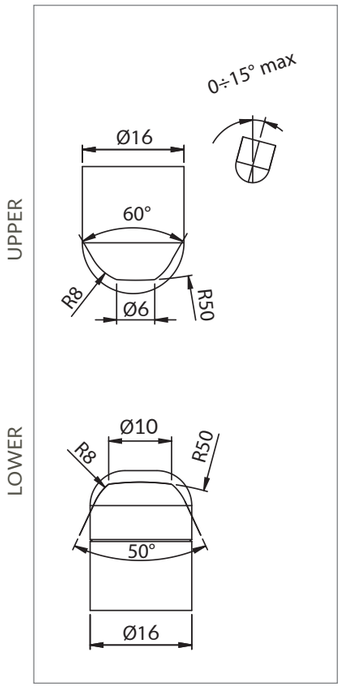
Description
Single blade cutter
RFRW +60 R8 P6 -50 R8 P10



1. Cod. 030801000051
2. Cod. 100100000039
3. Cod. 030901000011



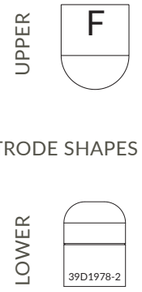
SUITABLE FOR DRESSERS: SINTERLEGHE, BRÄUER



ELECTRODE SHAPES
New
Dressed

RECOMMENDED OPERATING PARAMETERS

ELECTRODES	Ø16	Ø20
FIRST DRESSING	1÷3 sec or 3÷10 cutter turns	3÷5 sec or 10÷18 cutter turns
CYCLE DRESSING	0.5÷1 sec or 1÷3 cutter turns	1÷1.5 sec or 3÷5 cutter turns
WELDING GUNS CLOSING FORCE	115±15 daN	130±20 daN

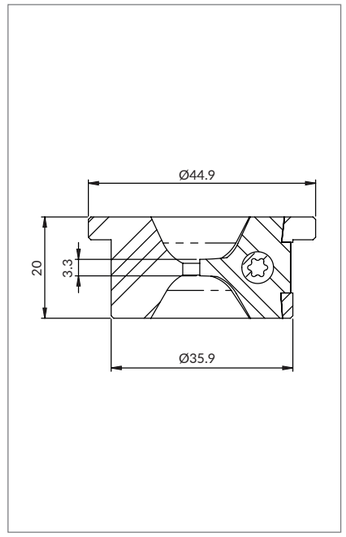


DRESSABLE ELECTRODE SHAPES

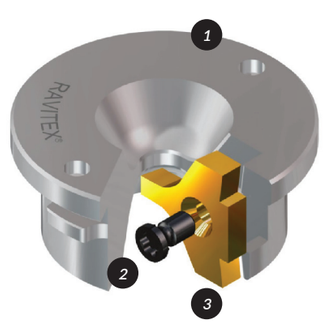
If the electrodes do not correspond to ISO 5821 B-E-F-G, send the welding gun and electrode drawings with the offer request in one of the following formats: step, igs, xt, sat, catpart, dwg, dxf.

Order number
070201000006

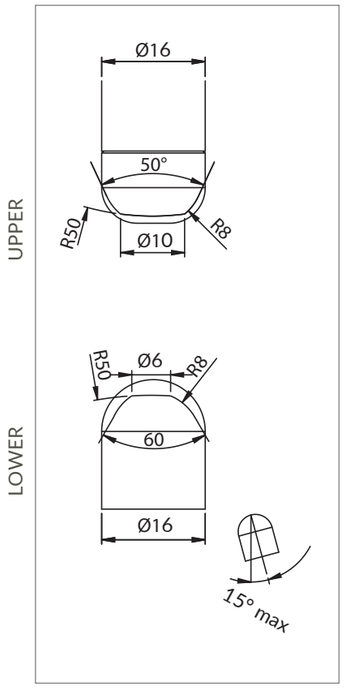
Description
Single blade cutter
RFRW +50 R8 P10 -60 R8 P6



1. Cod. 030801000052
2. Cod. 100100000039
3. Cod. 030901000012



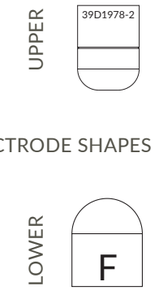
SUITABLE FOR DRESSERS: SINTERLEGHE, BRÄUER



ELECTRODE SHAPES
New
Dressed

RECOMMENDED OPERATING PARAMETERS

ELECTRODES	Ø16	Ø20
FIRST DRESSING	1÷3 sec or 3÷10 cutter turns	3÷5 sec or 10÷18 cutter turns
CYCLE DRESSING	0.5÷1 sec or 1÷3 cutter turns	1÷1.5 sec or 3÷5 cutter turns
WELDING GUNS CLOSING FORCE	115±15 daN	130±20 daN

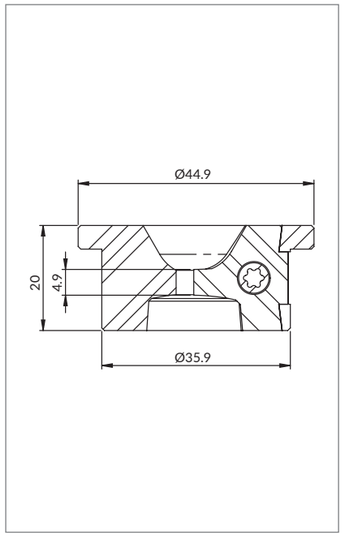


DRESSABLE ELECTRODE SHAPES

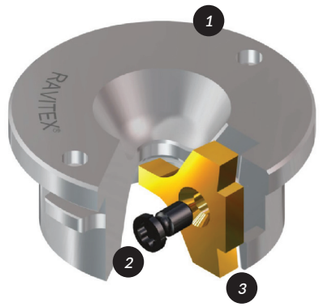
If the electrodes do not correspond to ISO 5821 B-E-F-G, send the welding gun and electrode drawings with the offer request in one of the following formats: step, igs, xt, sat, catpart, dwg, dxf.

Order number
070201000007

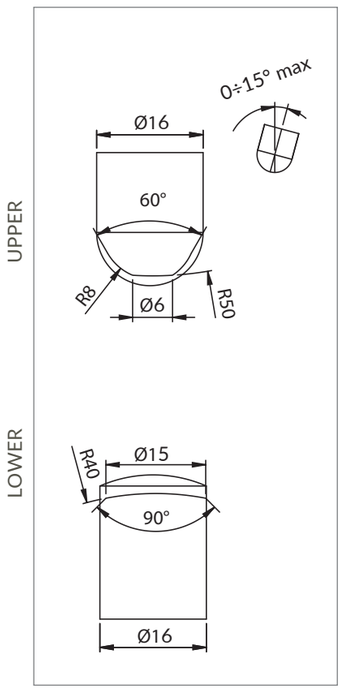
Description
Single blade cutter RFRW
+60 R8 P6 -R40 (16)



1. Cod. 030801000048
2. Cod. 100100000039
3. Cod. 030901000008



SUITABLE FOR DRESSERS: SINTERLEGHE, BRÄUER



ELECTRODE SHAPES
New
Dressed

RECOMMENDED OPERATING PARAMETERS

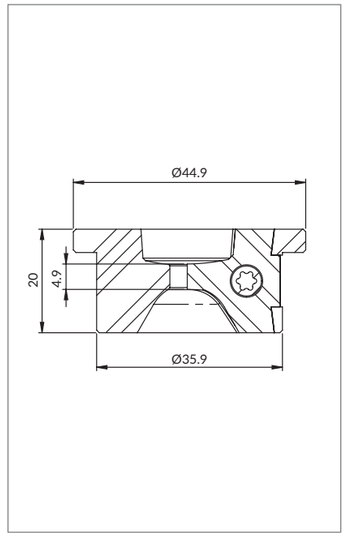
ELECTRODES	Ø16	Ø20
FIRST DRESSING	1÷3 sec or 3÷10 cutter turns	3÷5 sec or 10÷18 cutter turns
CYCLE DRESSING	0.5÷1 sec or 1÷3 cutter turns	1÷1.5 sec or 3÷5 cutter turns
WELDING GUNS CLOSING FORCE	115±15 daN	130±20 daN

DRESSABLE ELECTRODE SHAPES

If the electrodes do not correspond to ISO 5821 B-E-F-G, send the welding gun and electrode drawings with the offer request in one of the following formats: step, igs, xt, sat, catpart, dwg, dxf.

Order number
070201000008

Description
Single blade cutter RFRW
+R40(16) -60 R8 P6



1. Cod. 030801000049
2. Cod. 100100000039
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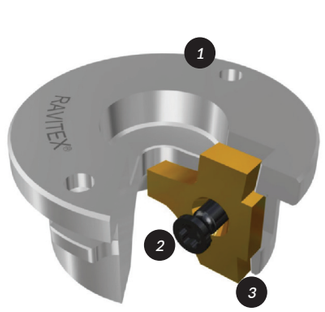
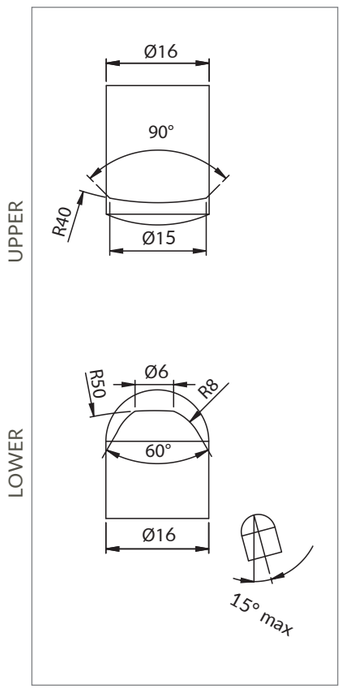


SUITABLE FOR DRESSERS: SINTERLEGHE, BRÄUER



ELECTRODE SHAPES
New
Dressed

RECOMMENDED OPERATING PARAMETERS

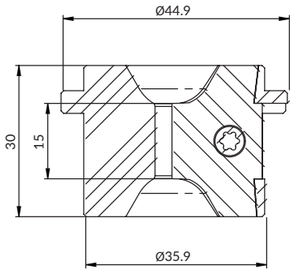
ELECTRODES	Ø16	Ø20
FIRST DRESSING	1÷3 sec or 3÷10 cutter turns	3÷5 sec or 10÷18 cutter turns
CYCLE DRESSING	0.5÷1 sec or 1÷3 cutter turns	1÷1.5 sec or 3÷5 cutter turns
WELDING GUNS CLOSING FORCE	115±15 daN	130±20 daN

DRESSABLE ELECTRODE SHAPES

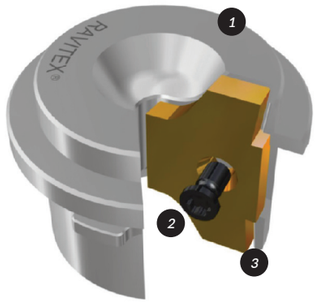
If the electrodes do not correspond to ISO 5821 B-E-F-G, send the welding gun and electrode drawings with the offer request in one of the following formats: step, igs, xt, sat, catpart, dwg, dxf.

Order number
070201000009

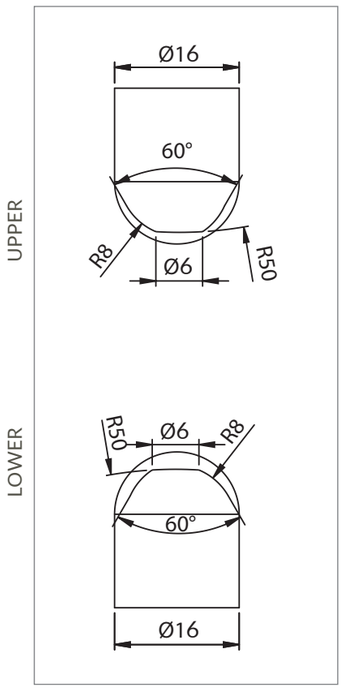
Description
Single blade cutter
RFRW 60 R8 P6 ±5mm



1. Cod. 030801000050
2. Cod. 100100000039
3. Cod. 030901000010



SUITABLE FOR DRESSERS: SINTERLEGHE, BRÄUER



ELECTRODE SHAPES
New
Dressed

RECOMMENDED OPERATING PARAMETERS

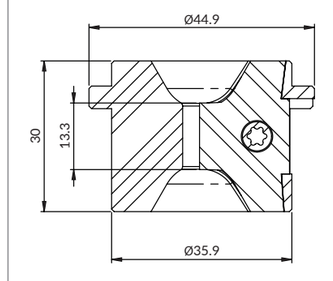
ELECTRODES	Ø16	Ø20
FIRST DRESSING	1÷3 sec or 3÷10 cutter turns	3÷5 sec or 10÷18 cutter turns
CYCLE DRESSING	0.5÷1 sec or 1÷3 cutter turns	1÷1.5 sec or 3÷5 cutter turns
WELDING GUNS CLOSING FORCE	115±15 daN	130±20 daN

DRESSABLE ELECTRODE SHAPES

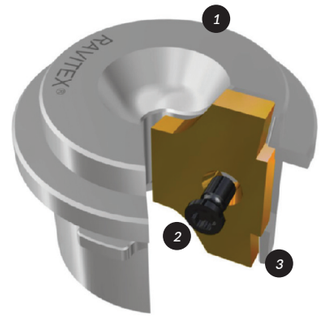
If the electrodes do not correspond to ISO 5821 B-E-F-G, send the welding gun and electrode drawings with the offer request in one of the following formats: step, igs, xt, sat, catpart, dwg, dxf.

Order number
070201000010

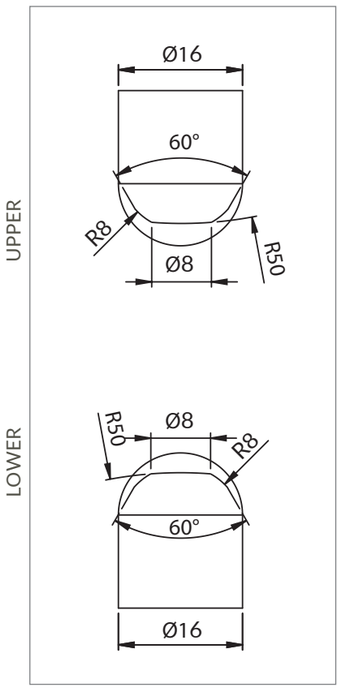
Description
Single blade cutter RFRW 60 R8
P8 ±5mm



1. Cod. 030801000054
2. Cod. 100100000039
3. Cod. 030901000013



SUITABLE FOR DRESSERS: SINTERLEGHE, BRÄUER



ELECTRODE SHAPES
New
Dressed

RECOMMENDED OPERATING PARAMETERS

ELECTRODES	Ø16	Ø20
FIRST DRESSING	1÷3 sec or 3÷10 cutter turns	3÷5 sec or 10÷18 cutter turns
CYCLE DRESSING	0.5÷1 sec or 1÷3 cutter turns	1÷1.5 sec or 3÷5 cutter turns
WELDING GUNS CLOSING FORCE	115±15 daN	130±20 daN

DRESSABLE ELECTRODE SHAPES

If the electrodes do not correspond to ISO 5821 B-E-F-G, send the welding gun and electrode drawings with the offer request in one of the following formats: step, igs, xt, sat, catpart, dwg, dxf.

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v. 02	06/2019	Reprinting and partners update
v. 01	09/2017	New catalogue

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