



system  
technik

# Product Information Catalogue

- **electrode tip dresser  
for manual welding guns**
- **electrode tip dresser  
for robot welding guns**
- **electrode tip changer**
- **combi units  
(combined electrode tip dresser/changer)**
- **swivelling systems**



system  
technik

# Technical Information

## electrode tip dresser for manual welding guns

**pneumatically driven**

**BF 2400.000.10**

**BF 2401.000.00**

**electrically driven**

**BF 2450.000.00**

**hand-operated**

**BF 2470.000.00**



# Product Information Sheet

issued:  
01.01.2012

## manual tip dressers

product information:  
BF-2400.000.10

### manual tip dresser BF-2400.000.10

The advantages of the Bräuer manual tip dresser are obvious. Our manual tip dresser are offered in several types, e.g. pneumatically and electrically driven or with manual leverage, and is an inexpensive solution for the manual electrode dressing for the single user.

The units are flexible, quick and milling head changes are possible and also the milling of different geometries is possible.

#### delivery scope:

The manual tip dresser **BF-2400.000.10** consists of the following parts:

- 1 **milling gear unit**
- 1 **pneumatic drive** (hand lever with turn-on-protection)
- 1 **handle bar** (mountable on left or right side)
- 1 **ready-made connection tube** (tube end with nozzle NW7,2; coupling NW 7,2 with nozzle for tube inner diameter of app. 9 mm)

#### note:

The necessary milling head needs to be ordered separately. Please supply us with a drawing of the used electrode caps and the desired shape of the electrode cap after the milling process.

#### illustration:



#### ordering example:

**F-2400.000.10**

manual tip dresser

Bräuer Systemtechnik GmbH  
Gewerbestraße 4  
09488 Thermalbad Wiesenbad / OT Schönfeld  
GERMANY

phone: +49 3733 5601-10  
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e-mail: [info@braeuersysteme.de](mailto:info@braeuersysteme.de)  
URL: [www.braeuersysteme.de](http://www.braeuersysteme.de)



# Product Information Sheet

issued:  
01.01.2012

## manual tip dressers

product information:  
BF-2400.000.10

### manual tip dresser BF-2400.000.10

#### operating principle:

The Bräuer electrode tip dresser BF 2400 is a pneumatically driven unit which can mill two electrodes or electrode caps at the same time. The welding gun needs to be closed for the milling operation due to the milling of both electrode caps.

#### technical data:

weight:	app. 2,5 kg
torque:	90 Nm
revolutions at milling head:	170 rpm
compressed air connection:	5,5-6,3 bar
release measure:	min. 20 mm (between upper and lower electrode)
gun force:	min. 1,0 kN, max. 1,8 kN



# Product Information Sheet

issued:  
01.01.2012

## manual tip dresser

product information:  
BF-2401.000.00

### manual tip dresser BF-2401.000.00

The advantages of the Bräuer manual tip dresser are obvious. Our manual tip dresser are offered in several types, e.g. pneumatically and electrically driven or with manual leverage, and is an inexpensive solution for the manual electrode dressing for the single user.

The units are flexible, quick and milling head changes are possible and also the milling of different geometries is possible.

#### delivery scope:

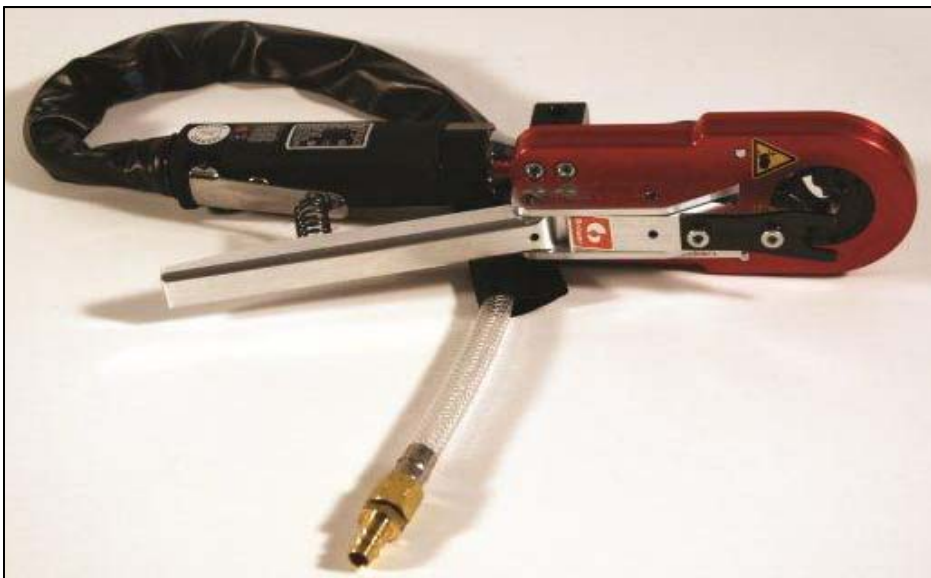
The manual tip dresser **BF-2401.000.00** consists of the following parts:

- 1 **milling gear unit**
- 1 **pneumatic drive** (lever with start up fuse)
- 1 **handle-bar** (mountable on left or right side)
- 1 **fork** (positioning of electrode cap)
- 1 **made-up connecting tube** (tube end with plug-in nozzle NW7,2; clutch NW 7,2 with tube nozzle for inner tube diameter of app. 9 mm)

#### note:

The necessary milling head needs to be ordered separately. Please supply us with a drawing of the used electrode caps and the desired shape of the electrode cap after the milling process.

#### illustration:



#### ordering example:

**F-2401.000.00**

manual tip dresser



# Product Information Sheet

issued:  
01.01.2012

## manual tip dresser

product information:  
BF-2401.000.00

### manual tip dresser BF-2401.000.00

#### operating principle:

The manual tip dresser BF 2401 is a pneumatically driven unit that can mill each electrode separately due to its reversion of the lever. The closure of the welding gun is not necessary.

#### technical data:

weight:	app. 2,5 kg
torque:	90 Nm
revolutions at milling head:	170 U/min
compressed air connection:	5,5-6,3 bar
release measure:	min. 20 mm (between upper and lower electrode)
gun force:	min. 1,0 kN, max. 1,8 kN



# Product Information Sheet

issued:  
01.01.2012

## manual tip dresser

product information:  
BF-2450.000.00

### manual tip dresser BF-2450.000.00

The advantages of the Bräuer manual tip dresser are obvious. Our manual tip dresser are offered in several types, e.g. pneumatically and electrically driven or with manual leverage, and is an inexpensive solution for the manual electrode dressing for the single user.

The units are flexible, quick and milling head changes are possible and also the milling of different geometries is possible.

#### delivery scope:

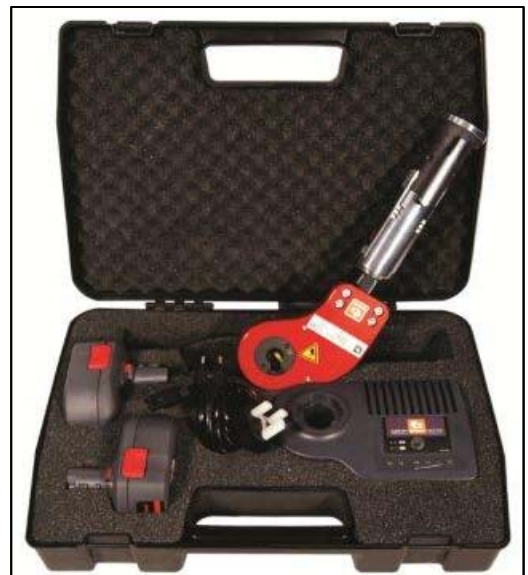
The manual tip dresser **BF-2450.000.00** consists of the following parts:

- 1 milling gear unit
- 1 electrical drive
- 2 accumulators (Ni-Cd)
- 1 speed charger
- 1 hardcase for storage of unit

#### note:

The necessary milling head needs to be ordered separately. Please supply us with a drawing of the used electrode caps and the desired shape of the electrode cap after the milling process.

#### illustration:



#### ordering example:

**F-2450.000.00**

manual tip dresser



# Product Information Sheet

issued:  
01.01.2012

## manual tip dresser

product information:  
BF-2450.000.00

### manual tip dresser BF-2450.000.00

#### operating principle:

Bräuer's manual tip dresser BF 2450 is an electrically driven unit and especially designed for the milling process of electrode caps of manual welding guns. The welding gun needs to be closed during the milling procedure because both electrode caps are milled at the same time.

#### technical data:

weight:	app. 2,9 kg (with battery)
torque:	94 Nm
revolutions at milling head:	170 U/min
rated voltage:	14,4 V
release measure:	min. $\varnothing$ 0 mm (between upper and lower electrode)
gun force:	min. 1,0 kN, max. 1,8 kN





# Product Information Sheet

issued:  
01.01.2012

## manual tip dresser

product information:  
BF-2470.000.00

### manual tip dresser BF-2470.000.00

The advantages of the Bräuer manual tip dresser are obvious. Our manual tip dresser are offered in several types, e.g. pneumatically and electrically driven or with manual leverage, and is an inexpensive solution for the manual electrode dressing for the single user.

The units are flexible, quick and milling head changes are possible and also the milling of different geometries is possible.

#### delivery scope:

The manual tip dresser **BF-2470.000.00** consists of the following parts:

- 1 milling gear unit
- 1 ratching tool

#### note:

The necessary milling head needs to be ordered separately. Please supply us with a drawing of the used electrode caps and the desired shape of the electrode cap after the milling process.

#### illustration:



#### ordering example:

**F-2470.000.00**

manual tip dresser



# Product Information Sheet

issued:  
01.01.2012

## manual tip dresser

product information:  
BF-2470.000.00

### manual tip dresser BF-2470.000.00

#### operating principle:

The manual electrode tip dresser BF 2470 is a low-priced unit. This manual tip dresser has been especially designed for the milling process of electrodes and electrode caps of manual welding guns, the BF 2470 can also be operated on spot welding machines or similar assembled systems. The manual tip dresser is even suitable for manual welding guns without a proportional valve, a gun pressure up to app. 4 kN is not a problem. The welding gun needs to be closed during the milling procedure because both electrode caps are milled at the same time.

#### technical data:

weight: app. 1,6 kg  
release measure: min. 20 mm (between upper and lower electrode)  
gun force: app. 1,5 kN



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# Technical Information

## electrode tip dresser for robot welding guns

□ **single head**  
**BFS 3600.037.00A**

□ **double head**  
**BFS 3610.037.00A**



# Product Information Sheet

issued:  
01.01.2011

## electrode tip dresser for robot guns

product information:  
BFS-3600.037.00A

### electrode tip dresser BFS-3600.037.00A

Stationary electrode tip dresser support the welding process within a robot cell by reshaping the electrode cap after a certain amount of welding points.

These units can be ordered in setup H, V1 and V2. For setup type V2 an additional vertical angle needs to be added to your order.

The necessary milling head needs to be ordered separately. We will be glad to assist you in choosing one.

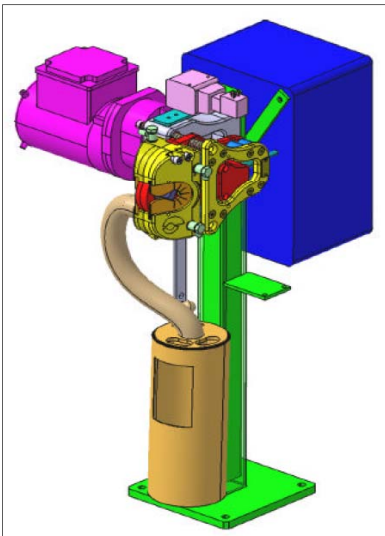
#### delivery scope:

The standard stationary electrode tip dresser BFS-3600.037.00A consists:

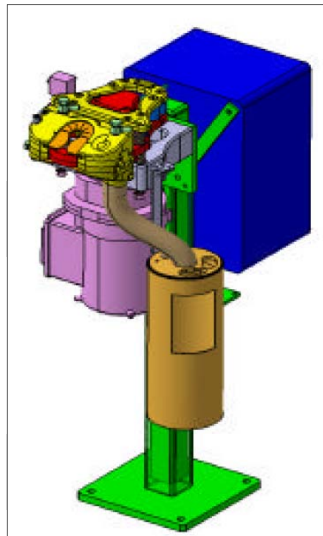
- 1 **milling base unit** with vertical height equalization
- 1 **proximity switch "rotation"** with connecting cable
- 1 **motor** (power: 0,75 kW) including terminal box and connecting cable
- 1 **electrical switch box (standard)** with double bit lock in RAL-colour 7035
- 1 **swarf lead system and swarf bag**
- 1 **solenoid valve (standard)** for swarf blow-out and connecting cable
- 1 **height-adjustable stand** without dowel

*Please specify RAL-colour when ordering, otherwise stand will be painted RAL-colour 9002.*

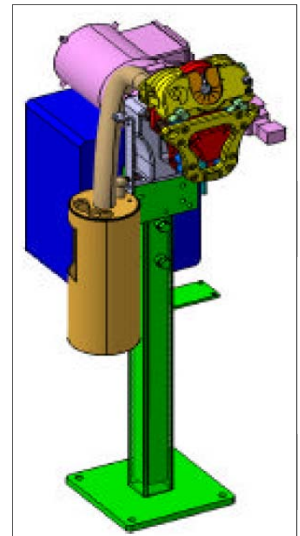
#### illustrations:



setup type H



setup type V1 (standard)



setup type V2

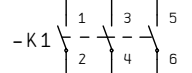
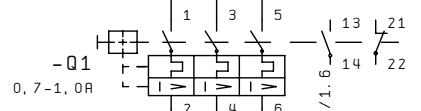
#### ordering example:

**F-3600.037.00A**

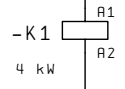
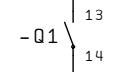
electrode tip dresser, setup type H  
stand in RAL-colour 9010

400V AC 3/PE 50Hz

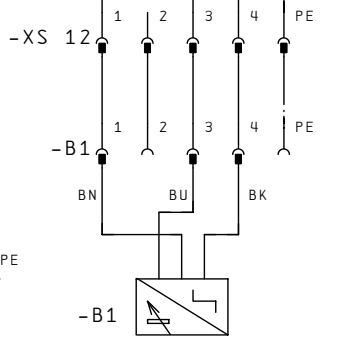
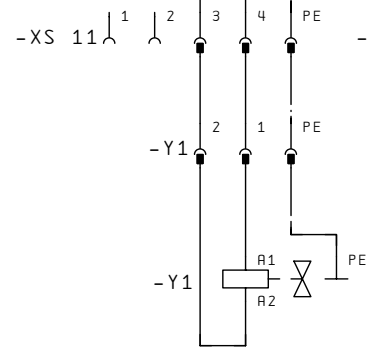
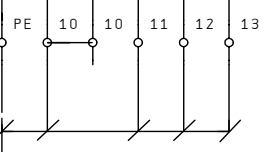
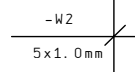
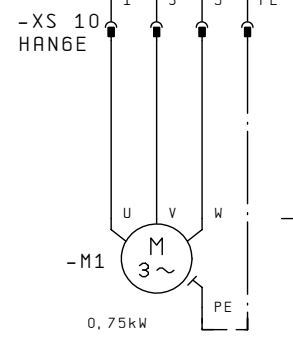
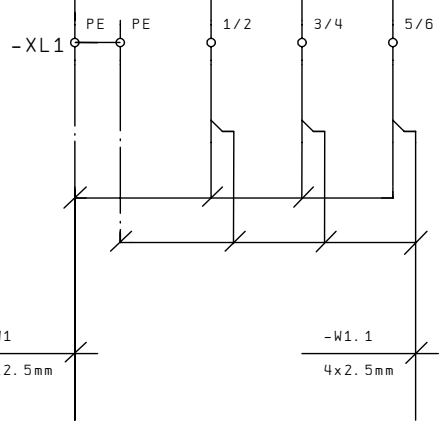
L1  
L2  
L3  
1L+  
1L-  
PE



24V DC



0V DC



EINSPEISUNG  
power supply

ZUM NÄCHSTEN FRÄSER  
to the next tip dresser


FRÄSERMOTOR  
drive

FRÄSER DREHT  
signal tip dresser turning  
START FRÄSEN  
start cutting

START FRÄSEN  
start cutting

AUSBLASVORRICHTUNG  
blow out

DREHIMPULSE  
rotary sensor  
detection

				Datum	25.07.05	Elektrodenkappen- fräser				Schweißtechnik Bräuer GmbH Gewerbestraße 4 09488 Thermalbad Wiesenbad / Schönfeld Tel: 03733/560110 Fax: 03733/560111		=	+	B1. 1		
				Bearb.	Rico Sander		Urspr.	Ers. f.	Ers. d.						NSB-3000-038.3	1 B1
				Gepr.	02.08.06											
Händerung	Datum	Name	Norm													



# Product Information Sheet

issued:  
01.01.2011

## electrode tip dresser for robot guns

product information:  
BFS-3610.037.00A

### electrode tip dresser BFS-3610.037.00A

Stationary electrode tip dresser support the welding process within a robot cell by reshaping the electrode cap after a certain amount of welding points.

These units can be ordered in setup H, V1 and V2. For setup type V2 an additional vertical angle needs to be added to your order.

The necessary milling heads need to be ordered separately. We will be glad to assist you in choosing one.

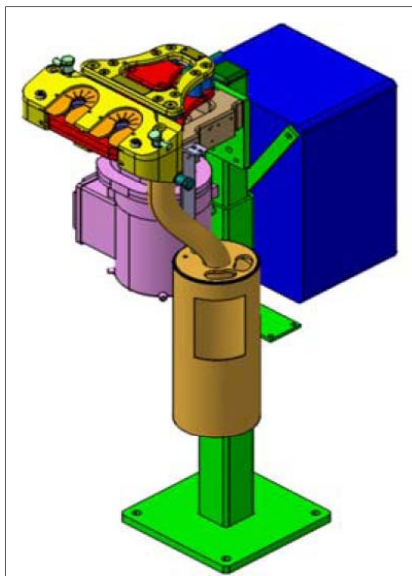
#### delivery scope:

The standard stationary electrode tip dresser BFS-3610.037.00A consists:

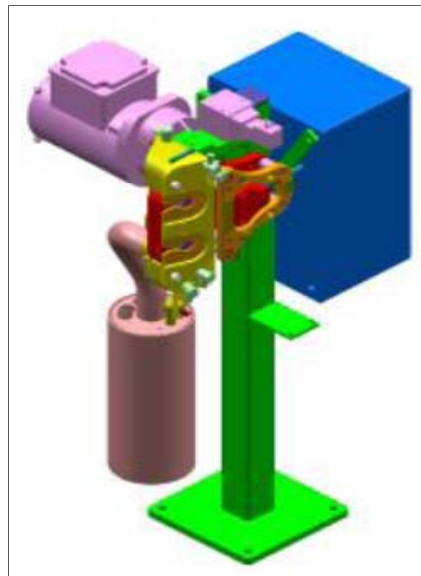
- 1 **milling base unit** with vertical height equalization
- 1 **proximity switch "rotation"** with connecting cable
- 1 **motor** (power: 0,75 kW) including terminal box and connecting cable
- 1 **electrical switch box (standard)** with double bit lock in RAL-colour 7035
- 1 **swarf lead system and swarf bag**
- 1 **solenoid valve (standard)** for swarf blow-out and connecting cable
- 1 **height-adjustable stand** without dowel

*Please specify RAL-colour when ordering, otherwise stand will be painted RAL-colour 9002.*

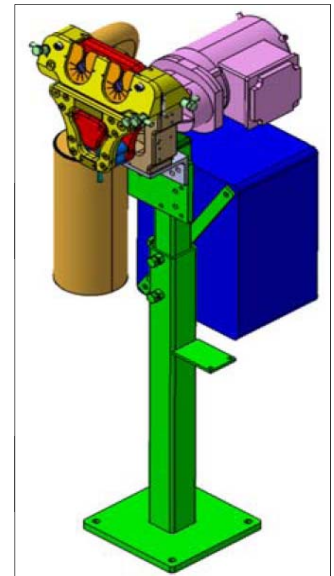
#### illustrations:



setup type H



setup type V1 (standard)



setup type V2

#### ordering example:

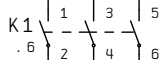
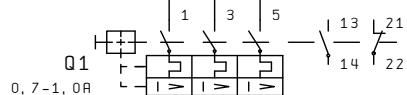
**F-3610.037.00A**

electrode tip dresser, setup type H / V1 / V2

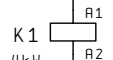
stand in RAL-colour 9010

400/480V AC 3/PE 50/60Hz

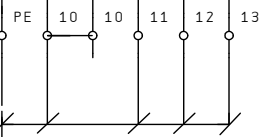
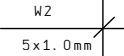
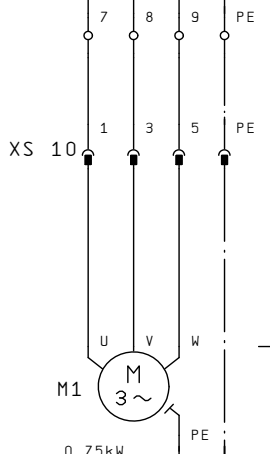
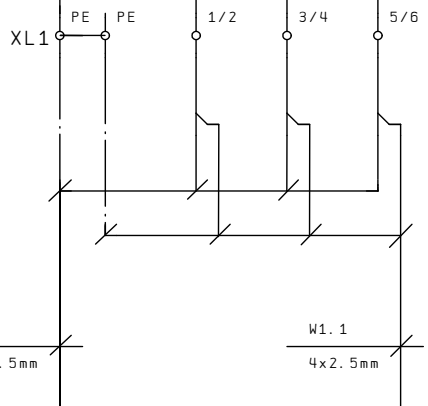
L1  
L2  
L3  
1L+  
1L-  
PE



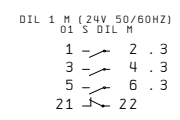
24V DC



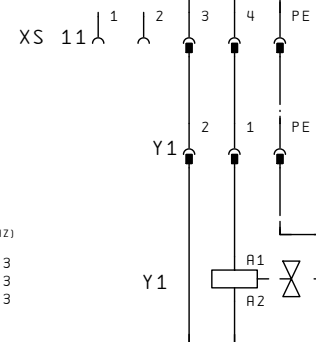
0V DC



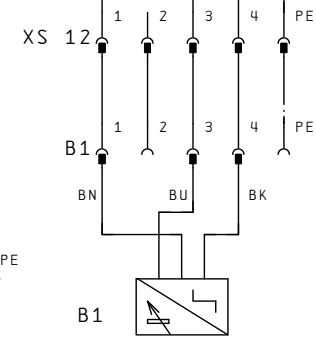
FRÄSER DREHT  
signal tip dresser turning  
START FRÄSEN  
start cutting



START FRÄSEN  
start cutting



AUSBLASVORRICHTUNG  
blow out



DREHIMPULSE  
rotary sensor detection

EINSPEISUNG  
power supply

ZUM NÄCHSTEN FRÄSER  
to the next tip dresser

FRÄSERMOTOR  
drive

				Datum	25.07.05	Elektrodenkappenfräser									
				Bearb.	Rico Sander	ABE 3600									
				Gepr.	10.11.10										
Händerung	Datum	Name	Norm	Urspr.	Ers. f.	Ers. d.	Schweißtechnik Bräuer GmbH								
							Gewerbestraße 4 09488 Thermalbad Wiesenbad / Schönfeld Tel: 03733/560110 Fax: 03733/560111			Bräuer		NSB-3000.038.3		B1. 1 1 B1	



system  
technik

# Technical Information

## electrode tip changer for robot welding guns

□ **single head**  
**BWS 5700.037.00A**

□ **double head**  
**BWS 5710.037.00A**





# Product Information Sheet

issued:  
01.01.2012

## electrode tip changer for robot guns

product information:  
BWS-5700.037.00A

### electrode tip changer BWS-5700.037.00A

Stationary electrode tip changer support the welding process within a robot cell by changing the electrode cap automated after a certain amount of welding points.

These units can be ordered in setup types H and V2. For setup type V2 an additional vertical angle needs to be added to your order.

The necessary changing heads are already included in the delivery scope. The cap magazine will have to be adapted to your used electrode caps. Please provide us with a technical data sheet on the used electrode caps.

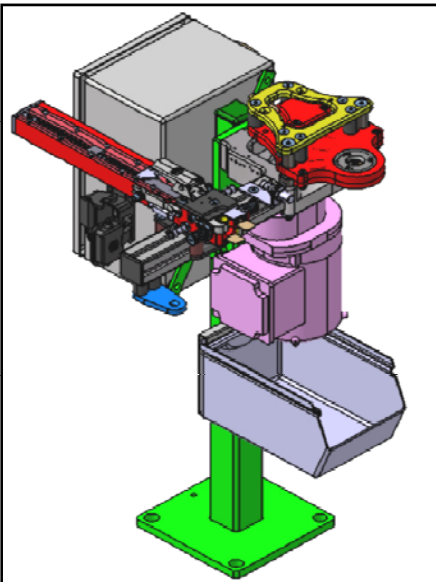
#### delivery scope:

The standard stationary electrode tip changer BWS-5700.037.00A consists of:

- 1 **base unit** with electrical drive
- 1 **electrical switch box (standard)** with double bit lock in RAL-colour 7035
- 1 **changing head**
- 1 **proximity switch** for cap control monitoring
- 1 **basic magazine body** with refillable changing magazine
- 1 **cap push-on plate** if required
- 1 **cap catching box**
- 1 **height-adjustable stand** without dowel

*Please specify RAL-colour when ordering, otherwise stand will be painted RAL-colour 9002.*

#### illustrations:



setup type H

*illustration not available*

setup type V2

#### ordering example:

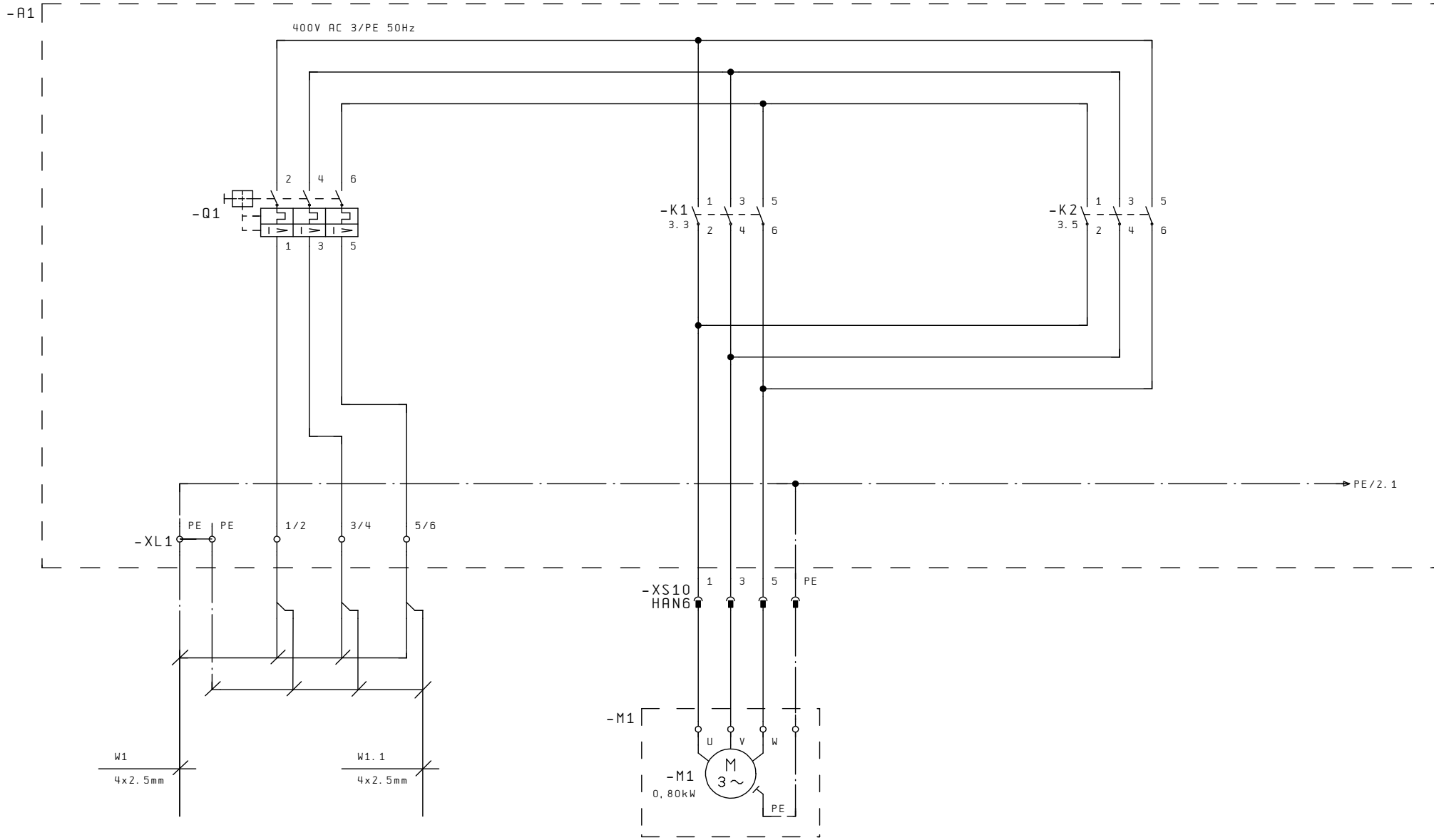
**BWS-5700.037.00A**

electrode tip changer, setup type H / V2

stand in RAL-colour 9010

Bräuer Systemtechnik GmbH  
Gewerbstraße 4  
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GERMANY

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fax: +49 3733 5601-11  
e-mail: [info@braeuersysteme.de](mailto:info@braeuersysteme.de)  
URL: [www.braeuersysteme.de](http://www.braeuersysteme.de)

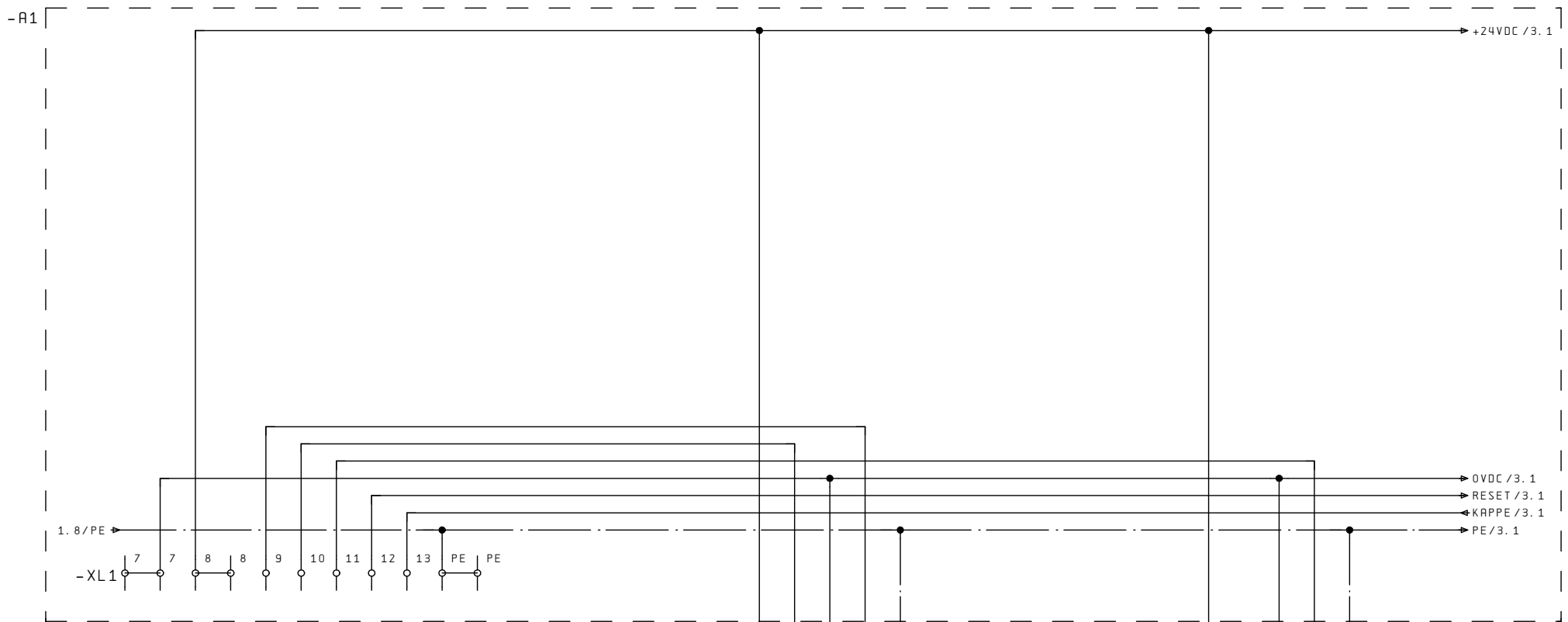


EINSPEISUNG  
power supply

ZUM NÄCHSTEN KAPPENWECHSLER  
to the next tip device

MOTOR  
electric motor

			Datum	14.03.11	KAPPENWECHSLER BKS 5700/5710...	Bräuer Systemtechnik GmbH Gewerbestraße 4 09488 Thermalbad Wiesenbad / Schönfeld Tel: 03733/560110 Fax: 03733/560111		NSB-5700-037.00	B1. 1 3 B1.
		Bearb.	SANDER						
		Gepr.	21.11.11						
Änderung	Datum	Name	Norm	Urspr.	Ers. f.	Ers. d.			

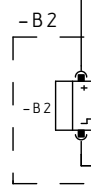


power supply control 24VDC

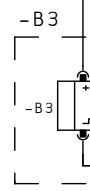
sensor 1 for caps level  
 sensor 2 for caps level  
 sensor caps control/  
 monitoring  
 reset counter  
 signal cap  
 relaxedly

-XS11

Y-KABEL

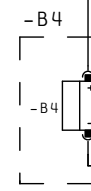


INITIATOR 1  
 FÜLLSTAND  
 MAGAZIN  
 sensor 1  
 for caps level



INITIATOR 2  
 FÜLLSTAND  
 MAGAZIN  
 sensor 2  
 for caps level

-XS12



INITIATOR  
 KAPPENKONTROLLE  
 sensor caps control  
 monitoring

0VDC

+24VDC

+24VDC /3. 1

0VDC /3. 1  
 RESET /3. 1  
 KAPPE /3. 1  
 PE /3. 1

1. 8 / PE

-XL1

7 7 8 8 9 10 11 12 13

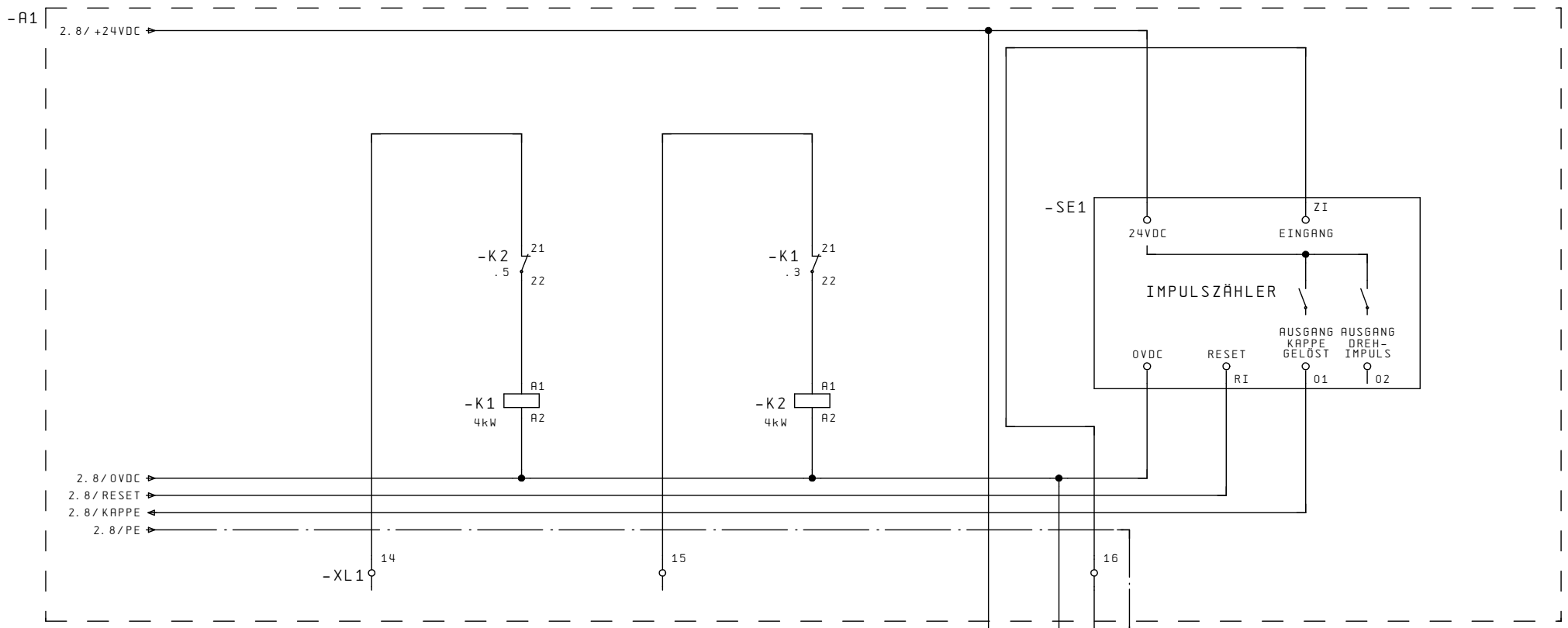
PE PE

1 2 3 4 PE

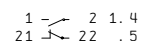
1 2 3 4 PE

Datum		14.03.11		KAPPENWECHSLER BKS 5700/5710...	Bräuer Systemtechnik GmbH Gewerbestraße 4 09488 Tharandt/Wiesbaden / Schönfeld Tel: 03733/560110 Fax: 03733/560111	=	+	B1. 2
Bearb.		SANDER						
Gepr.		21.11.11						
Änderung	Datum	Name	Norm	Urspr.	Ers. f.	Ers. d.	NSB-5700-037. 00	
							3 B1.	

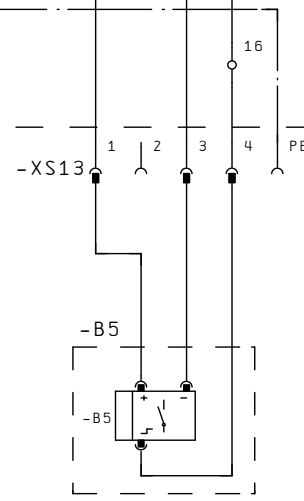
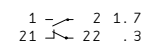




MOTOR RECHTSLAUF  
motor direction of rotation  
clockwise



MOTOR LINKSLAUF  
motor direction of rotation  
counterclockwise



INITIATOR  
ZAHNRADABFRAGE  
sensor  
gearwheel query

		Datum	14.03.11	KAPPENWECHSLER BKS 5700/5710...	Bräuer Systemtechnik GmbH Gewerbestraße 4 09488 Thermalbad Wiesenbad / Schönfeld Tel: 03733/560110 Fax: 03733/560111	=	+	B1. 3	
		Bearb.	SANDER						
		Gepr.	21.11.11						
Änderung	Datum	Name	Norm	Urspr.	Ers. f.	Ers. d.		NSB-5700-037.00	3 B1.



# Product Information Sheet

issued:  
01.01.2012

## electrode tip changer for robot guns

product information:  
BWS-5710.037.00A

### electrode tip changer BWS-5710.037.00A

Stationary electrode tip changer support the welding process within a robot cell by changing the electrode cap automated after a certain amount of welding points.

These units can be ordered in setup types H and V2. For setup type V2 an additional vertical angle needs to be added to your order.

The necessary changing heads are already included in the delivery scope. The cap magazine will have to be adapted to your used electrode caps. Please provide us with a technical data sheet on the used electrode caps.

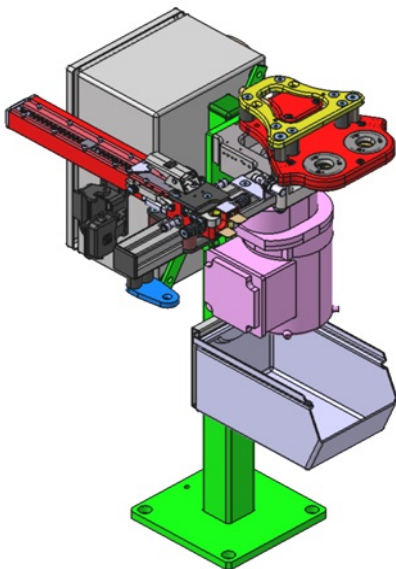
#### delivery scope:

The standard stationary electrode tip changer BWS-5710.037.00A consists of:

- 1 **base unit** with electrical drive
- 1 **electrical switch box (standard)** with double bit lock in RAL-colour 7035
- 2 **changing heads**
- 1 **proximity switch** for cap control monitoring
- 1 **basic magazine body** with refillable changing magazine
- 1 **cap push-on plate** if required
- 1 **cap catching box**
- 1 **height-adjustable stand** without dowel

*Please specify RAL-colour when ordering, otherwise stand will be painted RAL-colour 9002.*

#### illustrations:



*illustration not available*

setup type H

setup type V2

#### ordering example:

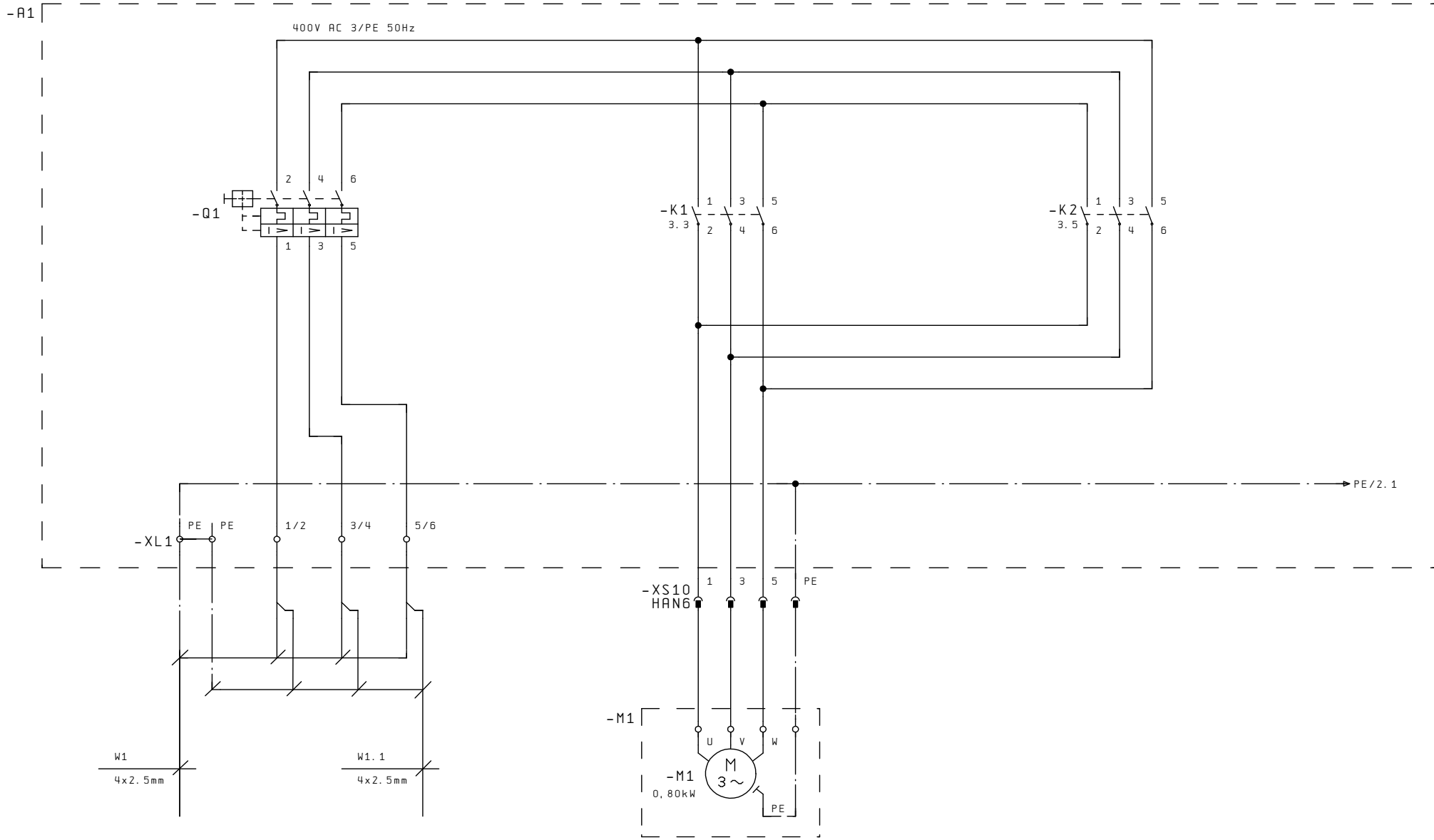
**BWS-5710.037.00A**

electrode tip changer, setup type H / V2

stand in RAL-colour 9010

Bräuer Systemtechnik GmbH  
Gewerbstraße 4  
09488 Thermalbad Wiesenbad / OT Schönfeld  
GERMANY

phone: +49 3733 5601-10  
fax: +49 3733 5601-11  
e-mail: [info@braeuersysteme.de](mailto:info@braeuersysteme.de)  
URL: [www.braeuersysteme.de](http://www.braeuersysteme.de)

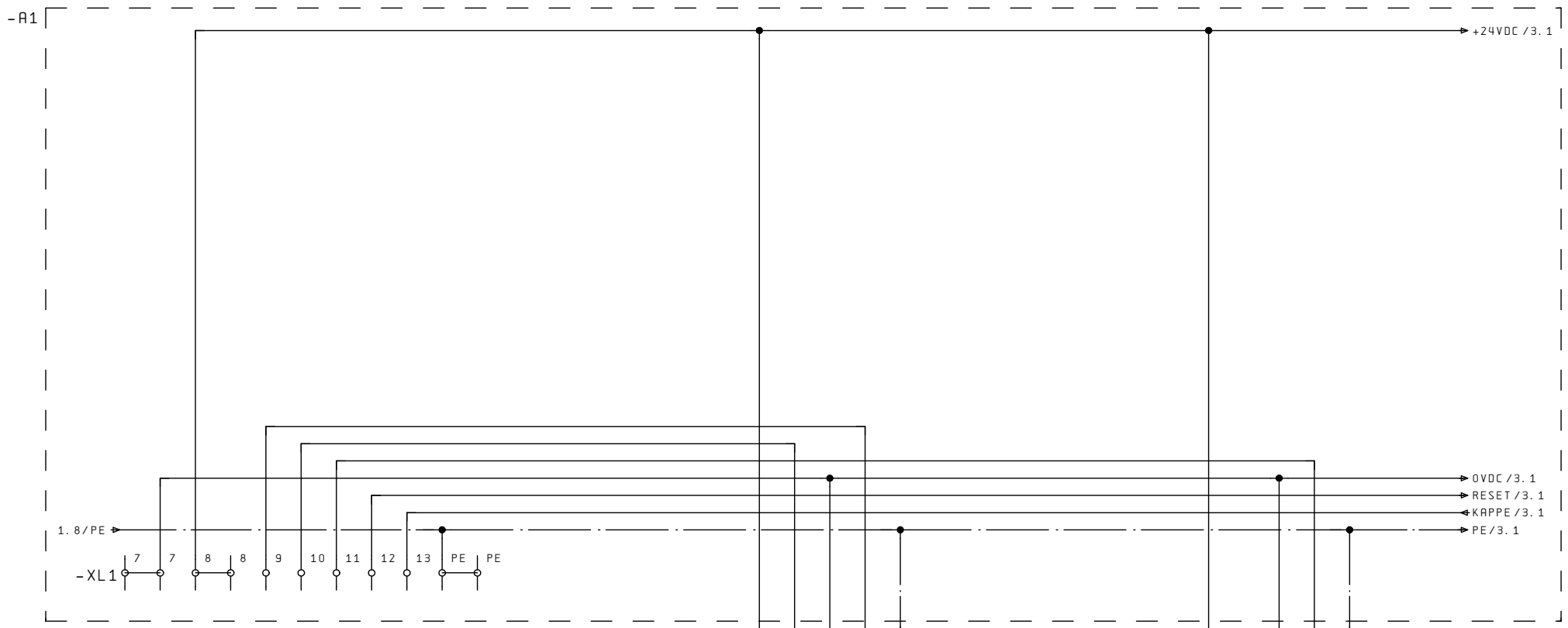


EINSPEISUNG  
power supply

ZUM NÄCHSTEN KAPPENWECHSLER  
to the next tip device

MOTOR  
electric motor

			Datum	14.03.11	KAPPENWECHSLER BKS 5700/5710...	Bräuer Systemtechnik GmbH Gewerbestraße 4 09488 Thermalbad Wiesenbad / Schönfeld Tel: 03733/560110 Fax: 03733/560111		NSB-5700-037.00	B1. 1 3 B1.
		Bearb.	SANDER						
		Gepr.	21.11.11						
Änderung	Datum	Name	Norm	Urspr.	Ers. f.	Ers. d.			



0VDC

+24VDC

power supply control 24VDC

INITIATOR 1  
FÜLLSTAND MAGAZIN  
INITIATOR 2  
FÜLLSTAND MAGAZIN  
INITIATOR  
KAPPENKONTROLLE  
RESET  
IMPULSZÄHLER  
SIGNAL  
KAPPE GELÖST

sensor 1 for caps level  
sensor 2 for caps level  
sensor caps control/  
monitoring  
reset counter  
signal cap  
relaxedly

-XS11

Y-KABEL

-B2

-B3

-B4

INITIATOR 1  
FÜLLSTAND  
MAGAZIN  
sensor 1  
for caps level

INITIATOR 2  
FÜLLSTAND  
MAGAZIN  
sensor 2  
for caps level

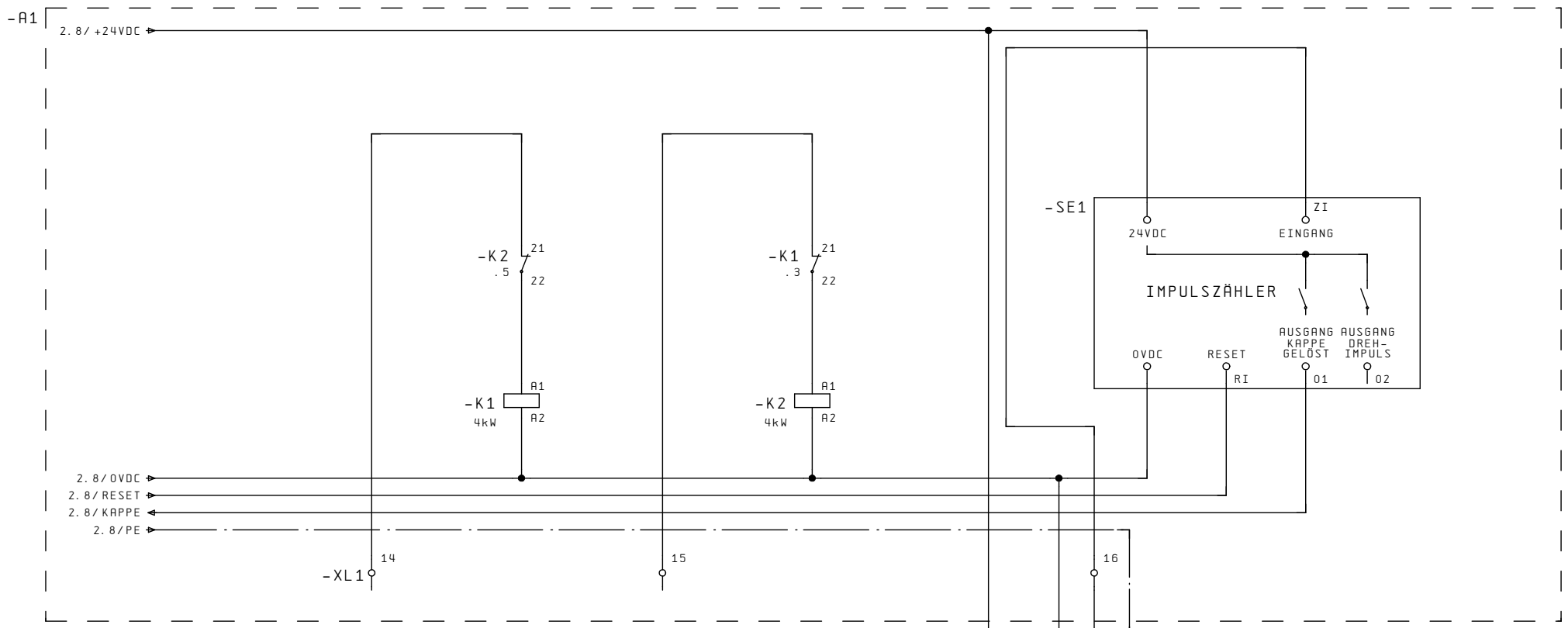
INITIATOR  
KAPPENKONTROLLE  
sensor caps control  
monitoring

Datum		14.03.11		KAPPENWECHSLER BKS 5700/5710...		Bräuer Systemtechnik GmbH Gewerbestraße 4 09488 Tharandbad Wiesenbad / Schönfeld Tel: 03733/560110 Fax: 03733/560111		=		+ 3 B1	
Bearb.		SANDER									
Gepr.		21.11.11									
Änderung		Datum		Name		Norm		Urspr.		Ers. f.	

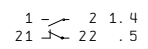


NSB-5700-037.00

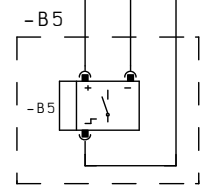
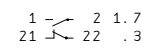
B1. 2  
3 B1



MOTOR RECHTSLAUF  
motor direction of rotation  
clockwise



MOTOR LINKSLAUF  
motor direction of rotation  
counterclockwise



		Datum	14.03.11	KAPPENWECHSLER BKS 5700/5710...	Bräuer Systemtechnik GmbH Gewerbestraße 4 09488 Thermalbad Wiesenbad / Schönfeld Tel: 03733/560110 Fax: 03733/560111	=	+	B1. 3	
		Bearb.	SANDER						
		Gepr.	21.11.11						
Änderung	Datum	Name	Norm	Urspr.	Ers. f.	Ers. d.		NSB-5700-037.00	3 B1.





system  
technik

# Technical Information

## combi units

(combined electrode tip dresser/changer)

**double head**  
**BKS 5810.037.00A**

**triple head**  
**BKS 5820.037.00A**



# Product Information Sheet

issued:  
01.01.2012

## combi units for robot welding guns

product information:  
BKS-5810.037.00A

### combi unit BKS-5810.037.00A

Stationary combi units support the welding process within a robot cell by milling the shape of the electrode cap after a certain amount of welding spots and changing this electrode cap after worn.

These unit can be ordered in setup type H and V2. For setup type V2 an additional vertical angle needs to be added to your order.

The necessary changing heads are already included in the delivery scope. The cap magazine will have to be adapted to your used electrode caps. Please provide us with a technical data sheet on the used electrode caps.

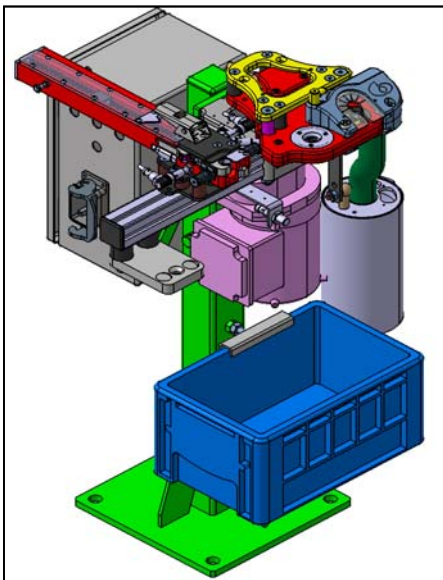
#### delivery scope:

The stationary combi unit BKS-5810.037.00A consists of:

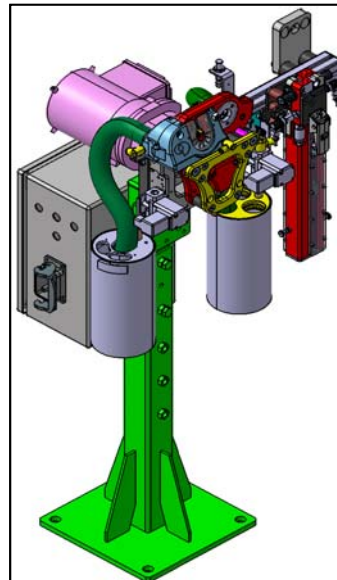
- 1 **basic unit** with electric drive
- 1 **electrical switch box (standard)** with double bit lock in RAL-colour 7035
- 1 **changing head**
- 1 **proximity switch** for cap control monitoring
- 1 **magazine basic body** with refillable changing magazine
- 1 **cap push-on plate** if required
- 1 **cap collection box**
- 1 **height-adjustable stand** without dowels

*Please specify your RAL-colour when ordering, otherwise stand will be painted in RAL 9002.*

#### illustrations:



setup type H



setup type V2

#### ordering example:

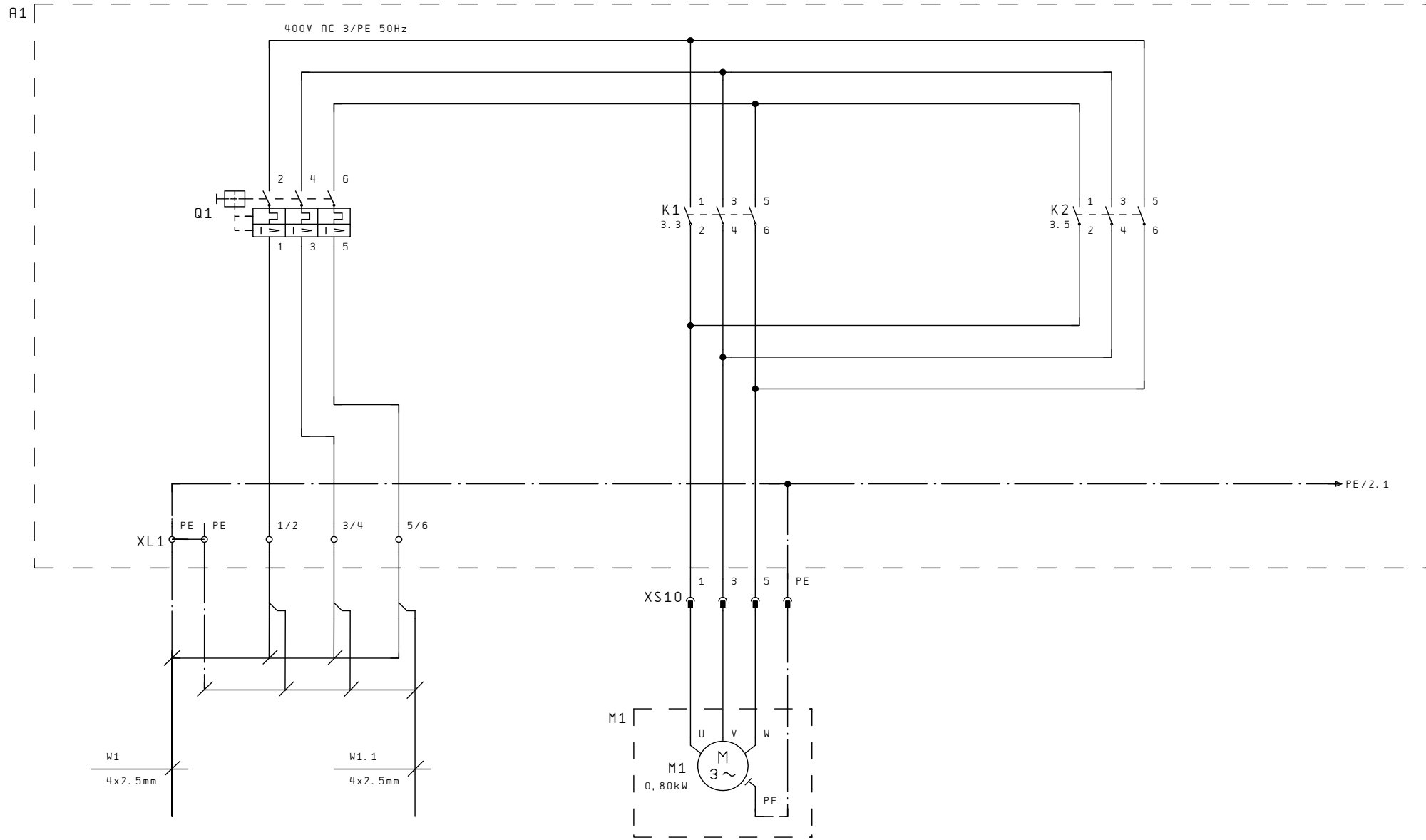
**BKS-5810.037.00A**

combi unit (electroden tip dresser & changer), setup type H / V2

stand in RAL-colour 9010

Bräuer Systemtechnik GmbH  
Gewerbestraße 4  
09488 Thermalbad Wiesenbad / OT Schönfeld  
GERMANY

phone: +49 3733 5601-10  
fax\_ +49 3733 5601-11  
e-mail: info@braeuersysteme.de  
URL: www.braeuersysteme.de

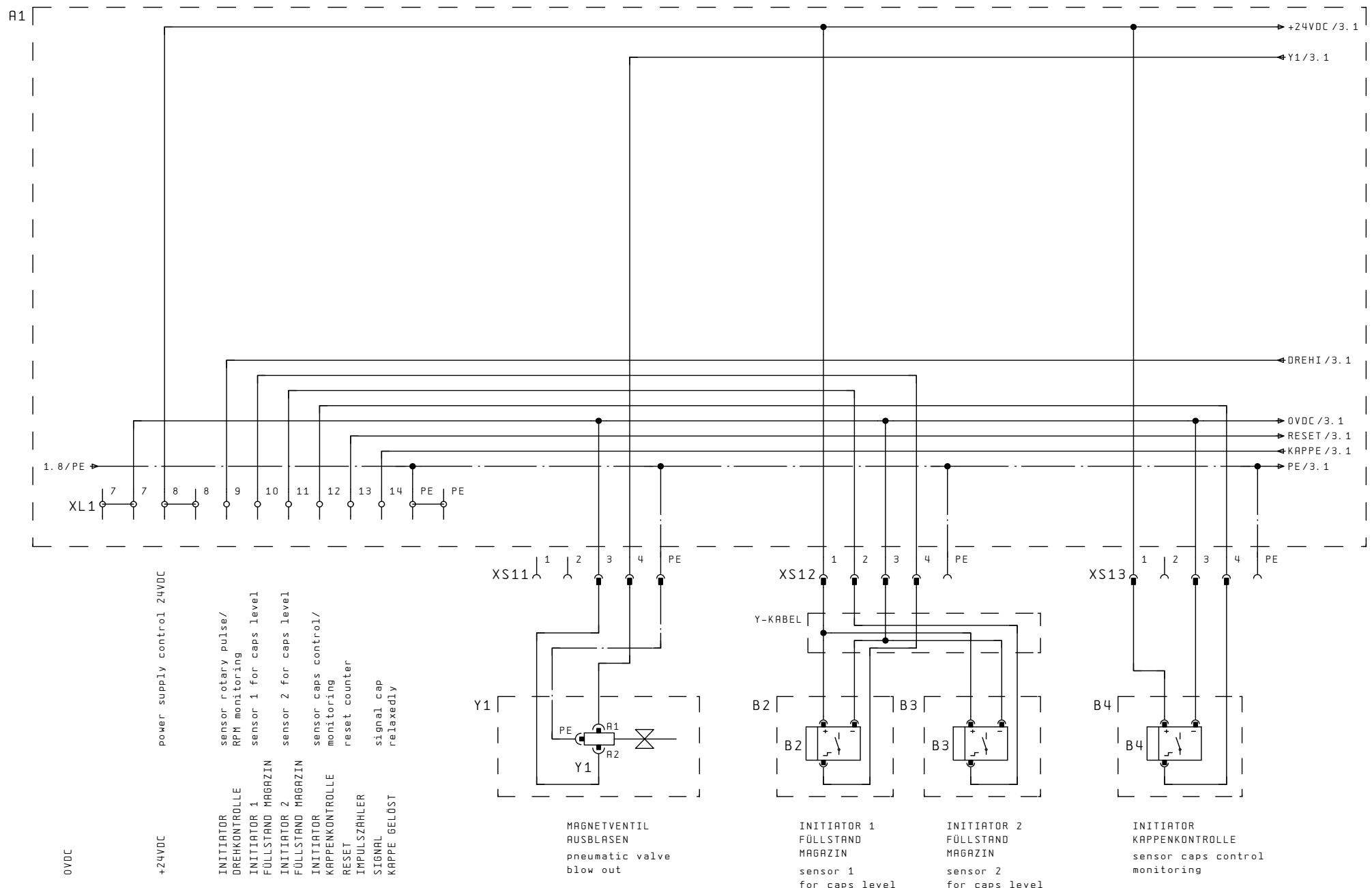


EINSPEISUNG  
power supply

ZUM NÄCHSTEN KAPPENWECHSLER  
to the next tip device

MOTOR  
electric motor

				Datum	16.06.10	KAPPENWECHSLER		Schweißtechnik Bräuer GmbH			
				Bearb.	Sander	BKS 5810...		Gewerbestraße 4			
				Gepr.	11.02.11			09488 Thermalbad Wiesenbad / Schönfeld			
								Tel: 03733/560110			
								Fax: 03733/560111			
Händerung	Datum	Name	Norm	Urspr.	Ers. f.	Ers. d.	Bräuer		NSB-5810-037.10		B1. 1
											3 B1.



			Datum	16.06.10	KAPPENWECHSLER BKS 5810...	Schweißtechnik Bräuer GmbH Gewerbestraße 4 09488 Thermalbad Wiesenbad / Schönfeld Tel: 03733/560110 Fax: 03733/560111	Bräuer	=	+	B1. 2
		Bearb.	Sander							
		Gepr.	11.02.11							
Änderung	Datum	Name	Norm	Urspr.	Ers. f.	Ers. d.				3 B1.





# Product Information Sheet

issued:  
01.01.2012

## combi units for robot welding guns

product information:  
BKS-5820.037.00A

### combi unit BKS-5820.037.00A

Stationary combi units support the welding process within a robot cell by milling the shape of the electrode cap after a certain amount of welding spots and changing this electrode cap after worn.

These unit can be ordered in setup type H and V2. For setup type V2 an additional vertical angle needs to be added to your order.

The necessary changing heads are already included in the delivery scope. The cap magazine will have to be adapted to your used electrode caps. Please provide us with a technical data sheet on the used electrode caps.

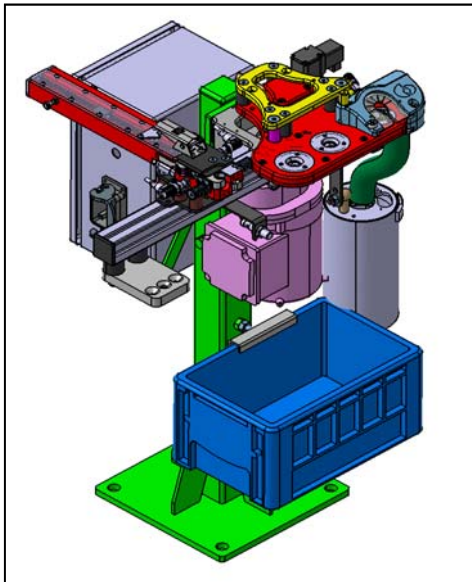
#### delivery scope:

The stationary combi unit BKS-5820.037.00A consists of:

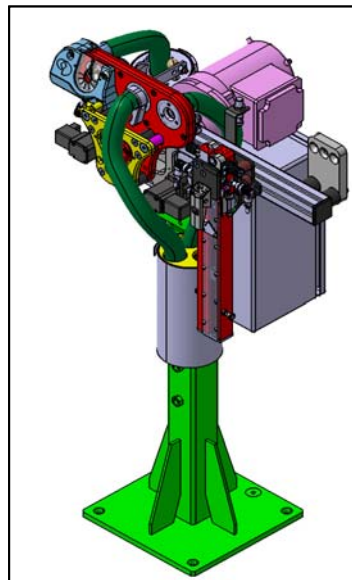
- 1 **basic unit** with electric drive
- 1 **electrical switch box (standard)** with double bit lock in RAL-colour 7035
- 2 **changing heads**
- 1 **proximity switch** for cap control monitoring
- 1 **magazine basic body** with refillable changing magazine
- 1 **cap push-on plate** if required
- 1 **cap collection box**
- 1 **height-adjustable stand** without dowels

*Please specify your RAL-colour when ordering, otherwise stand will be painted in RAL 9002.*

#### illustrations:



setup type H



setup type V2

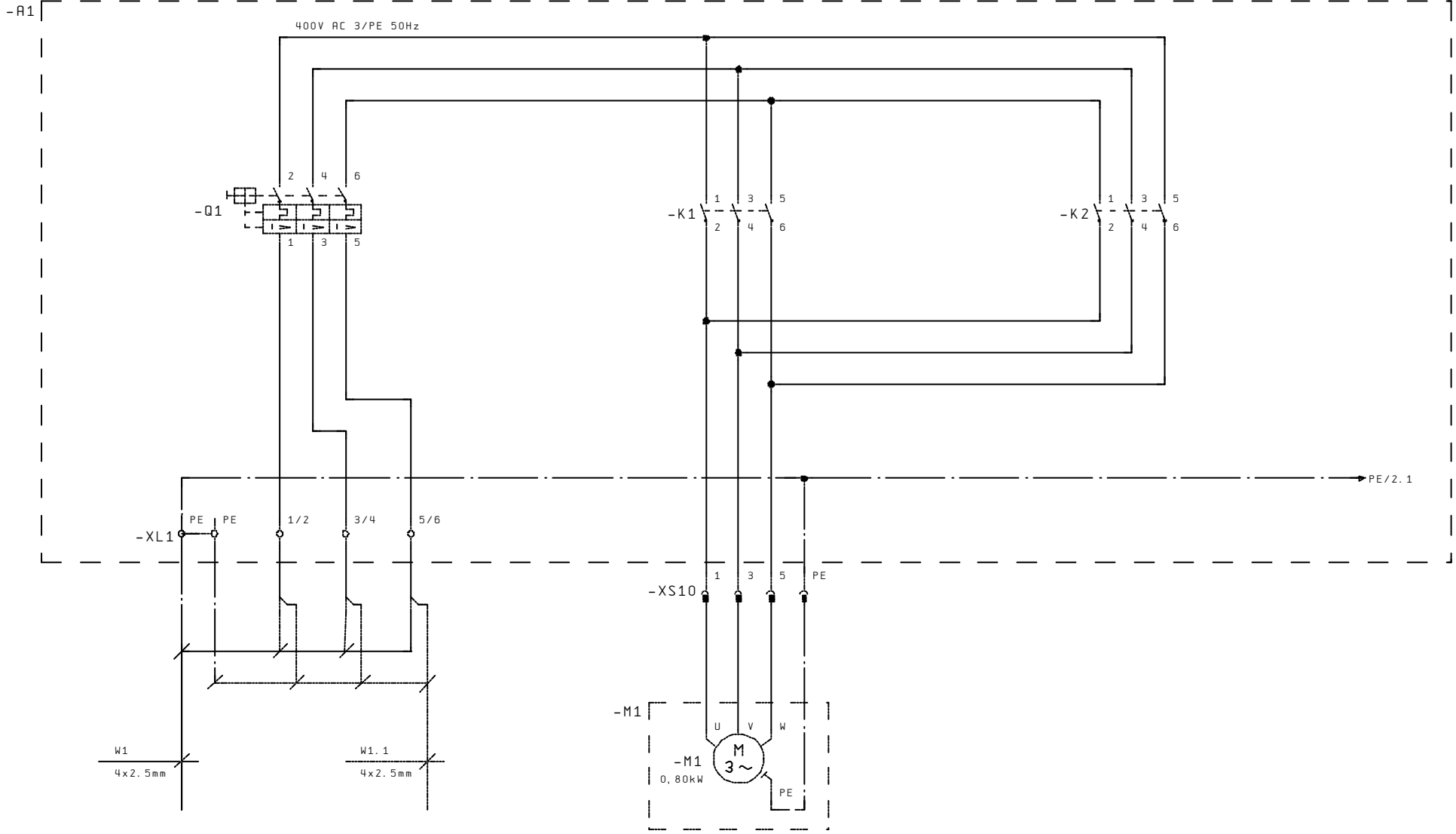
#### ordering example:

**BKS-5820.037.00A**

combi unit (electroden tip dresser & changer), setup type H / V2  
stand in RAL-colour 9010

Bräuer Systemtechnik GmbH  
Gewerbestraße 4  
09488 Thermalbad Wiesenbad / OT Schönfeld  
GERMANY

phone: +49 3733 5601-10  
fax\_ +49 3733 5601-11  
e-mail: info@braeuersysteme.de  
URL: www.braeuersysteme.de



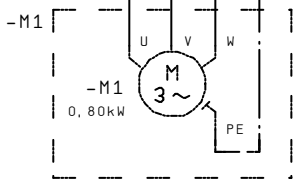
EINSPEISUNG  
power supply

ZUM NÄCHSTEN KAPPENWECHSLER  
to the next tip device

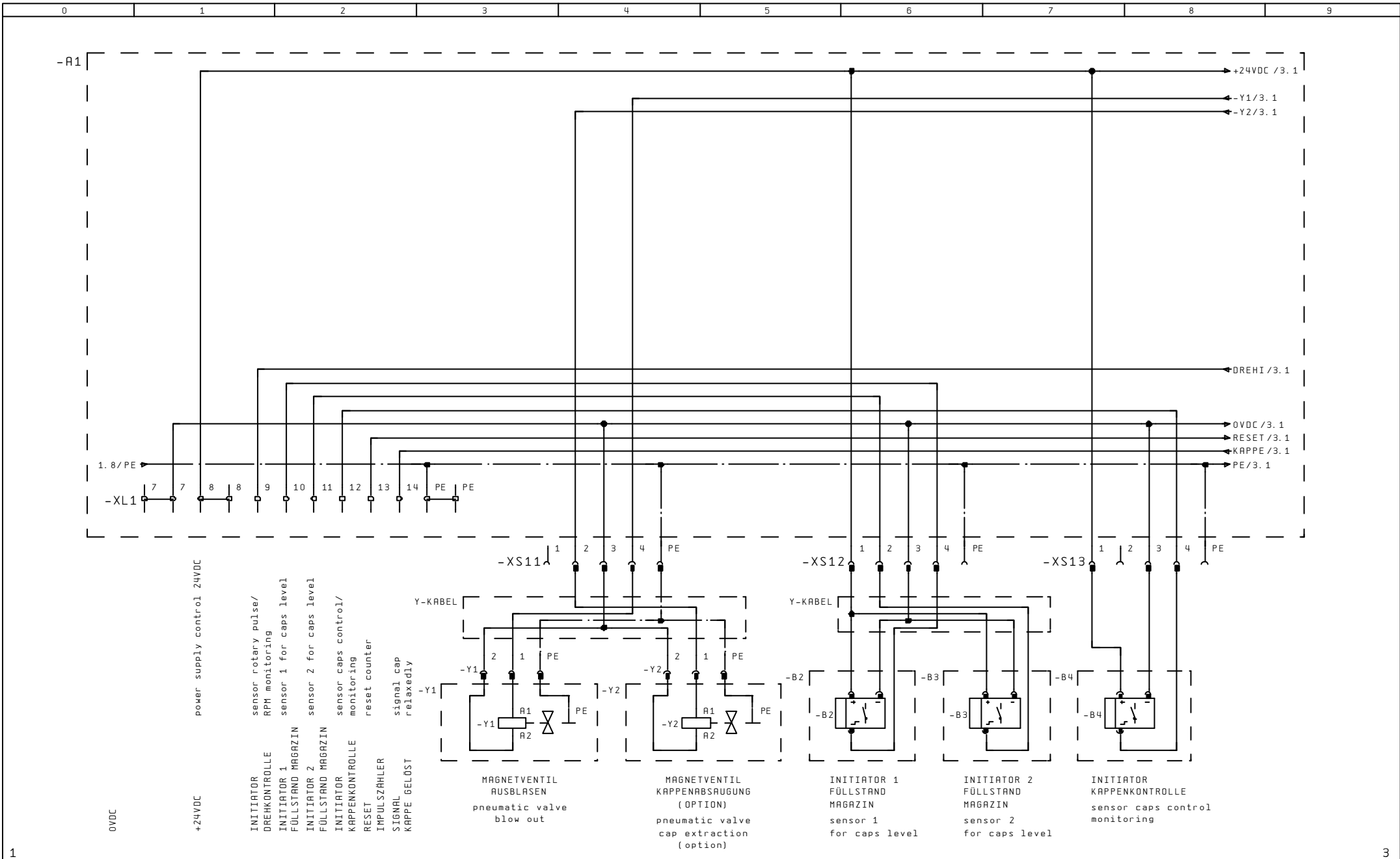
MOTOR  
electric motor

W1  
4x2.5mm

W1.1  
4x2.5mm

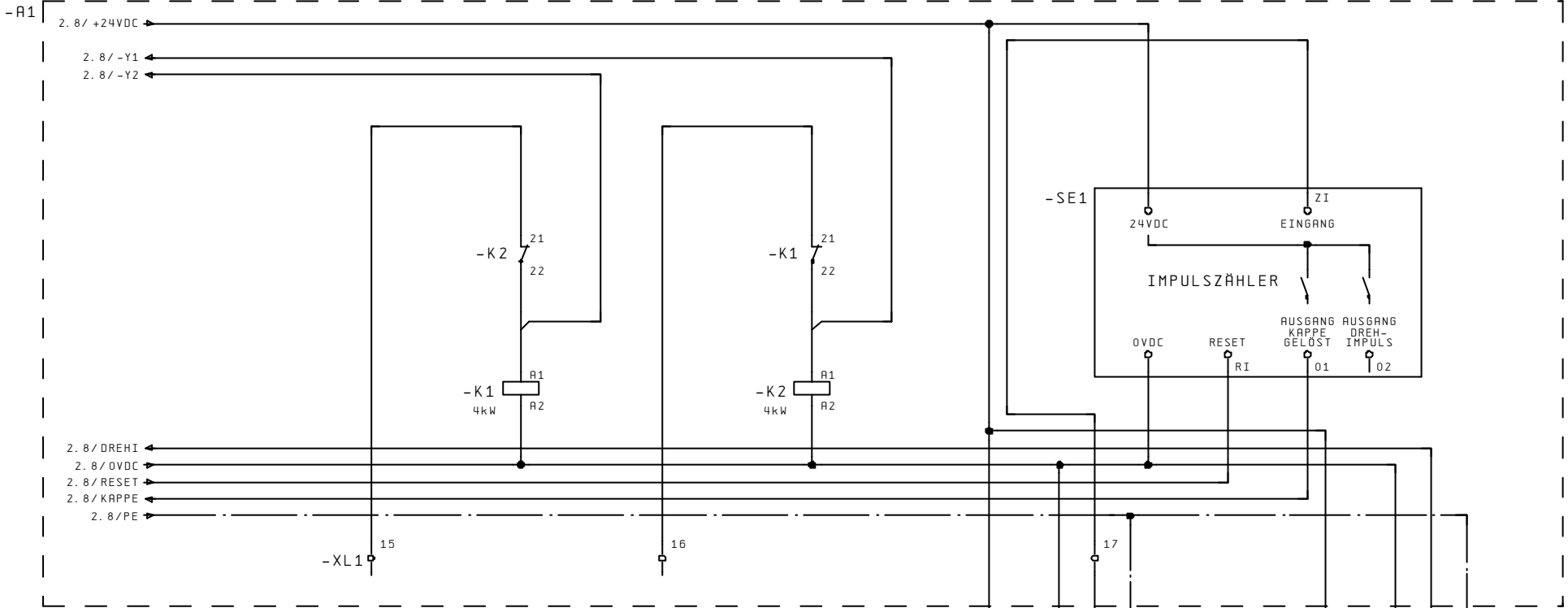


Datum		16.06.10		KAPPENWECHSLER		Schweißtechnik Bräuer GmbH		=	
Bearb.		SANDER		BKS 5820...		Gewerbstraße 4		+	
Gepr.		11.05.11				09488 Thernthalbad Wiesenbad / Schönfeld			
Anderung		Datum		Name		Norm		Bl. 1	
								3 Bl.	
Urspr.		Ers. f.		Ers. d.		NSB-5820-037.10			
						Bräuer			
						Tel: 03733/560110			
						Fax: 03733/560111			



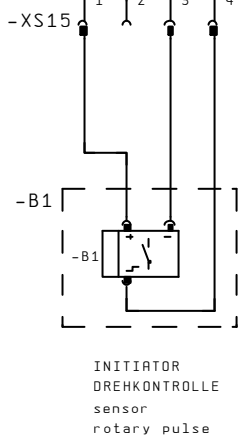
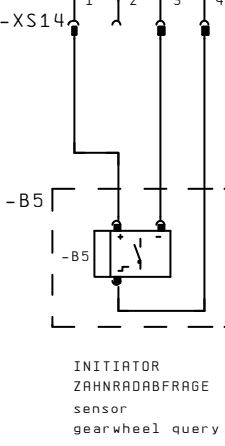
1		3	
Datum	16.06.10	Schweißtechnik Bräuer GmbH	
Bearb.	SANDER	Gewerbstraße 4 09488 Thersfelde Wiesenbad / Schönfeld Tel: 03733/560110 Fax: 03733/560111	
Gepr.	11.05.11	Bräuer	
KAPPENWECHSLER BKS 5820...		NSB-5820-037.10	
Änderung	Datum	Name	Bl. 2
			3 Bl.






MOTOR RECHTSLAUF  
motor direction of rotation  
clockwise

MOTOR LINKSLAUF  
motor direction of rotation  
counterclockwise



Datum 16.06.10				KAPPENWECHSLER BKS 5820...		Schweißtechnik Bräuer GmbH					
Bearb. SANDER						Gewerbestraße 4					
Gepr. 11.05.11						09488 Thernheibad Wiesenbad / Schönfeld					
Änderung		Datum		Name		Norm		Urspr.		Ers.f.	
								Ers.d.			
Tel: 03733/560110 Fax: 03733/560111											
									Bl. 3		
									3 Bl.		



system  
technik

# Technical Information

## swivelling systems

 **pneumatically driven**  
**FS 1000.37000**

 **electrically driven**  
**FS 1600.37000**



# Product Information Sheet

issued:  
01.01.2012

## complete swivelling system

product information:  
FS-1000.37000

### swivelling system FS-1000.37000

Swivelling systems are used for pedestal welding guns where stationary tip dressers cannot be applied. These swivelling systems can be ordered as electrically or pneumatically driven units.

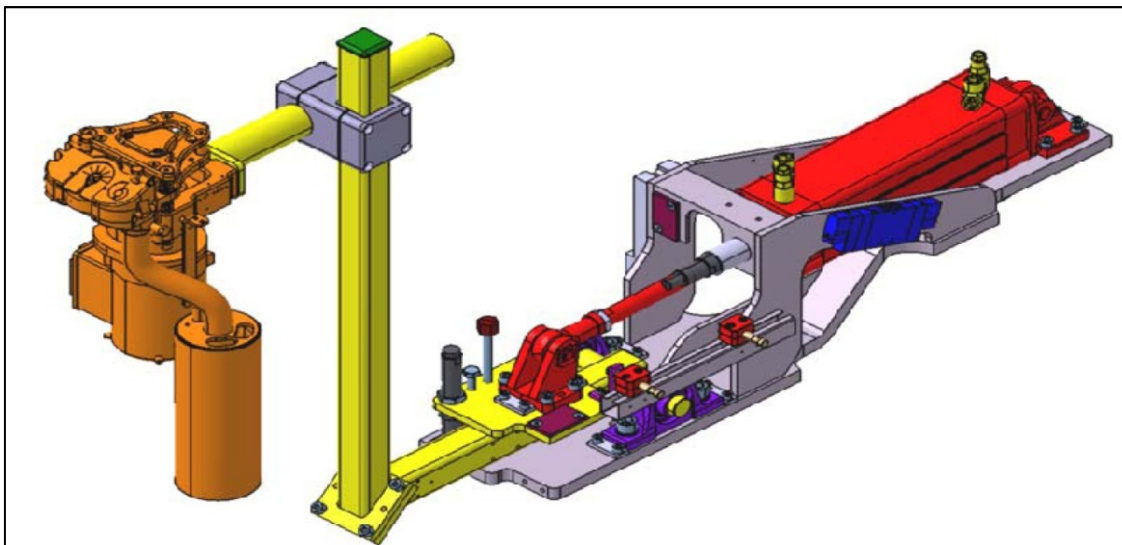
The swivelling electrode tip dresser is supplied on a basic mounted swing-in unit. According to our longtime experience the basic mounted swing-in unit consists of basic component groups. Depending on the project further components can be added accordingly.

#### delivery scope:

The basic mounting of the swivelling system **FS-1000.37000** includes:

- **swign-in unit F-1000.037.00** with standard cylinder (size:100x250mm), split swivelling arm as well as 2 proximity switches "end position monitoring" and 2 shock absorbers for end position
- **1 cross-clamp for the radial arm**
- **1 radial arm** (length: 400mm)
- **electrode tip dresser (type: BF-3600.037.500)** which also includes a swarf blow-out system, standard solenoid valve for swarf blow-out and a proximity switch "rotation monitoring"  
*Please note that the milling head needs to be ordered separately!*
- **1 standard 5/3-distributing valve, 2 throttle valves and 2 throttle check valves** for the triggering of the cylinder of the swivelling system including hosing  
*Please see the pneumatic plan 1000-037.00 for further information!*
- **standard electrical switch box containing of all connecting cables to the swing-in unit respectively the electrode tip dresser**  
*Please see wiring diagramm NSB-1000-037.00 for further technical details! Note that the cable package is approximately 2m long, electrical switch box needs to be mounted at a proper place by customer.*

#### illustrations:



Schwenksystem in Fräsposition



# Product Information Sheet

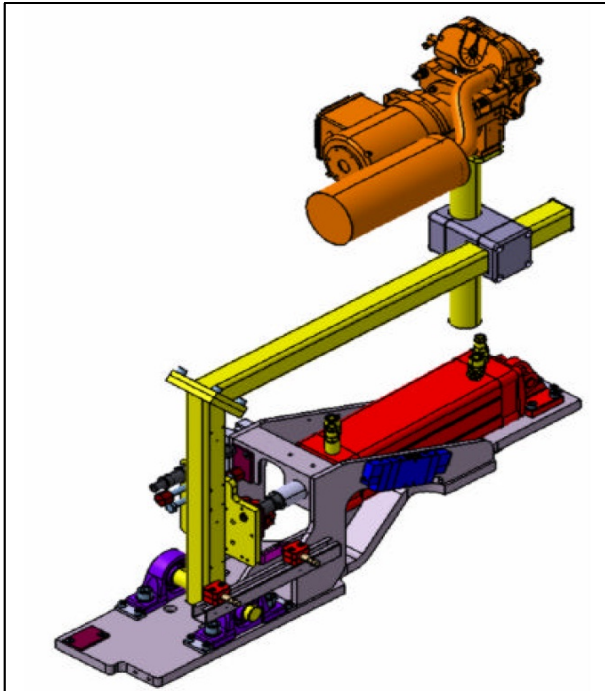
issued:  
01.01.2012

## complete swivelling system

product information:  
FS-1000.37000

### swivelling system FS-1000.37000

#### illustrations:



*Schwenksystem in Ruheposition*

#### ordering example:

**FS-1600.37000**

swivelling system 1600.37000

(basic plate RAL 9002 / swivelling arm RAL 2000)

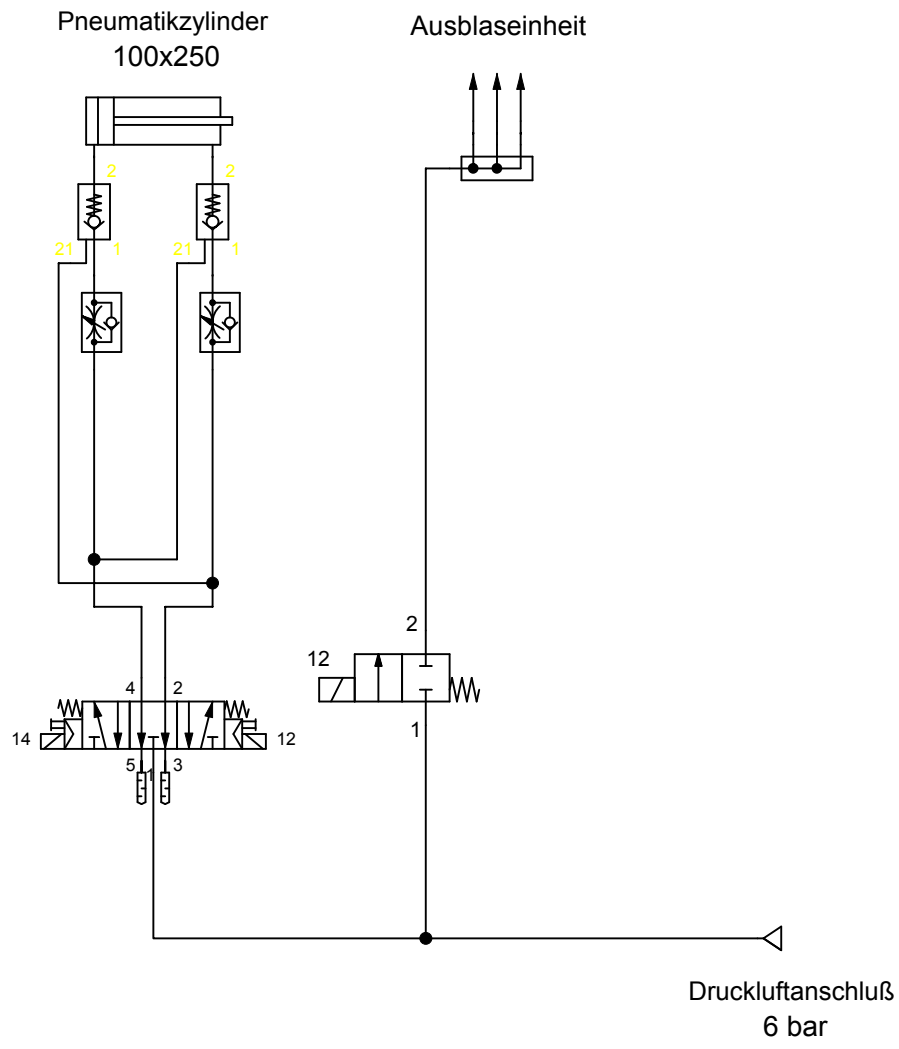
#### note:

*Please state the RAL-colours of the moving and fixed parts when ordering!*

#### **Caution!**

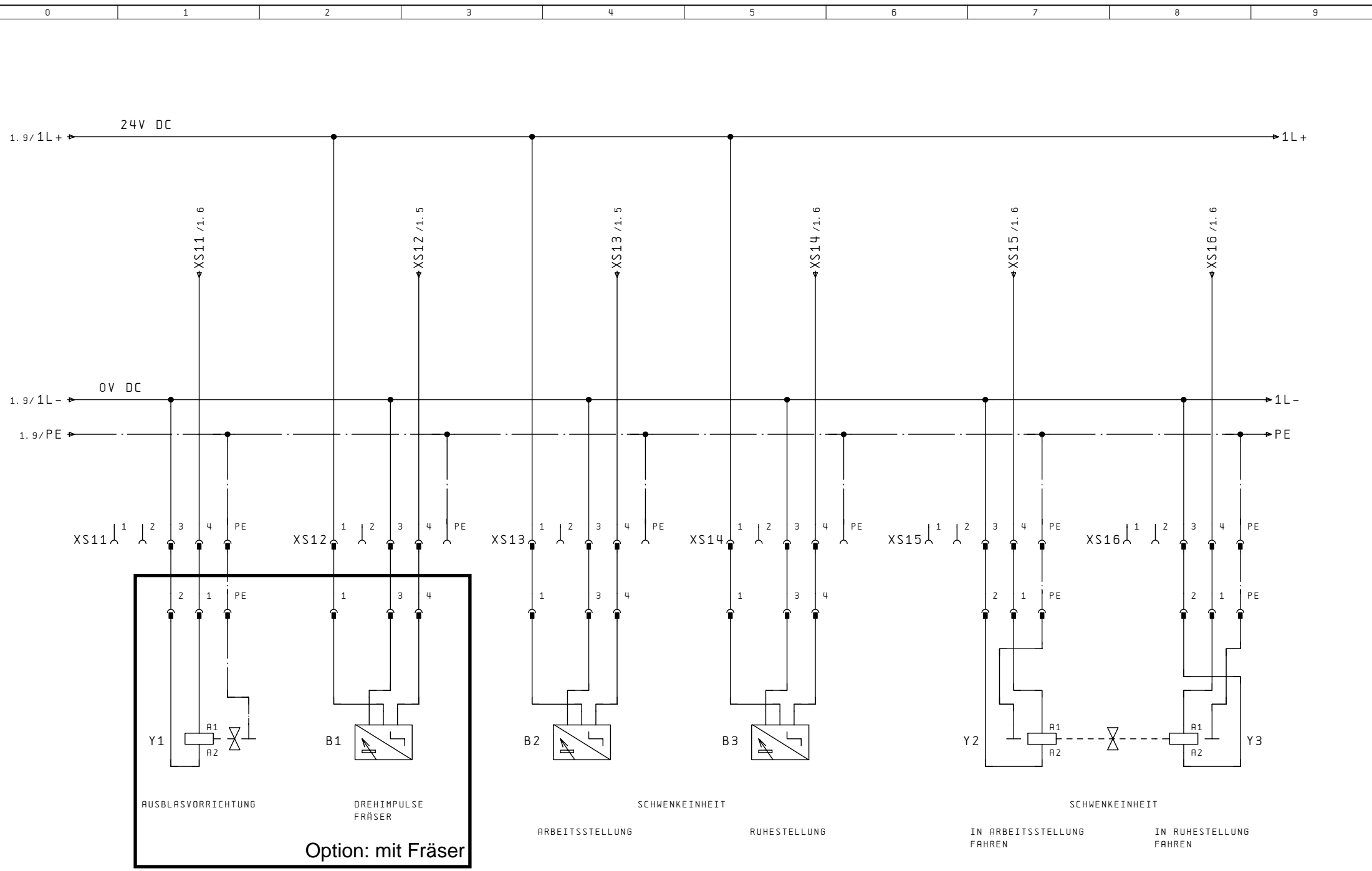
**These swivelling systems can only be used for setup types in which the electrode tip dresser will not leave its position due to its own weight when remaining in the electrode tip dressers's resting position.**

**Please see the pneumatic plan and wiring diagram on the following pages.**



	Aenderung	Datum	Name		Datum	Name	Benennung <b>Schwenkeinheit- ohne Abstecker</b> <b>swing in unit without peggin unit</b> <b>Standard</b>	Zeichnungs-Nr. <b>1000.037.00</b>	Anlage	Blatt Nr. 1 von 1 Blatt	Bräuer Schweißtechnik GmbH
a				gez.	17.04.07	Schneider					
b											
c				gepr.							
d											





Option: mit Fräser

1

			Datum	12.06.06	Schwenkeinheit ABE 1000		Schweißtechnik Bräuer GmbH		
			Bearb.	Rico Sander			Gewerbstraße 4 09488 Thermalbad Wiesenbad / Schönfeld Tel: 03733/560110 Fax: 03733/560111		
			Gepr.	25.04.07					
Änderung	Datum	Name	Norm	Urspr.	Ers. f.	Ers. d.			
							Bräuer	NSB-1000-00.00	B1. 2 Z B1. 2



# Product Information Sheet

issued:  
01.01.2012

## complete swivelling system

product information:  
FS-1600.37000

### swivelling system FS-1600.37000

Swivelling systems are used for pedestal welding guns where stationary tip dressers cannot be applied. These swivelling systems can be ordered as electrically or pneumatically driven units.

The swivelling electrode tip dresser is supplied on a basic mounted swing-in unit. According to our longtime experience the basic mounted swing-in unit consists of basic component groups. Depending on the project further components can be added accordingly.

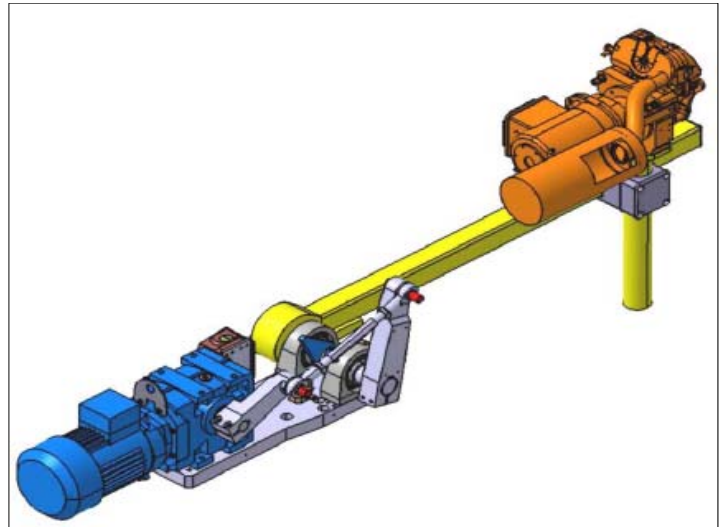
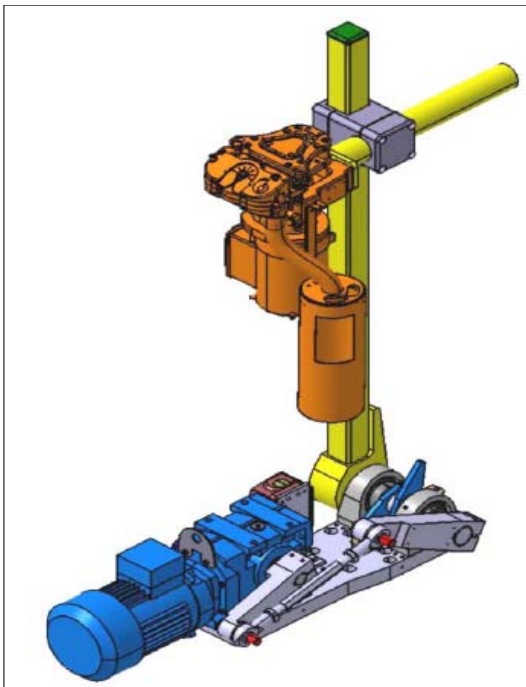
#### delivery scope:

The basic mounting of the swivelling system **F-1600.37000** includes:

- swing-in unit **F-1600.037.00** consisting of 2 proximity switches for end position check, 2 cams and a range position switch for end position switch-off
- 1 cross-clamp for the radial arm
- 1 radial arm (length: 400mm)
- electrode tip dresser (type: **BF-3600.037.400**) which also includes a swarf blow-out system, standard solenoid valve for swarf blow-out and a proximity switch "rotation monitoring"  
*Please note that the milling head needs to be ordered separately!*
- standard electrical switch box containing of all connecting cables to the swing-in unit respectively the electrode tip dresser

*Please see wiring diagramm NSB-1600-037.00 for further technical details! Note that the cable package is approximately 2m long, electrical switch box needs to be mounted at a proper place by customer.*

#### illustrations:



*"left-handed" type with above stated equipment  
(electrical switch box not shown in illustrations)*





# Product Information Sheet

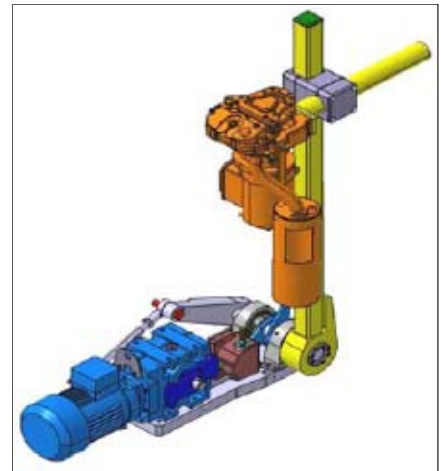
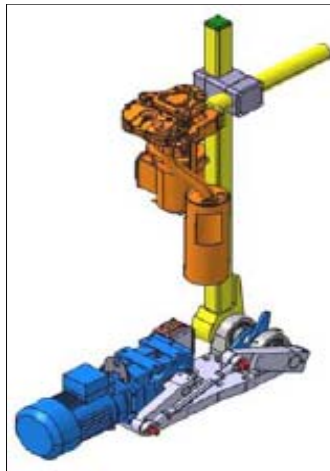
issued:  
01.01.2012

## complete swing-in system

product information:  
FS-1600.37000

### swing-in system FS-1600.37000

The swing-in system can be supplied as a "left-handed" (ill. 1) or "right-handed" (ill. 2) version for 4 different swinging areas each. In addition to that, two motor types are possible. Due to the different versions 16 delivery packages for the standard swing-in system are possible:



#### swing-in system - "left-motorized" type:

type	swivel angle	Bräuer article number	
		motor by SIEMENS	motor by SEW
"left"	90°	FS-1600.37000	FS-1600.37005
"left"	80°	FS-1600.37001	FS-1600.37006
"left"	70°	FS-1600.37002	FS-1600.37007
"left"	60°	FS-1600.37003	FS-1600.37008

#### swing-in system - "right-motorized" type:

type	swivel angle	Bräuer article number	
		motor by SIEMENS	motor by SEW
"right"	90°	FS-1600.37010	FS-1600.37015
"right"	80°	FS-1600.37011	FS-1600.37016
"right"	70°	FS-1600.37012	FS-1600.37017
"right"	60°	FS-1600.37013	FS-1600.37018

#### note:

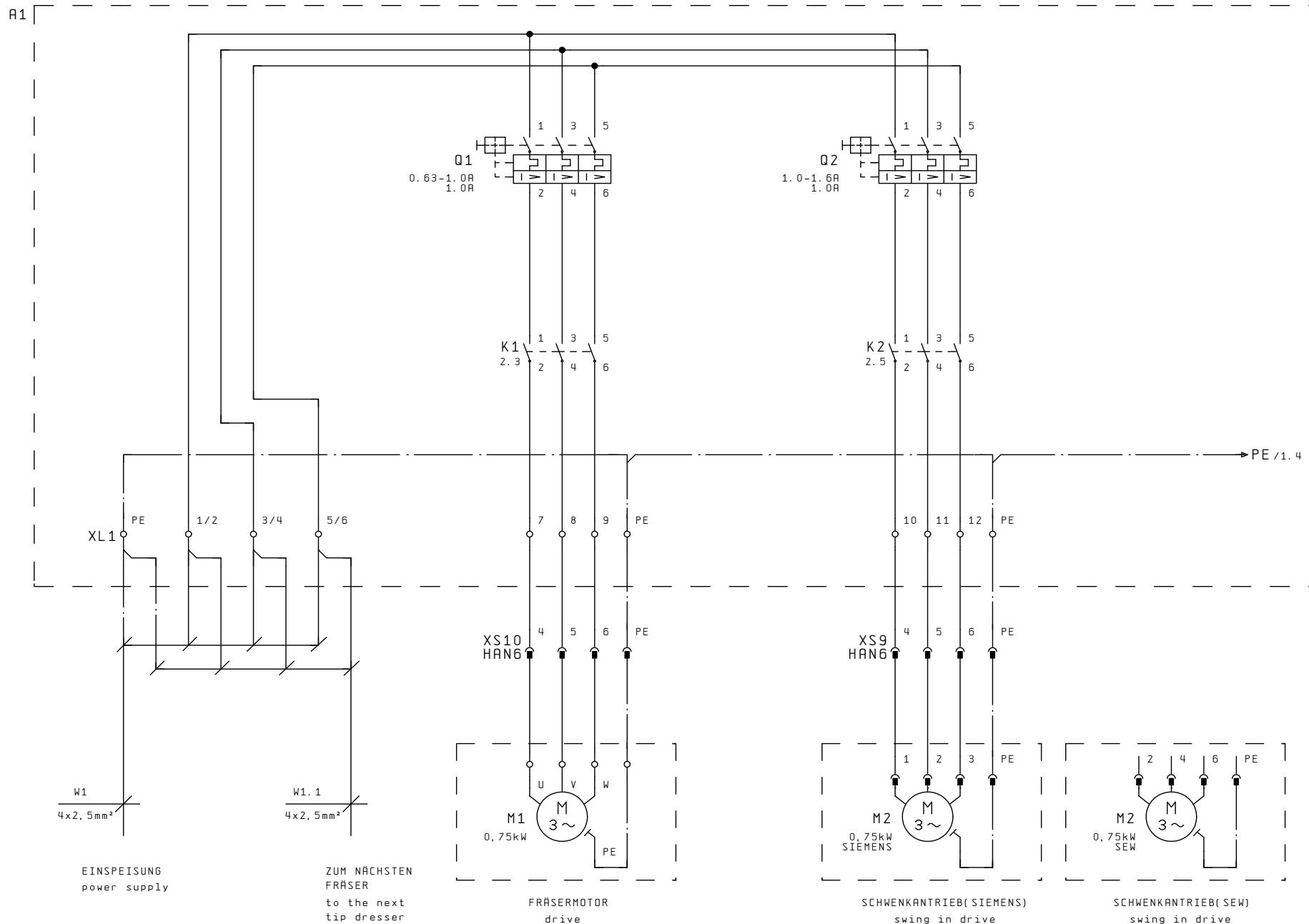
Please state the RAL-colours of the moving and fixed parts when ordering!

#### ordering example:

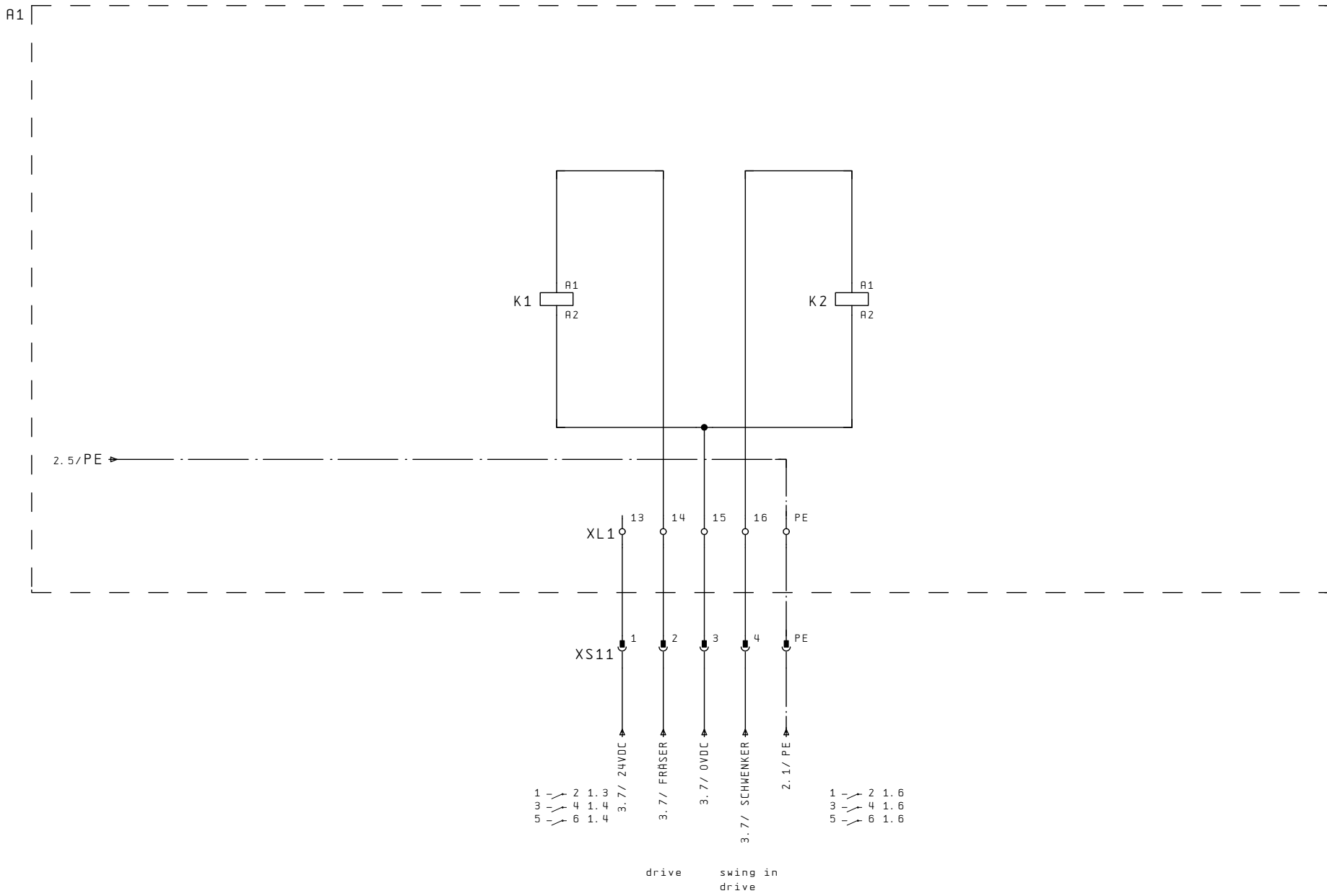
##### **FS-1600.37000**

swing-in system 1600.37000

(basic plate RAL 9002 / swinging arm RAL 2000)

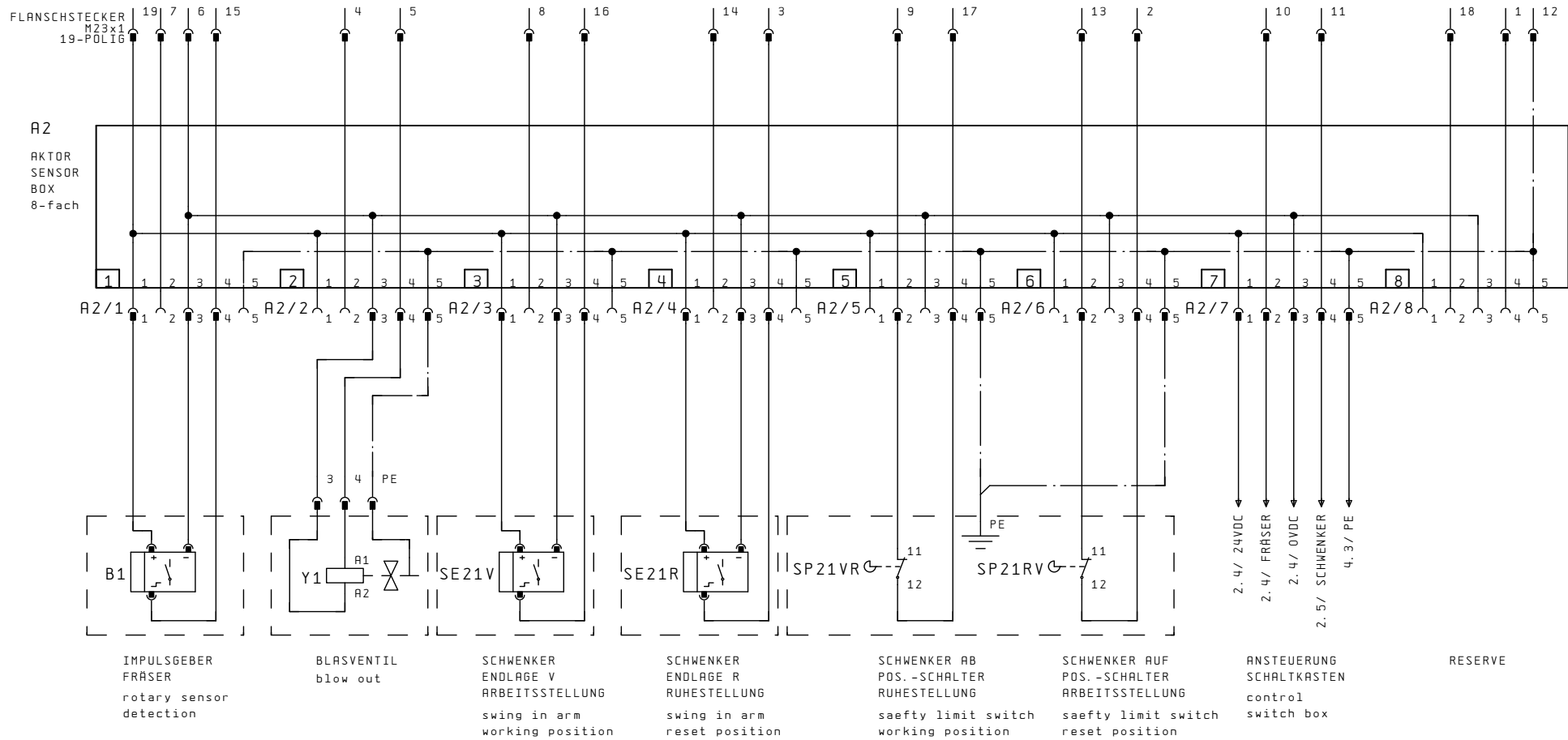


		Datum	23.11.10	Schwenkeinheit ABE 1600.037.00	BRÄUER STANDART	Schweißtechnik Bräuer GmbH Gewerbestraße 4 09488 Thermalbad Wiesenbad / Schönfeld Tel: 03733/560110 Fax: 03733/560111		NSB-1600-037.00	B1. 1
	Bearb.	SANDER							
	Gepr.	23.11.10							
Händerung	Datum	Name	Norm	Urspr.	Ers. f.	Ers. d.			3 B1



			Datum	23.11.10	Schwenkeinheit ABE 1600.037.00	BRÄUER STANDART	Schweißtechnik Bräuer GmbH Gewerbestraße 4 09488 Thermalbad Wiesenbad / Schönfeld Tel: 03733/560110 Fax: 03733/560111		NSB-1600-037.00	B1. 2
		Bearb.	SANDER							
		Gepr.	23.11.10							
Änderung	Datum	Name	Norm	Urspr.	Ers. f.	Ers. d.				3 B1.

AKTOR/SENSOR-VERTEILSYSTEM M12x1  
 8-FACH BOX, STECKBAR  
 MB-8M12-5P3



2

		Datum	23.11.10	Schwenkeinheit ABE 1600.037.00	BRÄUER STANDART	Schweißtechnik Bräuer GmbH Gewerbestraße 4 09488 Thiermalbad Wiesenbad / Schönfeld Tel: 03733/560110 Fax: 03733/560111		NSB-1600-037.00	B1. 3
	Bearb.	SANDER							
	Gepr.	23.11.10							
Änderung	Datum	Name	Norm	Urspr.	Ers. f.	Ers. d.			3 B1



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