

ESAB 250-35000 AHMA

Positioners for lifting, rotating and tilting demanding workpieces

Large movements - compact size

Infinitely variable height control by means of hydraulics

Remote control of all functions

ESAB positioners are designed in close co-operation with the best professionals in the field and on the basis of extensive practical experience.

ESAB 250-35000 AHMA positioners are in fact the best answer to the problem of lifting, rotating and tilting demanding workpieces.

Height, angle and speed are steplessly adjustable, thus guaranteeing the ideal ergonomic working position.

ESAB Positioners exceed the strictest international EN safety requirements

ESAB welding positioners are designed and built for tough engineering workshop conditions. All the positioners come with a low voltage (24V) remote control unit for all functions.

For daily work, these new positioners offer perfect solutions with optimized motor and gear drive sizes. The positioners of AHMA-series have 3-axis; height, tilting angle and rotation. Thus 3-axis operation is guaranteeing the ideal ergonomic working position. The rotation speed is adjustable by means of new inverter, so called vector inverter. The new technique of vector inverter improves accuracy and offers better rotation torque at very low rotation speeds. All drives are equipped with AC-motors which require less maintenance, no carbon-brush to change.

The hydraulics of height and tilt adjustment is equipped with built-in safety valves against hose-damages.

Mechanically and electrically the positioner has been designed more compact and with fewer components - meaning not only easier maintenance but smaller number of spare parts as well.



Positioner 750 AHMA

Positioner 7000 AHMA

Remote control

Easy control by help of a new small remote control with plug and play connection. Even if the remote control is small in size, it is big in features. The same control can be used on all standard positioner/roller bed models. Selecting the functions is carried out merely by connecting the remote control to the equipment and by then choosing the right type of positioner/roller bed from the display.

Thanks to the new bus connections the connecting cables are much thinner, lighter and more flexible.

In addition to functional keys, the remote control also features, as standard, a display for real rotation speed (rpm).

PEH Process Controller (optional for models 3500 AHMA and bigger)

The new positioners are compatible with PEH process controller. The whole welding process can be effectively automated.

For example, the rotation speed of the positioner can be controlled directly from the PEH control box, by just inserting a PEH control board (PH 60108100) and connecting the positioner with the PEH-controller by respective cables (PEH control cable 15 m PH60107600 and emergency stop cable 15 m PH60107100).

Load calculation

The loading torque should always be calculated from the surface of the table plate to the centre of gravity of the workpiece. When choosing positioners, the torque of the workpiece should be compared to the maximum torque in the appropriate table.

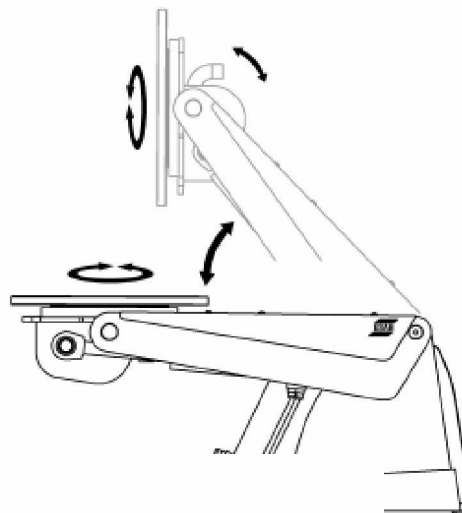
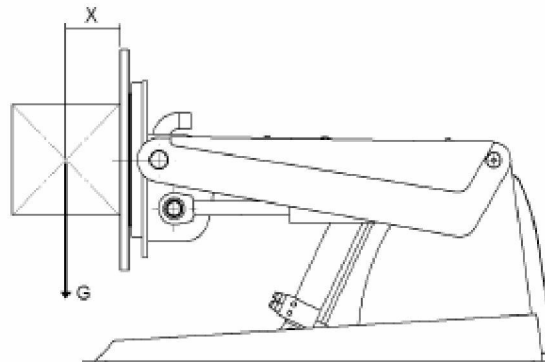
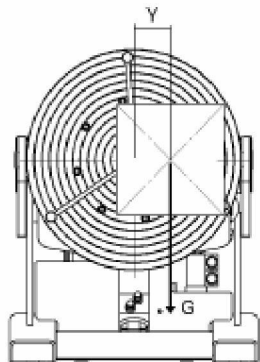
G (N) = weight of workpiece (kg) x gravity factor approx 10 (m/s²)

Y (m) = distance from centre of the table plate to workpiece centre of gravity

X (m) = distance from the surface of the table plate to workpiece centre of gravity

Rotational torque (Nm): $G \times Y$

Tilting torque (Nm): $G \times X$



Model	250 AHMA	750 AHMA	1500 AHMA	3500 AHMA	7000 AHMA	15000 AHMA AHMA	25000	35000 AHMA
Max load N	2 500	7 500	15 000	35 000	70 000	150 000	250 000	350 000
Rotation speed rpm	0.2-4.5	0.05-2.0	0.035-1.3	0.05-1.6	0.03-1.0	0.02-0.75	0.01-0.4	0.01-0.4
Max rotational torque Nm	80	600	1 000	2 800	9 000	18 000	40 000	55 000
Tilting / angle °degr.	man 135	hy 135	hy 135	hy 135	hy 135	hy 135	hy 120	hy 120
Tilting time 0-max angle s	manual	25	25	30	55	60	80	160
Max tilting torque Nm	300	1 500	3 000	7 500	14 000	70 000	175 000	280 000
Max welding current A	350	700	700	700	1 400	1 400	2 100	2 100
Table plate diameter mm	400	700	700	950	1 100	1 490	1 950	1950
T-slots on table plate	3 x M10	3 x M12	3 x M12	4 x M20	4 x M20	4 x M24	8 x M24	8 x M24
Center hole dia mm	60	-	-	-	-	-	-	-
Height min-max mm	man 490-910	720-1450	770-1540	980-1675	1000-1855	1300-2325	1600-2860	2000-3500
Length mm	940	1575	1640	2180	2640	3150	4080	4750
Width mm	570	695	810	1030	1490	1820	2380	2450
Weight kg	170	555	730	1800	3100	6500	15000	22000
Remote control	included	included	included	included	included	included	included	included
Mains supply connection 1x230V+N+PE	50 Hz	3x400V+N+PE	3x400V+N+PE	3x400V+N+PE	3x400V+N+PE	3x400V+N+PE	3x400V+N+PE	3x400V+N+PE
Power	16 A	16 A	16 A	25 A	25 A	32 A	35 A	50 A
Ordering information	PH10365301	PH10365401	PH10365501	PH10365602	PH10365701	PH10365801	PH10365901	PH10366001

On request:

Rotation control unit PEH-connection
PC-board + cables) Clamping chucks
for workpieces

see leaflet "Accessories for positioners" XA00120620
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