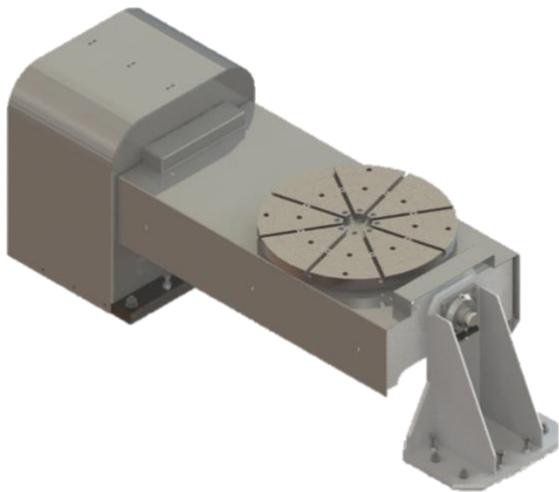


TILTING TURN TABLES

LTT-250, LTT-500L & LTT1250

The LTT-250, LTT-500 & LTT1250 Tilting Turn-Tables are heavy duty, high accuracy tilting turntables specially designed for today's thermal spray applications or laser cladding applications.



Turn tables are supplied in two versions:

1. Fully robot integrated as 7th and 8th axis, rotation/indexing and tilting/positioning
2. Standalone with own controller, rotation and tiling only (no indexing, no positioning).

All components selected for the tilting and rotation mechanism are of highest quality.

In the robotic integrated configuration, the rotation and tilting axis are fully integrated as external axis of the robot (7th and 8th axis). These robot controlled turntables provide a high degree of flexibility. Coordinated motions of the robot arm and the turntable allow the spraying of essentially any complex surface.

Movements and positions are programmed via the Robot teach pendant or off-line using robot simulation/development software.

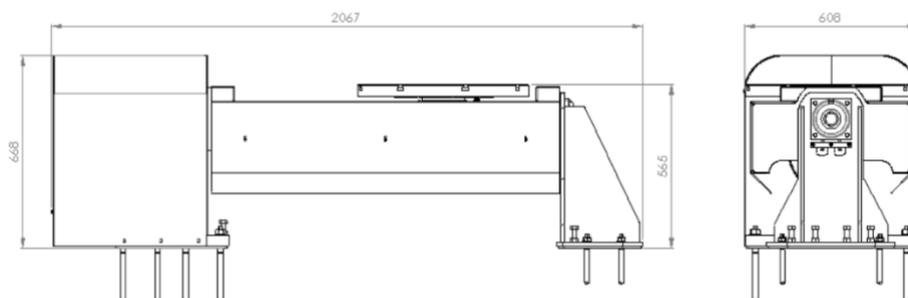
These turntables can be integrated with various robots including: ABB, (other robot systems upon request). Each axis is equipped with a high accuracy servomotor which is closed loop controlled. This provides highly accurate indexing and rotation.

The turntable system controls include safety devices to monitor the rotation speed, faceplate position and tilting movement of a work piece during the coating process. A zero speed sensor is used to monitor the rotational movement of the turntable during the spray process. In case of an unforeseen stop of the turntable, the control system will immediately stop the spray process and initiate the emergency shutdown mode. This feature prevents damage to the work piece by the process.

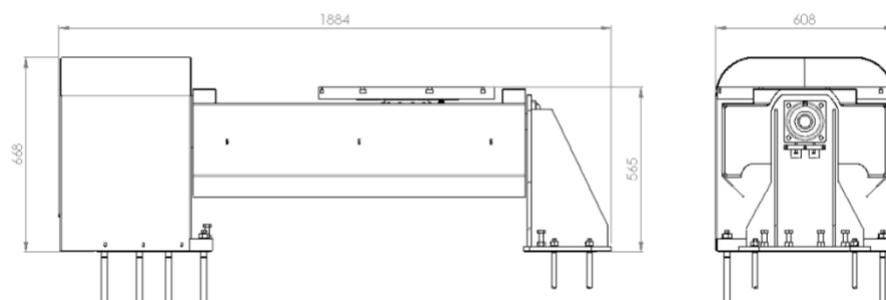
TECHNICAL SPECIFICATION

Description		LTT-250	LTT-500	LTT-1250
Load Capacity – Horizontal (0°) ¹	kg	250	500	1250
Load Capacity – Vertical (90°) ²	kg	180	250	1050
Recommended max. inertia product ³	kgm ²	11	13	13
Max. diameter product – Horizontal (0°)	mm	1400	1400	1600
Max. diameter product – Vertical (90°)	mm	850	850	850
Rotational speed range	rpm	0-300 (±1)	0-300 (±1)	0-300 (±1)
Acceleration time	sec	10	10	10
Direction of rotation	-	CW / CCW	CW / CCW	CW / CCW
Tilting repeatability accuracy	°	±0,1	±0,1	±0,1
Rotation repeatability accuracy	°	±0,1	±0,1	±0,1
Faceplate				
Material	-	Hardened	Hardened	Hardened
Diameter	mm	SS	SS	SS
Thickness	mm	600	600	600
T-slots	no.	40	40	40
		8	8	8
Max. allowed temperature faceplate	°C	90	90	90
Zero speed sensor	-	Optional	Optional	Optional
Hollow shaft for cooling	-	Optional	Optional	Optional
Total weight	Kg	±685	±700	±900

LTT-250 & LTT500

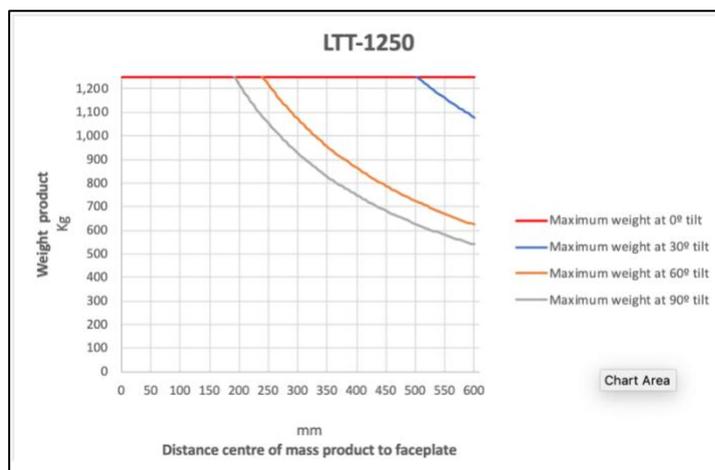
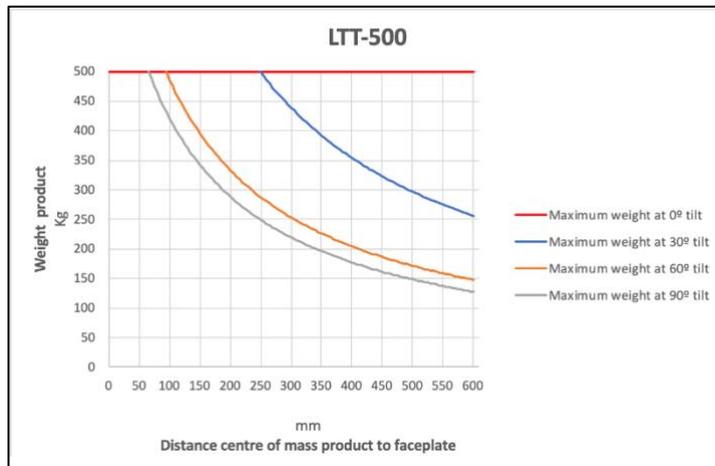
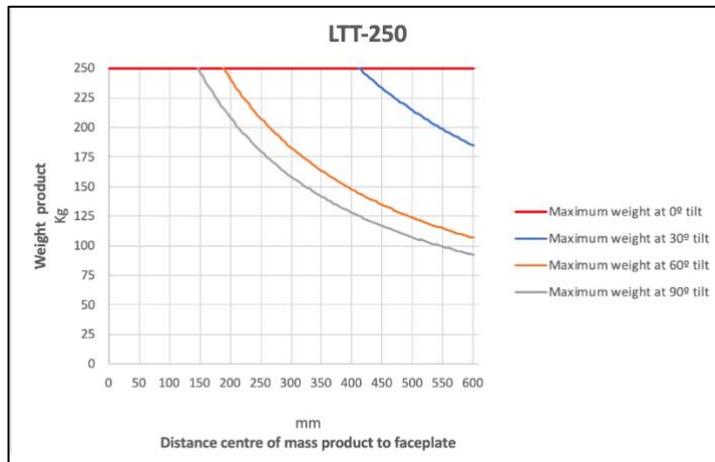


LTT-1250



Load diagram

Below the load diagrams of the different manipulators are given. The maximum allowed weight on the face plate, in relation to the centre of mass distance can be verified.



Flame Spray Technologies B.V.
The Netherlands (Head Office)
Tel: +31 26 3190140
Fax: +31 26 3190141
info@fst.nl

Flame Spray Technologies, Inc.
United States
Tel: +1 616 9882622
Fax: +1 616 9882629
info@fstincusa.com

Flame Spray Technologies Ltd.
United Kingdom
Tel: +44 2921 660511
Fax: +44 2921 660811
uk@fst.nl

Flame Spray Technologies
Middle East
Tel: +971 4 347 2220
Fax: +971 4 347 2221
fstme@emirates.net.ae

Flame Spray Technologies
France
Tel: +33 660 479051
D.Rivolet@fst.nl

Flame Spray Technologies Pte Ltd.
Singapore
Tel: +65 644 982 38
customer-support@fst-sg.com
www.fst.sg

