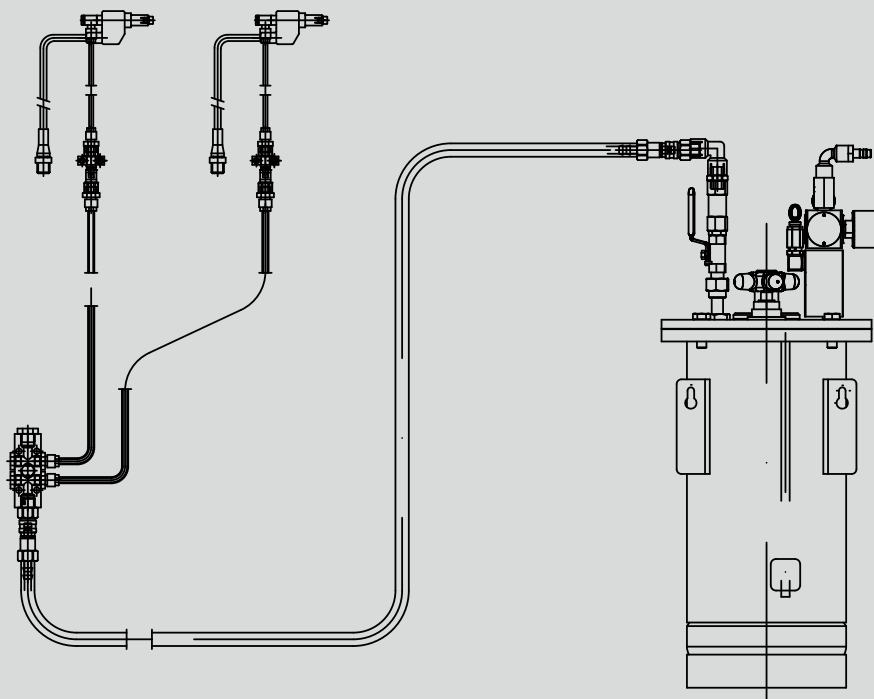


TOX®-Spray Equipment SP 02



Data
sheet
80.02

2017/02

TOX® PRESSOTECHNIK GmbH & Co. KG
Riedstrasse 4
D-88250 Weingarten

Find your local contact at:
www.tox-pressotechnik.com

TOX®-Spray Equipment

Type SP 02

Spraying system for spraying the workpiece surface and / or the TOX®-Tools before the joining process.

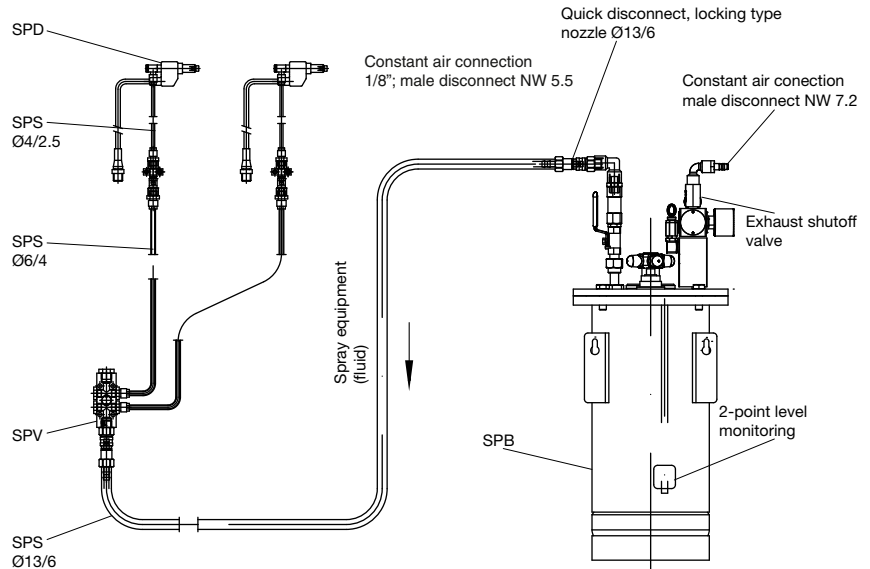
The spraying reduces the joining and stripping forces of the TOX®-Tools. Furthermore, the degree of forming of the materials increases due to the changed friction conditions.

Your application options remain flexible with the modular design of the TOX®-Spraying System. The system can be subsequently extended in complex plants.

Spray media with a maximum viscosity of 22 mm²/s can be used with the spraying system. The spray medium that is best suited to the technical requirements is assigned in the TOX®-Laboratory and is stated in the TOX®-Test Report. Furthermore, it is possible to use spray media that are preferred by the customer. The technological usability as well as compatibility with the TOX®-Spraying System is also tested within the scope of the TOX®-Test Report being created.

Note:

When using non-volatile spray media, spray media residue might remain on the component.



Function of complete system

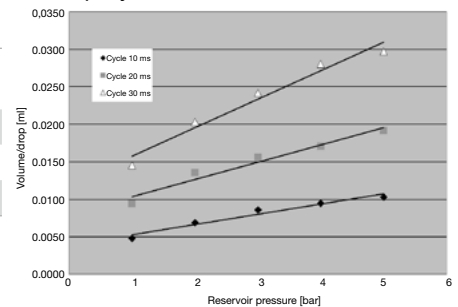
Several valve units can be connected in parallel on a central pressure vessel by means of spray distributors (SPV). Starting with the valve units, several spray heads (SPD) can be used for different requirements.

A pressure of approx. 2 bar is applied to the pressure vessel. The spray medium is distributed via solvent-resistant hoses. Each spray nozzle is equipped with a separately controllable valve.

Minimum flow rates for the spray equipment at a reservoir pressure of 2 bar and 10 msec cycle time:

Viscosity e. g. (mm ² /s)	Flow Rate (ml)
1	0.0075
2.5	0.008
22	0.009

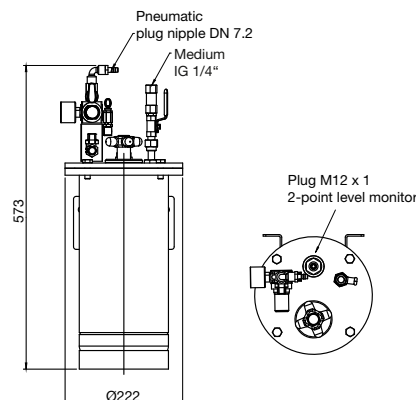
Flow rate diagram:
Spray medium: water, T = 18°C



Reservoir type SPB:

- Reservoir volume 6l;
- max. air pressure 6 bar
- Pressure regulator
- Pressure gauge
- Safety relief valve
- Dirt filter
- Quick exhaust
- Pressure relief valve
- Filling hopper
- 2-point level monitor

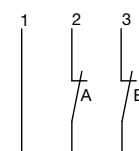
Ordering number
SPB 06.02.02.20



Technical data level monitor:
2 potential free NC contacts

Operating voltage: 24 VDC
Operating current: 150 mA
Protection class: IP65

Connection of 2-point level monitor



Plug M12 x 1
4-pole

Switching state for filled reservoir. If the medium level is falling, the contacts are opened.

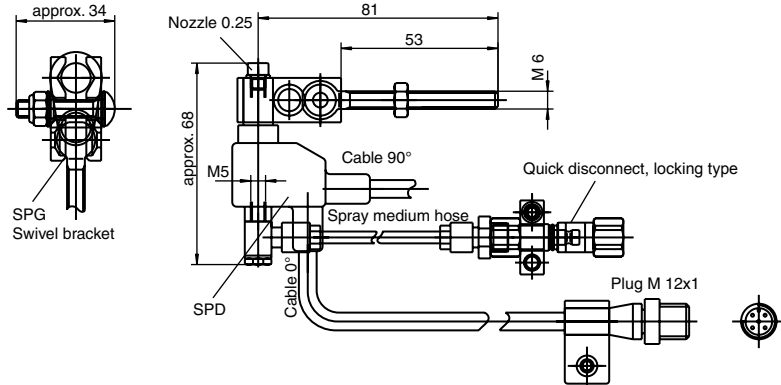
A = approx. 30 % filling level
B = approx. 10 % filling level

TOX®-Spray Equipment

Type SP 02

Spray head type SPD, complete:

- main body with integrated valve
- spraying distance of up to 300mm
- includes 1000mm cable with M12x1 plug
- includes 1000mm spray medium hose
- version 00 and 01 cable connection 0°
- 00 includes quick disconnect and fittings
- 01 without quick disconnect and fittings
- version 03 and 04 cable connection 90°
- 03 includes quick disconnect and fittings
- 04 without quick disconnect and fittings



Ordering example

SPD 02.00
 — Version
 — Electric connection
 — M12x1 plug
 — Type: spray head

Technical data spray valve:

Voltage: 24VDC
 Power: 5 Watt
 Connection: M12 plug 5-pole
 + 24V PIN 4
 0V PIN 3

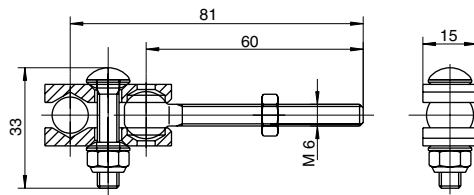
Swivel bracket type SPG:

- clamp spray head
- connecting threads M6

Flexible mounting for the spray head. Allows for accurate positioning of spray equipment.

Order number

SPG 01.00



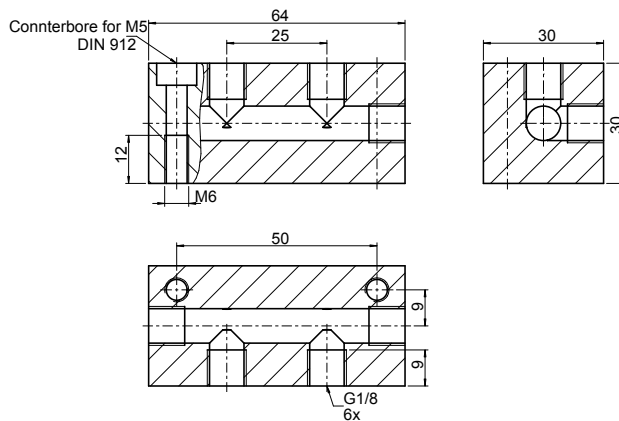
Spray manifold type SPV:

- manifold for spray heads

Depending on number of spray heads and application.

Order number

SPV 04.00



The hoses and fittings for the spray system installation are individually defined in the bill of materials for the schematic diagram.

Hose types SPS in use:

- SPS Ø 13/6: spray media compatible and abrasion resistant
- SPS Ø 6/4: spray media compatible
- SPS Ø 4/2.5: spray media compatible