**CENTRIFUGAL DISC FINISHING MACHINE TT...-A/2C**

TROWAL MASS FINISHING

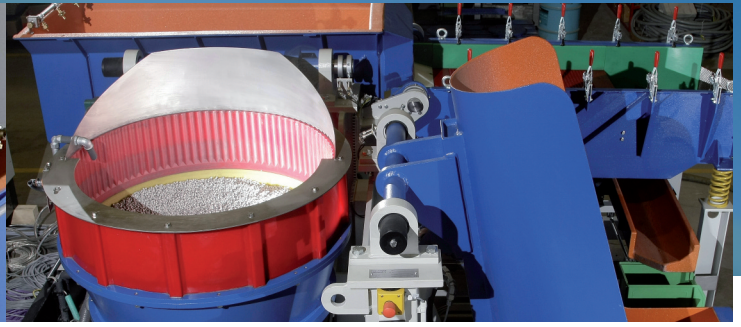
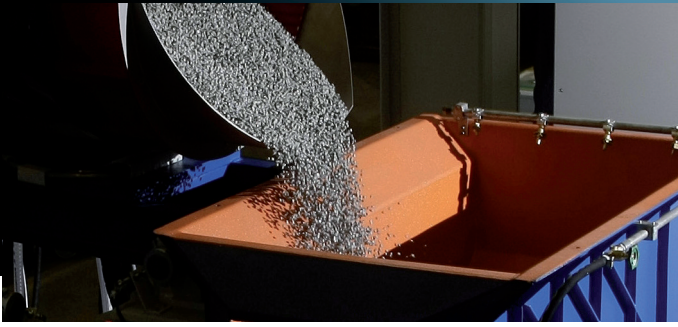
Centrifugal disc finishing machines TT...-A/2C 2- Batch System

Top performance!

Compared to vibrators, Trowal Turbotron centrifugal disc finishing machines offer up to 10 times higher grinding performance. Turbotron machines are mainly used for the removal of strong burrs and for the edge radiussing of small and medium size bulk parts. However, due to the application of special processing technologies, Turbotron machines are also suited for fine grinding and even polishing and "super polishing" operations.

How it works

The rotating spinner (60 - 250 RPM) accelerates the work piece / media mass to the wall of the stationary work bowl and pushes the mass upwards along the work bowl wall. With decreasing acceleration and increasing gravity the mass slides back down to the spinner where it is again accelerated.



Advanced machine technology

- Optimum dynamic geometry of spinner and work bowl
- Infinite water level control
- Infinitely adjustable speed of the spinner
- Automatic gap control via PLC the gap can be adjusted
- Rinsing of gap prevents premature wear of spinner and work bowl
- Anti-blocking system prevents "seizure" of the spinner
- Additional protection of spinner and work bowl by temperature control in the gap area

The double batch system

While one batch with finished parts is separated on the screening machine a second batch is processed in the work bowl.

| | | A | AA | B | C | D | E min | F |
|-------|------|-------|-------|-------|-------|-------|----------|-------|
| TT60 | A2C* | 2,100 | | 3,100 | 2,700 | 542 | ca.830 | 1,085 |
| | AT** | | 3,100 | 3,100 | 2,700 | 542 | ca.830 | 1,085 |
| TT90 | A2C* | 2,100 | | 3,100 | 2,700 | 637 | ca.830 | 1,115 |
| | AT** | | 3,100 | 3,100 | 2,700 | 637 | ca.830 | 1,115 |
| TT140 | A2C* | 2,350 | | 3,300 | 3,000 | 740 | ca.950 | 1,255 |
| | AT** | | 3,450 | 3,300 | 3,000 | 740 | ca.950 | 1,255 |
| TT280 | A2C* | 2,750 | | 3,500 | 3,025 | 914 | ca.950 | 1,320 |
| | AT** | | 4,100 | 3,500 | 3,025 | 914 | ca.950 | 1,320 |
| TT520 | A2C* | 3,000 | | 4,000 | 3,400 | 1,000 | ca.1,100 | 1,600 |
| | AT** | | 4,400 | 4,000 | 3,400 | 1,000 | ca.1,100 | 1,600 |

*Automatic double batch machine **Automatic four-batch tandem machine

| Double batch system | TT 60-A/2C | TT 90-A/2C | TT 140-A/2C | TT 280-A/2C | TT 520-A/2C |
|-------------------------------|------------|------------|-------------|-------------|-------------|
| Gross volume litres | 60 | 90 | 140 | 280 | 520 |
| Capacity work pieces* | 6 - 40 | 8 - 60 | 14 - 100 | 28 - 200 | 50 - 400 |
| Material work bowl | Steel / PU | Steel / PU | Steel / PU | Steel / PU | Steel / PU |
| Drive mode | electric | electric | electric | electric | electric |
| Spinner power kW | 4 | 4 | 11 | 15 | 30 |
| Speed max. (50 Hz) | 213 | 213 | 179 | 181 | 145 |
| Screening area m ² | 0.5 | 0.5 | 0.5 | 0.8 | 0.8 |

*Depending on the work piece geometry, material, sensitivity of the parts. The quantity of media and work pieces is determined by these factors.

In this manner costly idle times – especially for parts / media separation – can be minimized and productivity maximized. Double batch systems are ideally suited for automation.

Tandem Systems

Tandem systems – a version of the double batch system – are used for applications with relatively long processing times and short separation times:

Tandem systems have 2 work bowls but only one intermediate hopper and screening machine. The combined intermediate hopper and screening machine is used alternately by the 2 work bowls.

Advantage: Saving in cost and space requirements!

