3.2 Turning Rolls

ON • ON-SP • ON-VV

Rotating vessels and pipes during welding, cutting, painting and positioning. ON 5–100 t, self-aligning ON-SP for pipes that are not perfectly round, compact ON-VV up to 8 t.

Applications Vessels, pipes and tanks – for welding, cutting, painting and positioning.

Description

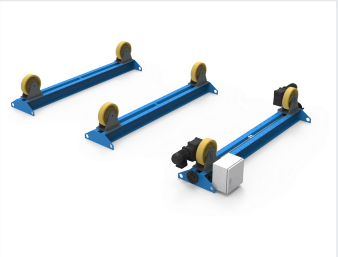
Turning rolls (also known as roller bed rotators) are used to rotate workpieces (vessels, tubes and the like) during processes such as welding, cutting, painting and positioning. They consist of two independent units: a drive unit and an idler unit. Both units can be moved longitudinally. The drive unit is fitted with one or two driven wheels, while the idler unit has free-running wheels. ON-VV turning rolls serve the same purpose, but are designed for lighter loads and cannot be moved longitudinally.

Each unit consists of a base frame, wheel carriers, wheels and, in the movable version, a frame with wheels for rails. The wheel surface is coated with hard polyurethane for durability and the required friction. Each wheel carrier can be moved manually along the base frame to suit different diameters. Rotation direction and speed can be controlled remotely. For longer workpieces several sets of turning rolls can be placed in line.

Options

- Wireless remote control
- Linear guides for wheel movement
- Speed control with foot switch
- Welding signal start/stop
- Steel wheels with copper-graphite brushes
- Touchscreen

Types



ON (5 – 100 t) • page 36

Two wheels on each unit; each wheel can be moved individually (manually) by a spindle. This configuration is especially recommended for handling and rotating heavy workpieces.



ON-SP (5 – 100 t) • page 37

A self-aligning type: it can be used for tubes that are not perfectly round and allows several diameters without moving the units. Each unit has four wheels.

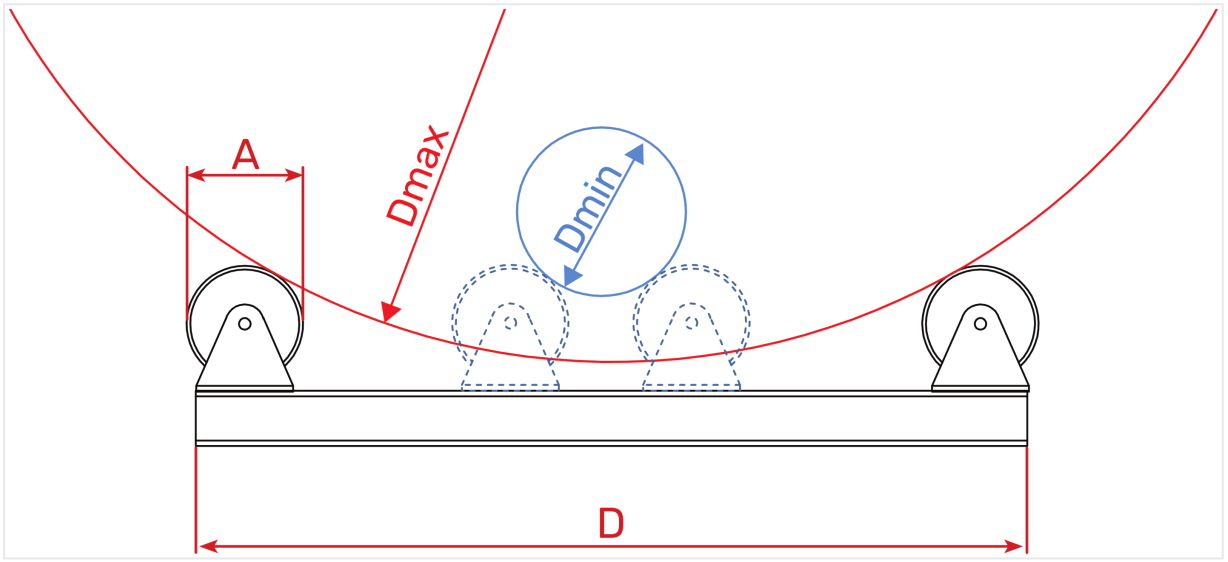


ON-VV (1 – 8 t) • page 38

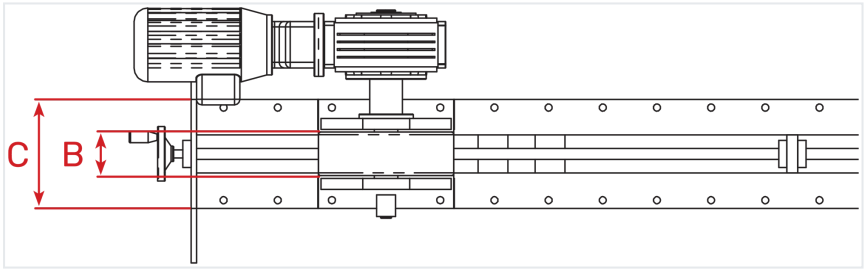
Turning rolls for lighter loads, up to 8 tonnes. The scissor-shaped construction makes them compact and ideal for smaller workpieces.

3.2 ON 5 – 100 t

Turning Rolls



Front view



Top view

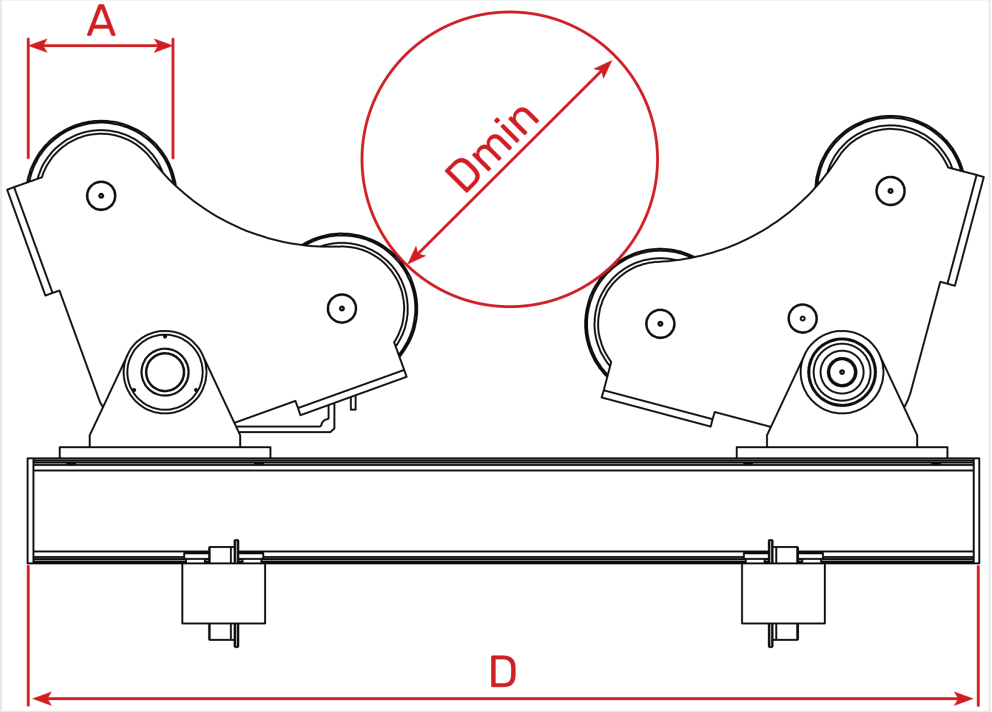
This type is fitted with two wheels on each unit; each wheel can be moved individually (manually) by a spindle.

Technical data

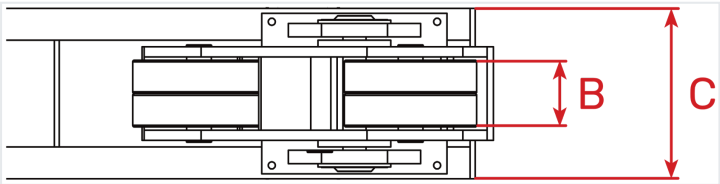
		ON 5t	ON 10t	ON 20t	ON 40t	ON 60t	ON 100t
A	mm	300			500		
B	mm	80	100	100	200	300	500
C	mm	300	300	400	500		800
D	mm	2,200			2,800		3,200
Dmin / Dmax	mm	200 / 3,800			400 / 5,500		
Load capacity	t/unit	2.5	5	10	20	30	50
Drive wheel torque	Nm	600	1,200	3,000	5,000	6,000	15,000
Turning speed	m/min	0.1 – 2					
Wheel material		PU					
Length – drive unit	mm	2,500			3,100		3,600
Length – idler unit	mm	2,200		2,500	3,100		3,600
Width – drive unit	mm	500		700	800	900	1,100
Width – idler unit	mm	300		400	500	600	800
Remote control		included					

3.2 ON-SP 5 – 100 t

Self-aligning turning rolls



Front view



Top view

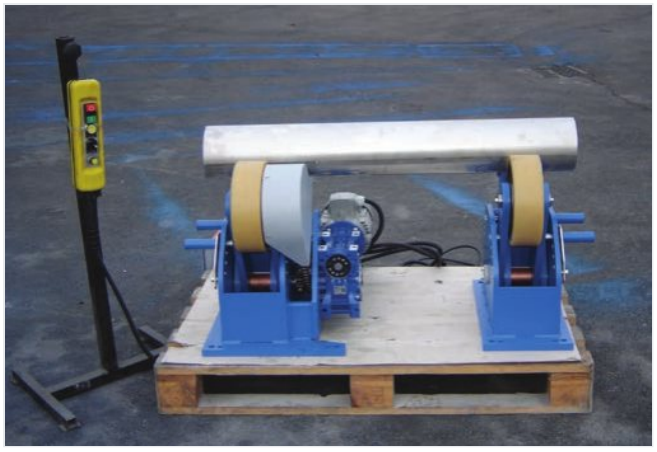
On this type each unit has four wheels. The wheel units are fixed and have only one position. The units are “self-aligning”, so they do not have to be moved when the workpiece diameter changes.

Technical data

		ON-SP 5t	ON-SP 10t	ON-SP 20t	ON-SP 40t	ON-SP 60t	ON-SP 100t
A	mm	250		300	350	400	500
B	mm	80	100	100	200	300	400
C	mm	300	300	400	500	500	800
D	mm	1,500			2,500		3,200
Dmin / Dmax	mm	400 / 3,800	400 / 4,500			500 / 5,500	
Load capacity	t/unit	2.5	5	10	20	30	50
Drive wheel torque	Nm	600	1,200	3,000	5,000	6,000	10,000
Turning speed	m/min	0.1 – 2					
Wheel material		PU					
Length – drive unit	mm	2,500			3,100		3,600
Length – idler unit	mm	2,200		2,500	3,100		3,600
Width – drive unit	mm	500		700	800	900	1,100
Width – idler unit	mm	300		400	500	600	800
Remote control		included					

3.2 ON-VV 1 – 8 t

Compact turning rolls



ON-VV 3t



ON-VV 3t



ON-VV 1t



Steel wheels and copper-graphite brushes (option)

ON-VV are turning rolls for lighter loads, up to 8 tonnes. The scissor-shaped construction makes them compact and ideal for working with smaller pieces. The distance between the wheels can be set manually (4 positions) to suit the size of the workpiece.

Technical data

		ON-VV 1t	ON-VV 3t	ON-VV 5t	ON-VV 8t
Load capacity	t	1	3	5	8
Workpiece diameter Ø	mm	100 – 1,000		200 – 1,500	
Wheel diameter	mm	125	250	300	
Wheel width	mm	40	80	100	135
Turning speed	m/min		0.1 – 2		
Rated power	kW		0.3		
Rated voltage	V		230		
Frequency	Hz		50		