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1. Technical scope of the quoted machine RB 650/1200/6 MP

- Self-centring three-jaw pipe chuck with main drive, electric-motor-driven clamping process and CNC axis
- 2 mechanical pipe carriages with manual scissor-type adjuster.
- Column carriage of 16,000 mm length with column, boom, torch head and CNC axis.
- Torch head with oscillation along the pipe axis, 380° rotation about its own axis and 2 CNC axes.
- Laser sensor with CNC axis for corrections of variation between the flame cutter and pipe surface.
- Slide system with CNC axis for automatic advance and retraction of the cutting torch.
- Electrical hardware consisting of switch cabinet, CNC, PLC, industrial computer (with Windows 7 operating system in German or English) and control panel.
- Quint buffer UPS.
- COROBS® pipe profile cutting machine in German or English with MDI module, SAC module, SPC module, MPC module, CPS module, starting point optimization, optimization of piercing, joint compensation, automatic speed control, negative cutting angle correction, restart positioning for aborted cutting operations, self-diagnosis system, logfile on the most recently performed operations.
- Library of standard cut macros.
- LAN interface.
- Internet maintenance module.
- Conventional oxy-fuel cutting package for the cutting of pipes with a maximum wall thickness of 90 mm, with solenoid-valve-controlled gas supply, manometer for setting gas pressure, ignition torch, solenoid-valve-controlled cutting torch, cutting nozzle package and operator protection package.
- Solenoid-valve-controlled preheating torch.
- Omniflow patented automatic gas control system.

2. Technical data of the quoted machine RB 650/1200/6 MP

Installation space in length, width, height:	mm	18.000 × 4.000 × 4,000
Gross weight:	kg	approx. 11,000
Maximum pipe weight: ¹⁾	kg	approx. 12,000
Clamping in the chuck ²⁾ :	mm	80 – 650
Clamping on the chuck ²⁾ :	mm	650 – 1,220
Diameter range of cutting head oscillation:	mm	80 – 1,220
Oscillation range for weld bevel with oxy-fuel:	degrees	+70° to -70°
Oscillation range for weld bevel with plasma:	degrees	+45° to - 45°
Torch rotation:	degrees	380°
Min. cutting range in front of the chuck: ³⁾	mm	300
Max. cutting range in front of the chuck: ³⁾	mm	12,000
Min. cutting range behind the chuck: ^{3) 4)}	mm	1,800 ⁵⁾
Max. cutting range behind the chuck: ^{3) 4)}	mm	2,300 ⁵⁾
Min. wall thickness for flame cutting: ^{3) 6)}	mm	5
Max. wall thickness for flame cutting: ^{3) 6)}	mm	90
Min. wall thickness for plasma cutting: ³⁾	mm	depends on power source
Max. wall thickness for plasma cutting: ³⁾	mm	depends on power source
Chuck rotation speed:	rpm.	0–5 ⁷⁾
Chuck clamping speed:	mm/min.	0–600
Max. static radial load in the chuck:	N	20,000
Torque	Nm	8,000
Torch carriage speed:	mm/min.	0–15,000
Max. static radial load of the pipe support carriage for diameters 80 – 1.220 mm:	N	75,000
Power supply to DIN IEC 38:	V	400
Other power supply alternatives on request	Hz	50
	phase	3, AC
	kVA	13 (oxy-fuel) / X (plasma) ⁸⁾
Mains voltage fluctuations to DIN IEC 38:	%	+6/-10
Mains frequency fluctuations	Hz:	±1.5
Permissible temperature range:	°C	5–40
Computer:		industrial PC
Oxygen:		8–8.2 kg/cm ² , purity 99.4% – 18,000 L/h
Acetylene/propane:		0.2-0.25 kg/cm ² , purity 98% - 1,700 L/h

Footnotes for technical data

- 1) If 2 carriages are employed.
- 2) The maximum pipe diameter in and on the chuck depends on the pipe's cylindrical shape. In the event of pipe deformation, the maximum diameters change accordingly.
- 3) The data refer to a vertical torch position.
- 4) The starting point is on the front of the jaw in front of the chuck.
- 5) Cutting behind the chuck is possible if the torch carriage track is extended (covered by this quotation).
- 6) The maximum cuttable wall thickness of 90 mm is not achievable with every combination of pipe diameter, pipe length and material, as the combination of pipe diameter, pipe length and material has an effect on pipe weight. The pipe weight that can be handled by the pipe profile cutting machine depends on the chuck's load-bearing capacity (maximum static load in the chuck), the torque in the chuck, and the load-bearing capacity and number of pipe carriages (maximum static load in the chuck). If no details are available from the customer at the time of quotation submission, the maximum possible pipe weight is limited to the technical data within this quotation.
- 7) When cutting thin-walled pipes with small diameters, we recommend, particularly if plasma cutting is employed, a much higher chuck rotation speed, otherwise the material of the pipes mentioned above will burn at a maximum speed of 5 rpm. In this case, we propose a chuck speed of 16 rpm (not covered by this quotation – please refer to enclosed list of optional extras).
- 8) Depending on the plasma cutting equipment.