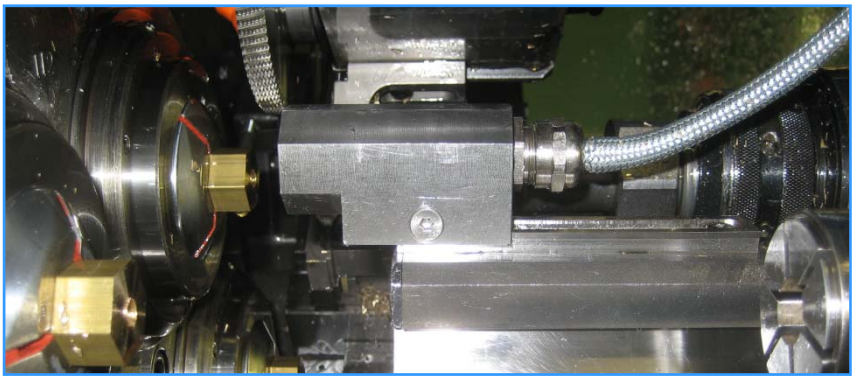
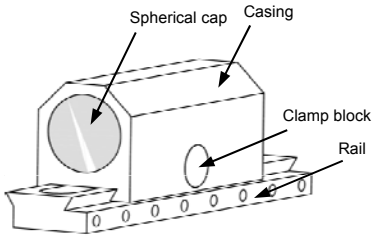
NORDMANN

TOOL MONITORING
AND PROCESS CONTROL

Workpiece length detector WLT





Specifications:

Casing, Rail, Clamp bolt:	Chrome nickel steel
Spherical cap:	High-alloyed reinforcement steel, TiN-coated
Weight :	1105 g
Power supply:	± 15 V
Temperature range:	+5°C to +70°C
Temperature drift :	≤ 3 µm (at 18 - 25°C)
Measuring range:	0.60 mm (0.1 mm / V)
Measuring voltage in neutral position (spherical cap not inserted):	2 V
Connecting lead:	Metal mesh hose protection (Ø = 10 mm) LiYCY 3 x 0.14 mm² + Shield / L = 5.00 m

- **Robust model**
- **Easy to adjust via a guide rail.**
- **Integrated measurement amplifier**

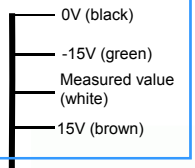
Measuring principle:

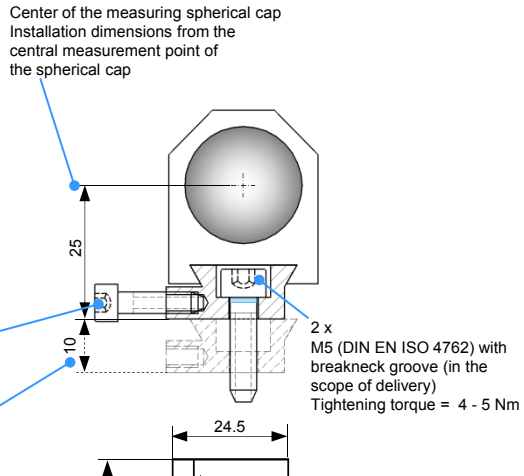
Work pieces touch the measuring spherical cap during indexing from one slide to the next slide. Compared with the smaller WLT-Mini (Order No. 8.2.4) the TiN coated measuring spherical cap is housed in a solid casing, so that collisions with work pieces that are too long do not have to result in damage of the sensor.

Nordmann GmbH & Co. KG • Kalscheurener Str. 8 • D-50354 Hürth
☏ +49(0) 2233/9688-0 • 🖷 +49(0) 2233/9688-22
Web: www.nordmann.eu • Mail: info@nordmann.eu

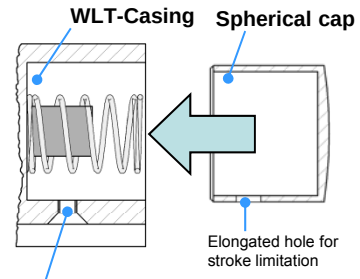
Nordmann International GmbH • Huobstrasse 10 • CH-8808 Pfäffikon
☏ +41(0) 55/4101500 • 🖷 +41(0) 55/4106462
Web: www.nordmann.eu • Mail: international@nordmann.eu

Terminal assignment:

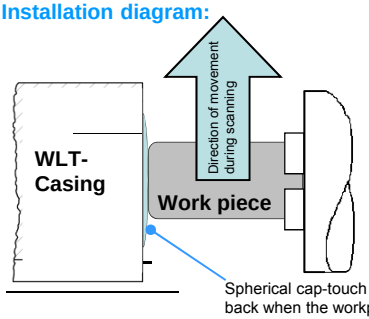




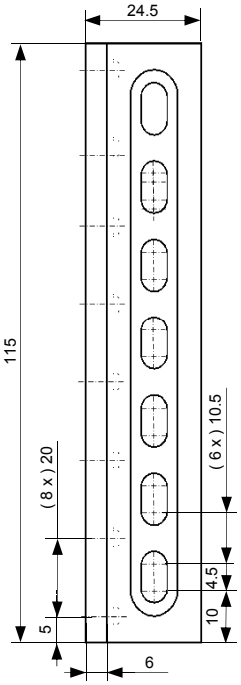
Replacing the spherical cap:



Installation diagram:



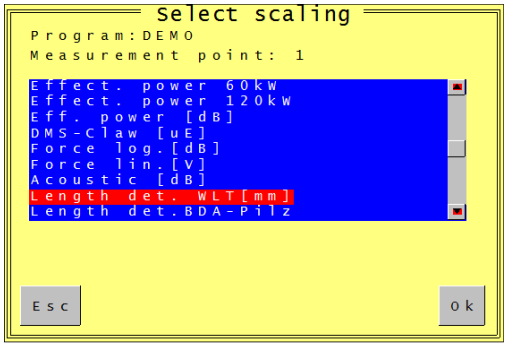
The measurement requires a precise alignment of the WLT. The spherical cap should not spring back more than 0.3 mm when scanning , and the overall stroke of the spherical cap amounts to 0.8 mm.



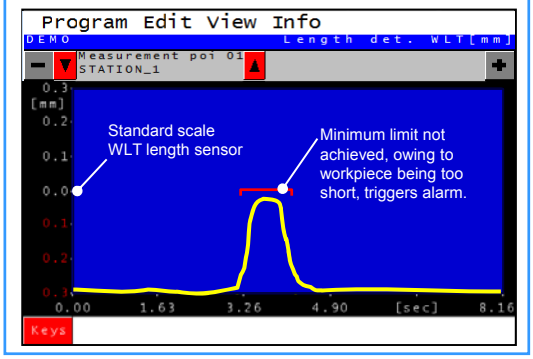
Using the WLT scanner, the length of workpiece can be checked by guiding the work piece between two machining stations along its slightly arched spherical cap (see installation diagram).

The measured value provided by the WLT can be shown by the tool monitor SEM module via a standard scale provided for this and be checked for sufficient height via a minimum limit (see a) Screenshot Tool Monitor). When reaching this minimum limit, a reject switch or / and a machine stop can be triggered, optionally: only after a predefined number of directly successive workpieces that are too short . (see b) Screenshot Tool Monitor)

a) Screenshot Tool Monitor:



b) Screenshot Tool Monitor:



Order number:

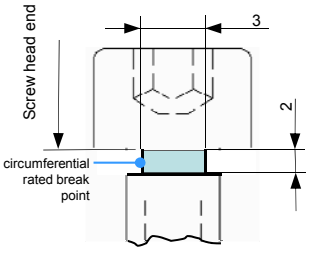
WLT (complete) 8.2.2

Spare parts:

WLT-Rail	8.2.4 .S
WLT-Spherical cap	8.2.2 .K

Installation with third-party screws:

For installation with longer screws not included in the scope of delivery , a breakneck groove should be screwed off at the bolt head (see diagram) and the above-mentioned tightening torque must be respected! Mounting of screws with the greatest possible distance from each other!



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