

Pre-assembly devices

Type 90 Comfort

Device for electrical mains power
400 V / 50 Hz / 3 Ph



Type	Order-No.	Designation
For machine-assisted pre-assembly of cutting rings on tubes with OD 6 - 42 mm, and for machine-assisted pre-assembly of flared cones and ZAKO rings, by means of a conversion kit (not part of standard delivery package).	5992893000	TD-TYPE90C2
Dimensions		
Width:	800 mm	
Height:	308 mm	
Depth:	615 mm	
Depth (with conversion kit):	636 mm	
Weight:		
Weight:	90 kg	
Noise level:		
Noise level:	70 dBA	
Conversion kit	9799600141	TD-BV10A-TYPE90C2
Other power supply ratings upon request.		

Pre-assembly devices

Type 85

Device for electrical mains power
400 V 16 A AC
3 Ph / N / PE / 50 Hz / 0.75 kW



Type	Order-No.	Designation
For machine-assisted pre-assembly of ZAKO rings for tubes with outer diameters 38 mm – 114.3 mm incl. drive unit and high-pressure hose.	5991085000	TD-TYPE85-DUHY1
Pre-assembly cylinder Type 85 without drive unit. Device for connection to a drive unit. $P_A = \text{max. } 700 \text{ bar}$ $V = \text{min } 3\text{l}$ with hydraulic plug coupling (NW 10 coupling sleeve YALE CFY-10-10).	5991085100	TD-TYPE85
Dimensions Width: 340 mm Height: 320 mm Depth: 650 mm		
Weight: 160 kg		
Drive unit (Electric hydraulic power pack YALE PY-07).	5992361000	TD-DUHY1
Other power supply ratings upon request.		

Precise checking of gauge accuracy

VOSS Fluid taper gauges for pre-assembly studs



Hardened pre-assembly studs for the coupling of cutting rings are wear-resistant, thus achieving consistent pre-assembly results. To maintain these results, the tools must be checked at regular intervals, since they are nevertheless subject to a certain degree of wear.

In addition to a visual inspection for damage or cracks, the checks must also include verification of the die dimensions using a gauge. This involves checking the internal conical bore of the pre-assembly die after every 50 applications.

VOSS taper gauges are available individually or as a complete set containing all sizes of the light-weight and heavy duty versions in a practical plastic case.

See page 355 for ordering information.

Cutting ring geometry at a glance

VOSS Fluid taper gauges for pre-assembly studs



VOSS supplies inspection gauges to check the results of cutting ring pre-assembly and which can be used to evaluate pre-assembly in conjunction with visual inspection of the pushed-up tube material. To establish a permanently leak-tight cutting ring coupling, the pre-assembled end of the tube must contact the screw coupling connecting piece and the cutting ring must be inserted securely into the 24° conical recess. A closed force transmission path and the resulting safe connection can only be achieved by the interaction of this geometry with a strong ring of raised tube material. The VOSS taper gauge is used as an auxiliary device for evaluating cutting ring pre-assemblies and summarizing the geometry situation in the form of legible values.

Operating principle:

The results are checked by measuring the pre-assembled tube end. This is done by pushing the tube end into the conical opening of the taper gauge and screwing on the union nut manually, hand-tight, without a spanner. The pointer of the dial will move until the cutting ring cone is in contact with the tapered hole in the gauge. The indicated value must be within specified limits. If the value is below the specified range, the assembly is probably faulty and the cutting ring is too near the end of the tube. If the value is higher than the specified range, it must be assumed that the cutting ring is too far from the end of the tube.

Applications:

- Series production of tubing Incoming goods
- Inspection of preconfigured tubing

Caution!

Use of the gauge does not eliminate the need to visually check for excessive or too little pre-assembly pressures (by checking the height of tube material pushed up by the first cutting ring edge)

See page 356 for ordering information.

Pre-assembly devices

Type 90 Basic II

Device for electrical mains power
400 V / 50 Hz / 3 Ph



Type	Order-No.	Designation
For machine-assisted pre-assembly of cutting rings on tubes with OD 6 – 42 mm, and for machine-assisted pre-assembly of flared cones and ZAKO rings, by means of a conversion kit (not part of standard delivery package).	5992892000	TD-TYPE90B2
Dimensions		
Width:	681 mm	
Height:	260 mm	
Depth:	520 mm	
Weight:	66 kg	
Noise level:	60 dBA	
Conversion kit	9799600140	TD-BV10A-TYPE90B2
Other power supply ratings upon request.		