



(Sample picture not binding)

Offer N° CMB-19-3115-1

Horizontal axis balancing machine model ZB750/TC/GV

**hard bearing technology, permanent calibration based on rotor dimensions, with
belt drive system
(sample lay-out 39IO35456)**

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1 Main machine specifications

The balancing machine we are proposing is 'hard bearing' type.

This feature allows to easily calibrate the machine and to obtain the best possible measuring accuracy.

Machine calibration is simply achieved by setting rotor geometrical dimensions.

This done, after one spin only and independently from the rotation speed, the machine automatically displays the value in grams and the angular position of unbalance for both planes.

At the end of the cycle, the balancing machine instrument keeps this data in the memory.

The measuring cycle is fully automatic; in fact, by pressing the start button, the machine accelerates the rotor progressively, completes the unbalance search cycle, stores the obtained data and decelerates the rotors till stop. Depending on rotor inertia, this operation is completed in a few seconds.

Many other special functions are also available on the instrument panel and this thanks to the experience we have accumulated in more than 30 years manufacture of hard bearing balancing machines.

Our machines make use of piezo-electric force transducers and this ensures remarkable advantages when compared to the 'semi-rigid' or 'dynamometric' system with electro-dynamic pick-ups as in use by other manufacturers.

In fact, thanks to the mechanical rigidity of these new type transducers, a wider range of application is ensured, since the measuring of the relative elasticity of the pedestals is not altered.

With the 'dynamometric' or 'semi-rigid' system it was in fact necessary to come to a compromise between the pedestals stiffness (necessary for maintaining the assembly rotor-pedestal far from the critical speed and thus allow the dimensional calibration) and the must to pick-up in any case a displacement of the pedestals by means of an electro-dynamic transducer.

By making use instead of the piezo-transducers, it is no more necessary to have any relatively elastic element. This implies that a large size balancing machine may also balance very light rotors with the same accuracy obtainable with a small size balancing machine and that wider application (stiffness) range may be obtained in comparison with semi-rigid balancing machines having same dimensions.

2 Technical specifications

Rotor characteristics			
Nominal weight capacity (see note n.1)	Min	7,5	Kg
	Max	750	Kg
Max occasional load per pedestal (see note n.2)		550	Kg
Max rotor diameter over the bedplate		1.580	mm
Lenght of the bedplate (see note n.3)		2,000	mm
Distance between support bearing centerline	Min	180	mm
	Max	1,650	mm
Rotor journals diameter range (see note n.4)	Min	10	mm
	Max	100	mm
Belt drive system			
Motor power		4.0	kW
Motor speed		1.500	RPM
Driving pulley diameter		115	mm
Max rotor driving diameter for the belt		500	mm
Instrumental measuring speed capacity (see note n.5)		90 ÷ 200.000	RPM
Machine performances			
WN ² max (see note n.6)		400 x 10 ⁶	WN ²
Unbalance measuring incertitude (see note n.7)		4	g.mm
Minimum achievable residual specific unbalance e_{mar} (see notes n.7 and 8)		0,3	g.mm/Kg
Unbalance reduction ratio with one spin only		> 95	%
Power requirements		400V/3P/50Hz	
NOTES			
1) It has to be considered as the maximum mass for rotor with symmetrical distribution of the weight between the two pedestals			
2) The occasional load per pedestals is only stated for the lowest balancing speed			
3) It is intended to be the primary bedplate lenght plus, if included in the supply, the additional bedplate lenght and the distance between the two bedplates			
4) Range is achieved with the roller carriages included in the supply.			
5) The balancing speed is defined by the ratio between the motor pulley and the driven diameter			
6) The value of WN ² it defines, based on the rotor weight, the balancing speed which gives and unbalance reduction ratio (URR based on the ISO norm ISO21940-21) of 90%. This value largely depends from the machine fixage and foundations. CEMB does not take any responsibility in case of use of the machine over the declared WN ² . Before that value, the machine can be used with the dimensional calibration. The declared value can be overrun maximum of the 50% without any risk of structural damage but in that case the dimensional calibration is no longer valid and the balancing operation has to be done with self learning calibration			
7) The declared values are valid using proving rotors based on the ISO norm ISO21940-21.			
8) The minimum achievable residual unbalance on a rotor, depends in general from the conditions of the rotor journals, from the geometrical and elastic characertistics of the rotor, from the type and wearing conditions of the belt drive, from the rotor weight, from the balancing speed and signal filtering.			

3 Machine composition

3.1 Cast-iron bedplate

Cast-iron bedplate where pedestals and the relative roller carriages are lodged.

- Bedplate length 2000mm

3.2 Additional cast-iron bedplate

Bedplate with the same characteristic features of the main one to be placed detached to process long rotor. One of the pedestals has to be shifted from the main bedplate and placed according to the length of the piece to be balanced.

- *(Optional) Additional bedplate length 2000mm*

3.3 Hard bearings pedestals

The hard bearings pedestals can accommodate all the equipment where the rotor to be balanced is placed. The piezo-electric force transducers are fitted inside the pedestals.

- N. 1 right pedestal
- N. 1 left pedestal

3.4 Roller carriages

The roller carriages are composed of a plate with a couple of rollers sized in thickness and diameter in order to process rotors within the entire machine range application. Rollers are crowned on the external diameter with the aim to maintain undamaged the surface of the rotor journals and to avoid the generation of axial thrust that can influence the unbalance reading.

There must be a +/- 5% variation in the ratio between the diameter of the rotor journals and the diameter of the rollers on the carriages (the ratio can't be equal, multiple or submultiple) in order to avoid instability of the readings especially at low unbalance values.

- N. 2 Roller carriages for journals d. 10-100 mm / Rollers d. 110x18mm

3.5 Safety hold down

A vertically adjustable safety hold down is mounted at the top of the pedestal so as to limit and contain any eventual shake of the rotor in case of excessive high unbalance.

- N. 2 Fiber safety brackets for carriages d. 20-60mm and 10-100mm

3.6 Underslung belt drive system

This comprises a motor with speed regulation by frequency converter, fitted on a slide adjustable along the bedplate and by an idle pulley system fitted on the same slide, so as to allow rotor driving by means of a flat belt.

Belt tensioning is obtained through manual hand wheel or an air-operated piston with manual control.

Different size belts are supplied in order to cover a range of diameters over which belt can drive.

It is also supplied a cross upright with the photocell (or no contact sensor if supplied) for the unbalance phase detection and proper synchronization and filtering of the signal.

The photocell can read a phase reference mark done on the rotor with a felt pen, reflective tape or either by chalk.

A couple of axial stopper with bearing installed on each pedestal, secure the rotor from any axial displacement during the unbalance reading.

- Underslung belt-drive 4kW - belt tensioning by hand

3.7 Power and measuring cabinet

Containing the machine power portion, the drive for motor and the measuring unit.

The cabinet is connected to the mechanical unit by means of a reinforced flexible cable, thus making installation and displacement of the machine very easy and quick.

The power cabinet is made according to E.C. regulations.

- Rack control cabinet with dimensions h1680x600x600mm

3.8 Measuring instrumentation

The measuring chain is entirely produced by CEMB with a proprietary software and electronic PCBs designed and developed in house.

The CEMB industrial PC has the main following characteristics:

- Operating System: Windows 10 Embedded with Enhanced Write Filter (EWF)
 - RAM memory: 4 GB
 - IP66 protection
-

- Ethernet port (for the connection to a network, it must be used on IP address different than 192.168.1.xxx as this is used for internal connections) + front USB port
- Large TFT colour LCD with large luminosity: 15 inch
- 2 simultaneous measuring channels
- Touch-screen that makes the rotor recipe setup especially fast and easy.

The main characteristics of the software are the following ones:

- 999 balancing programs memory with fast search database system and with possibility of direct backup on a USB key
- setting of direct or ISO or API balancing tolerances, referred to real or false planes
- setting both of different measuring units and different unbalance measuring
- indication of the unbalance angular position with an analogic display connected to the rotor position
- displaying and storing of the values obtained in several measures so as to verify possible deformations or rotor variations when in rotation
- possibility to print balancing certificated in HTML format to be saved into a USB key and then to be printed.

The use of C-Fast disk memory modules, makes the system more fast and reliable to work into an industrial environment.

3.8.1 Measuring instrumentation B11

For the B11 there are available a series of additional optional softwares that facilitate a lot the machine operator for both unbalance correction as well as the machine calibration check-up and certification.
(More detailed characteristics on the enclosed brochure).

3.9 Electronic position repeater of unbalance angle

Composed of a position transducer e elaboration core (mounted in the measuring unit), has the function to show, with high precision, the position of the rotant when in rotation by hand.

That instrument enable to easily find the position to correct the imbalance also with the help of the video markers: when the rotor is almost in position, the pointer turns yellow and once the position is reached it turns red so showing the exact point where add or remove weight.

3.10 Tunnel guard sliding on floor-mounted rails

According to EU Directives and with special reference to what defined in the release currently in force of the "Machinery Directive 2006/42/CE", the machine cannot absolutely be operated without a suitable accident prevention safety guard.

The safety guard is "Tunnel" type, "C" class, sliding on floor-mounted rails allow the load and the unload of the rotors to be balanced: opening and closing is manually done by the machine operator. Sample drawing is in attachment to the offer.

The details here below are referred to the number of sliding pieces, the length of the bedplate, the max rotor diameter, the protection class "C", the sense of opening and any other additional details.

- Safety guard 1/2000/1580mm, TC, C300, Lh

3.11 Micro safety switch (E.C. directives)

The machines is equipped with a micro-switch that allow guard opening only once the rotor is completely stopped. The same system doesn't allow the start if the guard is incorrectly closed.

- Single micro safety switch

3.12 Paint

- Machine and safety guards: GREY RAL 7035
- Electrical cabinet: GREY RAL 7035 with lateral red bands RAL3020

3.13 Documentation

Will be supplied on electronic PDF format (USB driver).

- EC Conformity Declaration (in one of EC language) only for countries in the EU,
- Introduction booklet (in one of EC language)
- Base Instruction manual (in one of EC language)
- Operator's manual (in one of EC language)
- Measuring manual (available languages: Italian, German, French, English, Russian, Spanish, Portuguese, Chinese, Swedish, Czech)
- Technical annexe just in Italian or English
- Wiring diagrams, EPLAN format (Italian or English)
- Mechanical assembly drawings, DXF format (Italian or English)

In case the machine has a PLC the list of it will be supplied in Italian (eventual translation shall be at extra price).

3.14 Machine accessories

Together with the machine we will supply the following accessories:

- Belt set to cover the operating range of machine
- Wrenches for fixing pedestal and carriages
- Plasticine for balancing test
- Elements for fixing the machine to the floor
- Detailed instruction manual

3.15 Commissioning

One of our technician will come to your plant where the machine is installed to put it into service and to show your operator how to use it properly.

Before his arrival, the machine must be correctly fixed on the floor according to the instructions we will send you with the machine documentation, the safety guard properly installed and electrical / pneumatic connections (if required) already done.

- *(Optional) Machine commissioning*

3.16 Packaging

The machine, properly protected with grease on exposed areas, will be fixed on a wooden base and envelopped with with shrink-wrapped cellophane. Dessiccants salts will be placed inside the pack to avoid any humidity formation.

The base can be moved either by means of the forklift or overhead crane.

Final weight and dimensions will be given once the machine is packed.

4 Exclusions

We intend excluded from the supply everything not clearly mentioned, in particular the following:

- foundation and generic civil work
- fixage of the machine on the floor / foundation
- wirings and piping to the main sources



Dott. Ing. M. Biffi

A handwritten signature in black ink, appearing to read 'M. Biffi', with a stylized flourish at the end.
