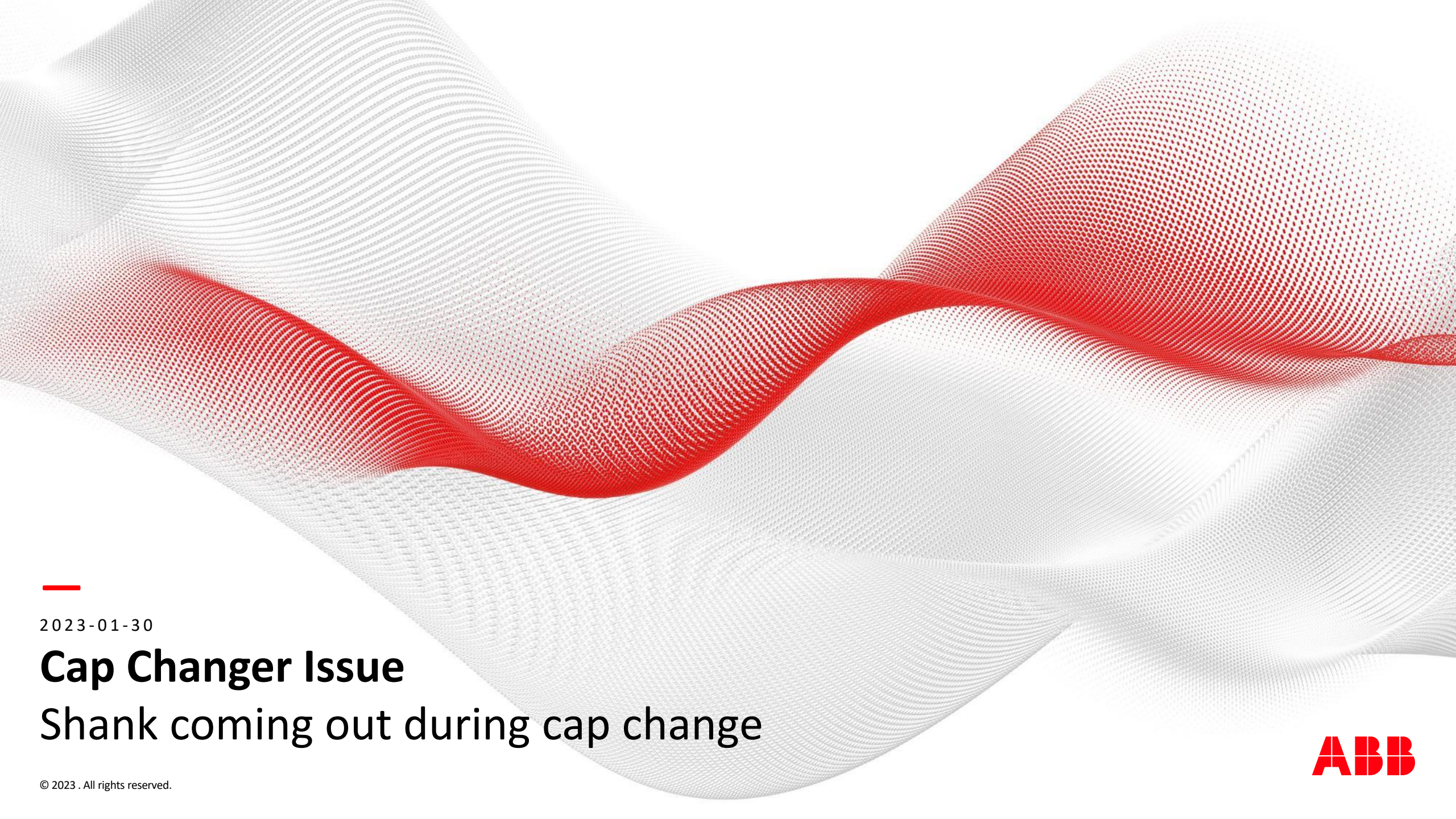


2023-01-30

Cap Changer Issue

Shank coming out during cap change

ABB supplied Tip / Cap & Shank drawings:

2 HÄTTA B

KRAV

Material

Koppar A2/2 - ISO 5182

Dimensioner

2 ELECTRODE CAP B

REQUIREMENTS

Material

Copper A2/2 - ISO 5182

Dimensions

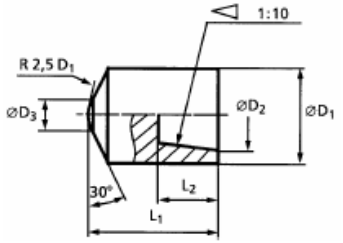


Fig 1

Tabell / Table 1

D_2	Kontolk Taper plug gauge
10	
12	9003794
15	9003795

Tabell / Table 2

D_1 h11	D_2	D_3	L_1 ±0,5	L_2 +0,5 0	Artikelnr Part No.
13	10	5	18	8	3045707 X
16	12	6	20	9,5	9003872 X
20	15	8	22	11,5	9003873 X

Picture-1

3 SKAFT FÖR HÄTTA Ø16

KRAV

Material

Koppar A2/2 - ISO 5182

Dimensioner

3 ADAPTOR FOR CAP Ø16

REQUIREMENTS

Material

Copper A2/2 - ISO 5182

Dimensions

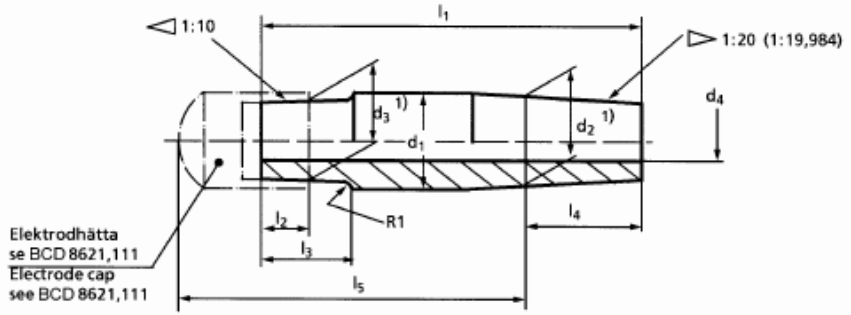


Fig 2

Tabell / Table 3

d_1 h11	d_2 1)	d_3 1)	d_4	l_2 ±0,5	l_3	l_4 ±0,5	Ringtolk Taper ring gauge d_2	Ringtolk Taper ring gauge d_3
16	15,8	12	8	8	13	18	9003793	9003796

Tabell / Table 4

l_1	l_5	Ritningsnr Drawing No.	Artikelnr Part No.
42	36	9931378	9931378 X
48	42	9931378	9931379 X
54	48	9931378	9931380 X
61	55	9931378	9931381 X
74	68	9931378	9931382 X
86	80	9931378	9931383 X
99	93	9931378	9931384 X
112	106	9931378	9931385 X
131	125	9931378	9931386 X

Picture-2

4 SKAFT FÖR HÄTTA Ø20

KRAV

Material

Koppar A2/2 - ISO 5182

Dimensioner

4 ADAPTOR FOR CAP Ø20

REQUIREMENTS

Material

Copper A2/2 - ISO 5182

Dimensions

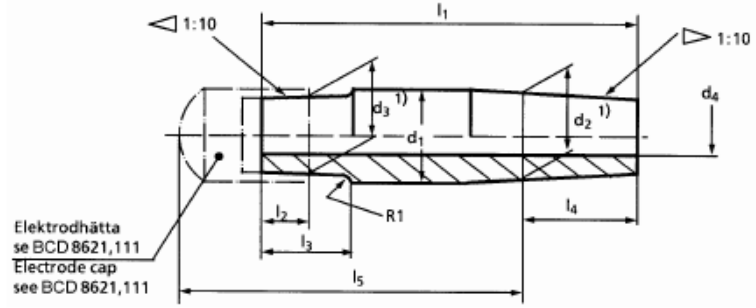


Fig 3

Tabell / Table 5

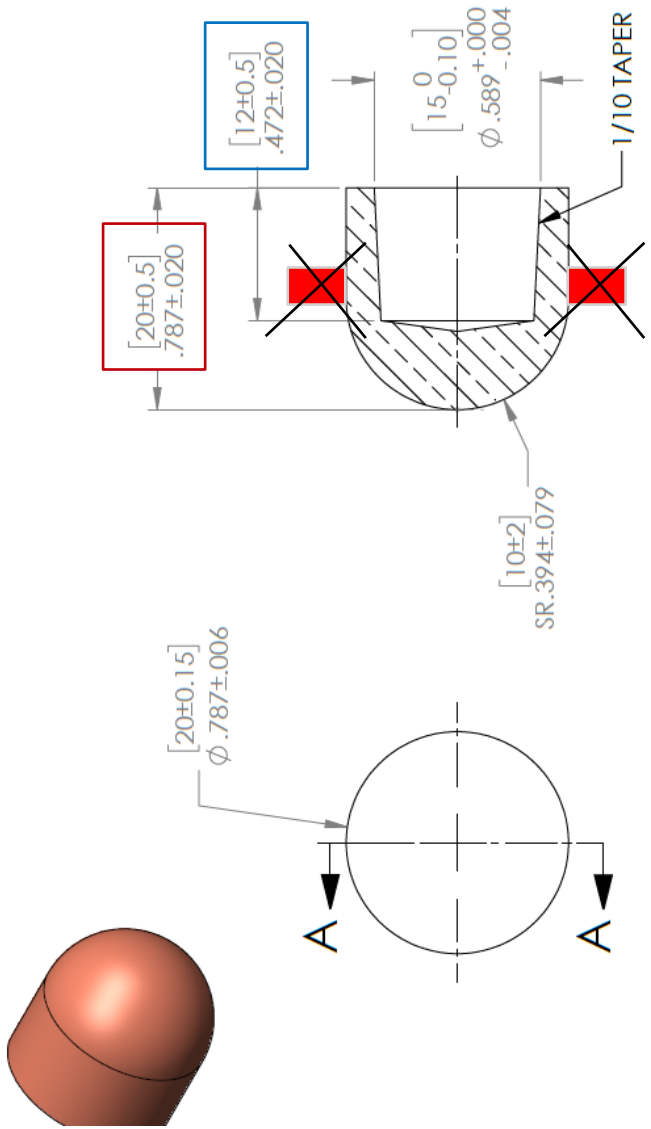
d_1 h11	d_2 1)	d_3 1)	d_4	l_2 ±0,5	l_3	l_4 ±0,5	Ringtolk Taper ring gauge d2	Ringtolk Taper ring gauge d3
20	19	15	10,5	10	15	25	9003786	9003797

Tabell / Table 6

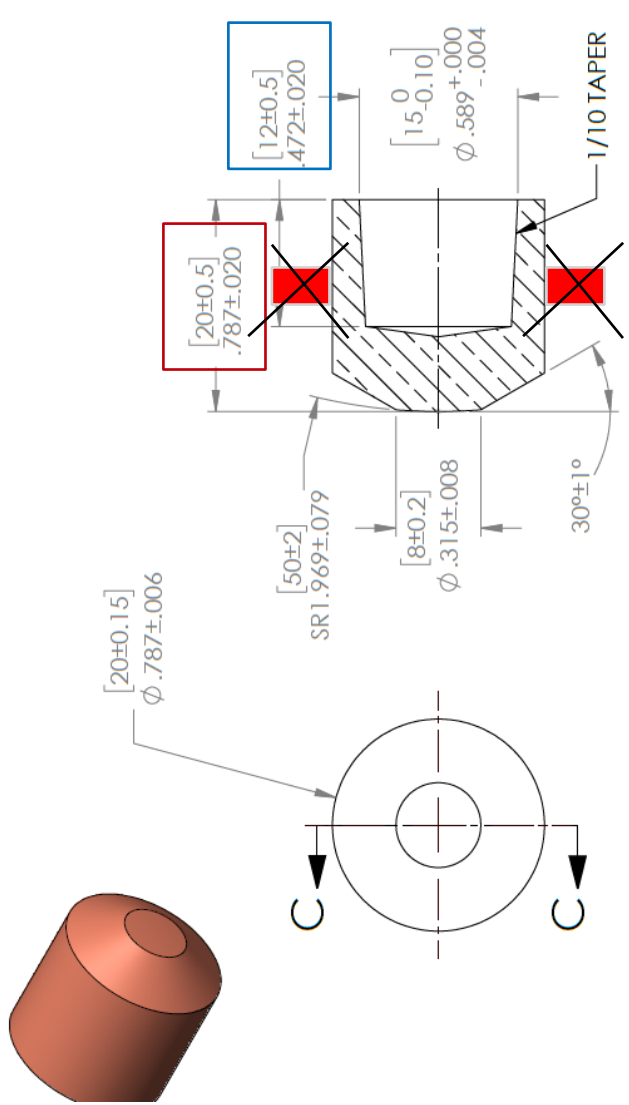
l_1	l_5	Ritningsnr Drawing No.	Artikelnr Part No.
54	41	9931387	9931387 X
60	47	9931387	9931388 X
66	53	9931387	9931389
73	60	9931387	9931390 X
86	73	9931387	9931391 X
98	85	9931387	9931392 X
111	98	9931387	9931393 X
124	111	9931387	9931394
143	130	9931395	9931395 X

Picture-3

Valiant supplied Tip / Cap drawings: key variations that are affecting the cap change process



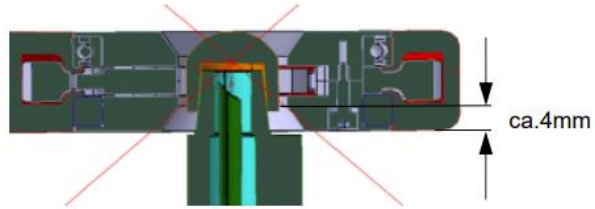
Picture-4

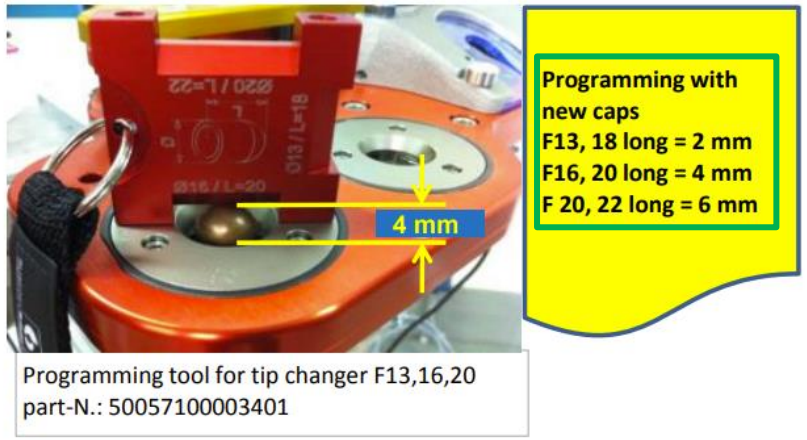


Picture-5

To be changed to 22±0.5 for Ø20 & 20±0.5 for Ø16 to give enough room for Tip changer jaws to grip during tip change

To be changed to 11.5+0.5/0 for Ø20 & 9.5+0.5/0 for Ø16





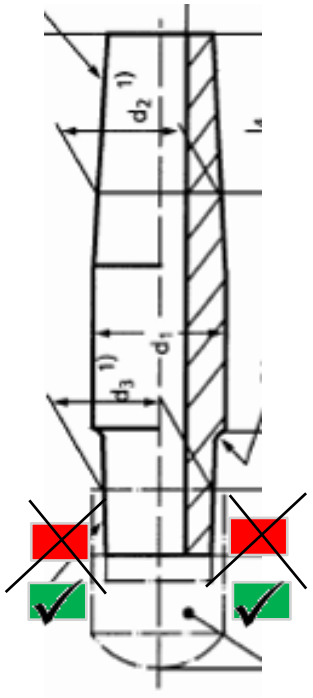
Programming tool for tip changer F13,16,20
part-N.: 50057100003401

Picture-6

Action plan for ABB: -

1. ABB will prove tip changer only with ABB supplied tips/caps.
2. ABB will use the new tips/caps for the setting.
3. Shank should be at 90° w.r.t. the cap changer surface for the straight shanks.
4. Cap positioning & the cap placing should be as per picture-6. Measure the dimension (2, 4 & 8) using vernier caliper.
5. Cap changer jaws should not squeeze the cap & shank mating surface, means cap changer jaws should only squeeze the cap using solid area instead of hallow area.

6. Volvo✓ & Valiant to establish the Tip/Cap dress frequency & also Tip/Cap change frequency considering the picture-6 parameters.




ABB