

# PPC 250 R3,5,6

Cladding machine (PTA method)

**KEEP  
SURFACE  
KEEN**

PPC 250 R (3,5,6) is suitable for hardfacing of rotary and non rotary parts, on the circumference, on the face (R5 and R6, -R3 only rotating part-) and it is also possible to hardface internal diameters from minimum inner diameter of 50mm.

It is variable where possible (according to customers order) this machine is fitted with 3 control axes (R3), 5 control axes (R5) and 6 control axes (R6) and according to how many axes the machine is automatically set for what application it is suitable for.

In the maximum setup (6 axes) it is top of the range according to present trends.

Suitable for applications with maximum load of 30kg.

This machine is

smaller than previous machines offered by KSK.

It is a more compact device.

The hardfacing process is realized in a close (secure) working area and it is possible to control this process directly through the window, equipped with welding glass.

It is also possible to have the machine fitted with an extractor (for waste gasses).





**Control system**

with 15" XGA touch screen mounted in an airconditionated box fitted with B&R system and our own SW developed by KSK.

Programing of the machine is provided in easy dialog or by method teach-in in cooperation with remote control.

With all our machines it is possible to control and carry out diagnostics via internet.



**Powder feeder**

Providing steady regulated delivery of powder to the torch.

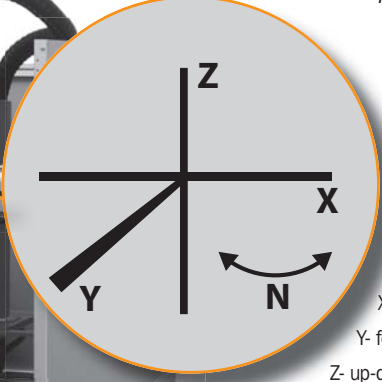
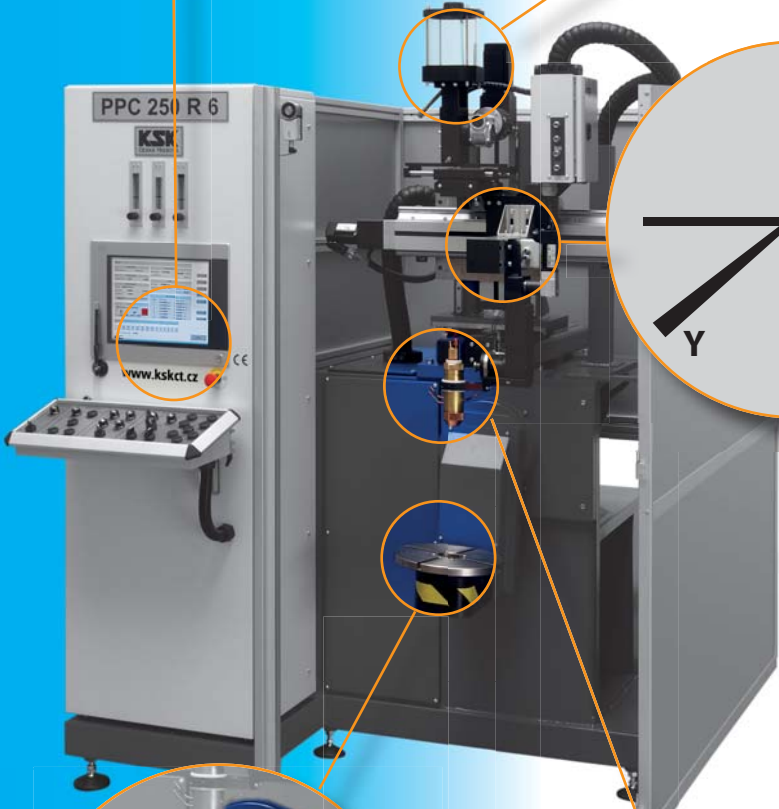
From the feeder the powder delivery is gas assisted.

It is also possible to have the feeders calibrated directly from a special program and calibrate feeder in whole spectrum of feeding.

In base configuration the machine is fitted with only one feeder but it is possible to have an additional feeder fitted.

Load of feeder - 10 kg of powder.

Recommended granularity of the powder - 50-200  $\mu$ m.



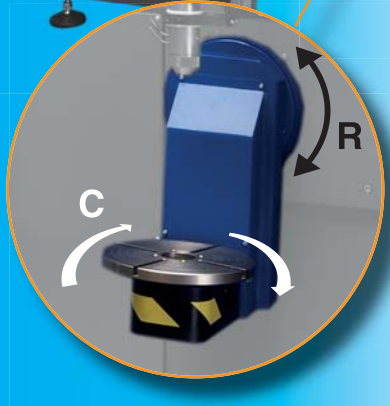
**Feed range of torch**

(realised by digital servo motors)

|                         | R3     | R5     | R6     |
|-------------------------|--------|--------|--------|
| X- right-left           | 490 mm | 490 mm | 490 mm |
| Y- forward-backward     | NA     | 260 mm | 260 mm |
| Z- up-down              | 260 mm | 260 mm | 260 mm |
| N- tilting of the torch | NA     | NA     | 40°    |

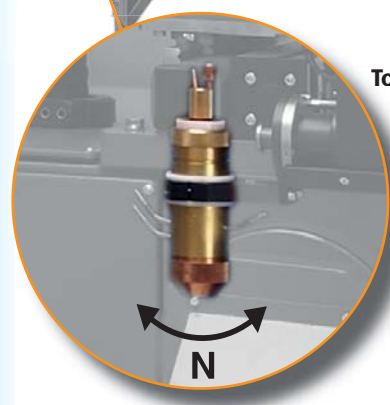
**Oscillation**

- R3 - width of up to 200 mm during rotation of the positioner
- R5 and R6 - oscillation, it is possible to use within width of up to 200 mm in X as well as in Y and also between two spots in space. By synchronising movement of all participating axes



**Positioner** (realised by digital servo motors)

|                                 | R3       | R5, R6 |
|---------------------------------|----------|--------|
| R- tilting                      | Manually | Yes    |
| C- rotation                     | Yes      | Yes    |
| Diameter of the face plate      | - 300 mm |        |
| Load weight of positioner up to | 30 kg.   |        |



**Torch**

According to the shape of hardfacing parts and type of powder.

We produce 7 types of torch developed by KSK. Torch and anode are cooled at optimal temperature.

**Dimensions (W x L x H): .....1.770 x 1.700 x 2.185 mm**

**Weight: .....1100 kg**