



Data sheet CIG Compact Duplex TMS

Connected loads	Electrical connection	230/400V +10%/-15%, 50/60 Hz, 3PNE
	Total connected load	≥31.7 kVA
	Pre-fuse (on-site)	3 X 35 A slow-blow
	Compressed air	<ul style="list-style-type: none"> • Connection: 1/4" • Rating: 5 - 6 bar constant • Quality: filtered 5μ • Consumption: about 0.16 m³/h production-dependent
	Exhaust air at the fluxer	<ul style="list-style-type: none"> • Connection 2 x Ø 120 mm • Rating about 800 m³/h
	Inert gas	<ul style="list-style-type: none"> • Connection: 1/2" inner thread • Rating: 7 bar constant • Consumption: 15-20 m³/h production-dependent
Transport	Transport speed	<ul style="list-style-type: none"> • Carrier transport: 0.5 - 2.5 m/min
	Transport angle above waves	<ul style="list-style-type: none"> • Carrier transport: 7° fixed
Fluxer	Atomizer fluxer control	Width in 9 stages / quantity continuous
Preheater	IR-pre-heater rating	<ul style="list-style-type: none"> • CIG 300/400/500 compact = 9 X 1.2 = 10.8 kVA
	Carbon/Hybrid-pre-heater rating	<ul style="list-style-type: none"> • CIG 400/500 compact = 6 x 0.9 + 6 x 0.8 = 10.2 kVA
	Length	<ul style="list-style-type: none"> • 1150 mm
	Temp. measurement PCB	<ul style="list-style-type: none"> • Infrared temperature measurement on the underside of the PCB • Passage temperature measuring instrument
	Inner temperature	continuously regulated
Solder bath	Solder bath heating	12 x 1.0 = 12.0 kVA
	Solder bath auxiliary heating	4 x 0.5 = 2.0 kVA
	Solder bath temperature	230° - 280°C
	Solder pot content	<ul style="list-style-type: none"> • CIG 300/400 compact = 380 – 450 kg *) x2 • CIG 500 compact = 550 -650 kg *) x2 *) it depends on the alloy
	Heating time of the solder	450 kg bath about 180 min. / 650 kg bath about 200 min
	Automatic solder replenishment	Solder wire Ø 6 mm, coil Ø 305 x 110 mm
	Solder wave height hollow wave	30 mm
	Solder wave height full wave	4 – 9 mm
	Solder wave width	300 = 320mm / 400 = 420mm / 500=520mm
	Distance between the peaks	70 mm / 100 mm
	Stability of solder bath temp.	± 1 °C
Inert gas	Permanent measurement	0-100 ppm, 0-1000 ppm, autom. regulation
	Gas used	Nitrogen
	Cleaning	Condensate trap (Option)
Controller	Robotronix controller	PC / MIS
Other	Continuous noise level	< 65 dB(A)
	Residual power consumers	1.3 kVA
	Dimensions of the machine	<ul style="list-style-type: none"> • CIG 300/400 compact = 4,44 x 2,98 x 1,10 m • CIG 500 compact = 4,44 x 3.28 x 1,10 m
	Weight of the machine	about 1100 kg (without solder filling)
	Color	Gray white RAL 9002