



Data sheet CIG HighSpeed Duplex TMS

Connected loads	Electrical connection	230/400V +10%/-15%, 50/60 Hz, 3PNE
	Total connected load	≥ 33 kVA
	Pre-fuse (on-site)	3 X 50 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 exit	<ul style="list-style-type: none"> • Connection 1 x Ø 120 mm • Rating about 5 m³/h
	Exhaust air at the fluxer	<ul style="list-style-type: none"> • Connection 1 x Ø 120 mm • Rating about 50 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	• Carrier transport: 0.5 - 2.5 m/min
Fluxer	Atomizer fluxer control	Width in 9 stages / quantity continuous
Preheater	IR-pre-heater rating	<ul style="list-style-type: none"> • CIG 300= 12 X 1.2 = 14.4 kVA • CIG 400/500/ = 12 x 1.35 = 16.2 kVA
	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 kW
	Solder bath auxiliary heating	4 X 0.5 = 2.0 kW
	Solder bath temperature	230° - 280°C
	Solder pot content	CIG 300/400 = 380 - 450 kg *) x2 CIG 500 = 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 305x110 mm
	Solder wave height hollow wave	5 - 40 mm
	Solder wave height full wave	4 - 9 mm
	Solder wave width	300/320=320mm / 400/420=420mm / 500=520mm
	Distance between the peaks	70 mm / 100 mm
	Stability of solder bath temp.	± 1 °C
Inert gas	Permanent measurement	0-99 ppm, 0-1000 ppm, autom. regulation
	Gas used	Nitrogen
	Cleaning	Condensate trap
Controller	Robotronix controller	PC / MIS
Other	Continuous noise level	< 65 dB(A)
	Residual power consumers	1.5 kVA
	Dimensions of the machine	<ul style="list-style-type: none"> • CIG 300/400 = 7270 x 2930 x 1100 mm • CIG 500 = 7270 x 3030 x 1100 mm
	Weight of the machine	about 1050 kg (without solder filling)
	Color	Gray white RAL 9002
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