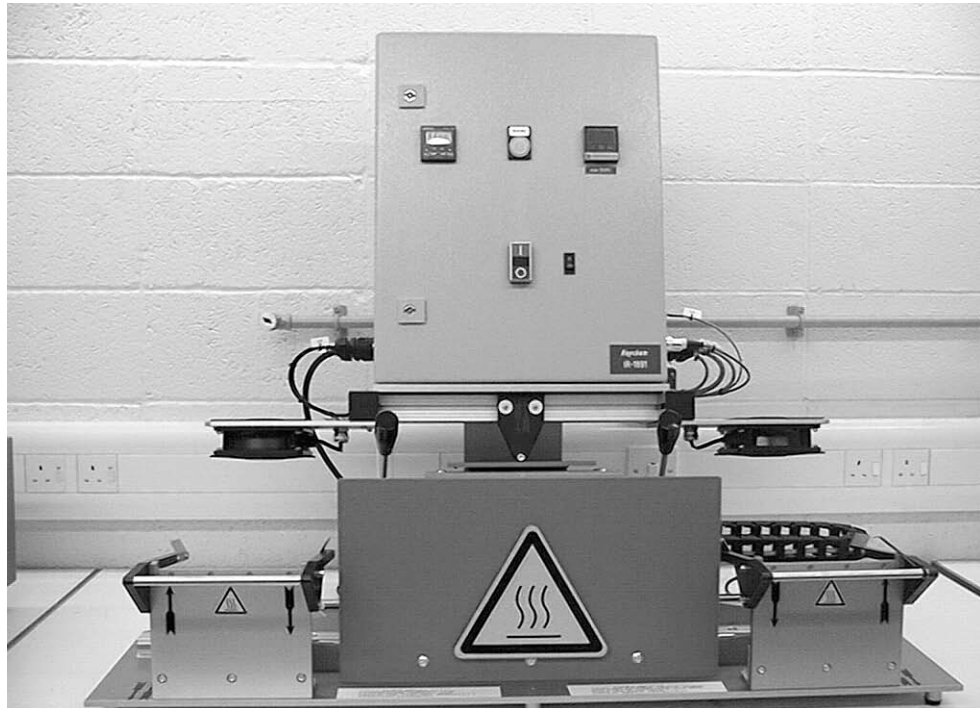


IR-1891

Heating Work Station for Short Length Tubing

Product Facts

- Automatic cycle start once heater is manually positioned over product, which gives improved process control (recommended for adhesive-lined heat-shrinkable tubing e.g. sealing applications)
- Automatic heating head retraction at end of cycle prevents damage to components
- Multiple product fixture assemblies give increased process rates
- Cooling fan above each fixture assembly maintains holding fixture at an acceptable temperature



Applications

The IR-1891 is suitable for the installation of a range of Raychem heat-shrinkable tubing products onto a variety of small components, e.g. ring terminals, Faston terminals and small connectors etc. The machine is provided with two work stations and a moveable heating head.

Each workstation is provided with supports for tooling fixtures (which must be specified and ordered separately). These support the workpieces and locate the tubing products. The operator loads the workpieces into the fixtures at one of the workstations, ensures that the tubing product is correctly positioned and then slides the heat head into position

before initiating the heating cycle. The operator then continues with loading/unloading the other work station whilst the heating cycle is taking place.

The IR-1891-220V-Shuttle-Retrn is provided with closed loop temperature control and in addition the heat head is 'locked' into position by use of an electromagnet during the heating cycle.

Once the other workstation has been loaded and the first installation is complete, the heat head is moved into position over the product and the next heating cycle initiated. Heating times vary typically from 3 to 30 seconds depending on the size and type of tubing product. Process rates up to 1200 pieces/hour can be achieved depending on the

heating time and the time taken by the operator to load and unload the workpieces. The installation temperature/power can be varied according to product type/size and required cycle times.

The heating elements, which are continuously energized, are of the infra-red medium wave length type and consist of a coiled resistance wire contained in quartz glass tubes. The closed loop temperature control uses similar elements but having integral thermocouple sensors.

Available in:	Americas	Europe	Asia Pacific
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IR-1891 (Continued)

Technical Specifications

Electrical Supply	230 V Single Phase
Power Consumption	1600 W
Operating Temperature	650°C max
Process Rate	1200 / hour maximum depending on application and operator
Heating Times	3 to 30 seconds depending on application
System Noise	< 70 dB
Dimensions – 508636-000	L1100 x H650 x D500 mm [L43 x H25 x D20 in]
Dimensions – 613148-000 / 167309-000 / 289588-000	L1100 x H900 x D500 mm [L43 x H35 x D20 in]
Base Plate Dimensions 289588-000 / 167309-000	L1040 x D450 mm [L41 x D18 in]
Base Plate Dimensions 613148-000	L1040 x D397 mm [L41 x D16 in]

Product Range

Wide range of Raychem tubing products in particular LSTT, RNF-3000, RNF-100, HTAT, ATUM.
Maximum diameter 20 mm [0.8 in] and maximum length 60 mm [2.0 in]

Ordering Information

Description	Part No.
*IR-1891-220V-Shuttle-Retrn	289588-000
*IR-1891-220V-Retrn-Syl	613148-000

***Note:** The descriptions given here DO NOT include the supply of the necessary tooling fixtures. These are designed for each individual application.

Accessories

Description	Part No.
Grippers:	
IR-1891-SI-GRP-165-RD-1mm	Red Gripper with 1mm hole 629602-000
IR-1891-SI-GRP-165-CL-2mm	Clear Gripper with 2mm hole 112676-000
IR-1891-SI-GRP-165-BK-3mm	Black Gripper with 3mm hole F83221-000
IR-1891-SI-GRP-165-WT-6mm	White Gripper with 6mm hole 629602-000
Fixtures:	
IR-1891-Quick-Rel-ESS-6/1	ESS Cap (6/1) Fixture 096735-000
IR-1891-Quick-Rel-ESS-8/2	ESS Cap (8/2) Fixture 148597-000
IR-1891-Tool-Fixt-Bas-ESS	Base Unit for Fixtures 760221-000

Note: A wider range of tooling fixtures and grippers designed for previous applications are available. Please contact Tyco Electronics for details.