

DESIGN

The device complies with the standards:

- 2014/35/EU – Low Voltage Directive
- 2014/30/EU – Electromagnetic Compatibility Directive
- 2011/65/EU – RoHS

A safety contact in the control unit can be used to prevent machining of the workpiece if the voltage unit is not switched on.

Manually actuated with illuminated push-buttons. The optional connection to a CNC control uses a 24 V signal voltage.

A stepped holding force control is integrated as a standard. It can be controlled with a coding switch.

When using the lower levels of the holding force control, it must be noted that safety as per the accident prevention regulations is no longer ensured. The enabling level can be adjusted, however, and must be adapted to the workpiece.

Ambient temperature max.: 45 °C

Power supply: 230/400 V DC

Frequency: 50/60 Hz

Duty cycle for electromagnets: 100 %

APPLICATION

For electromagnetic workholding devices. Also suitable for retrofitting.

FUNCTION

Electronic polarity reversal control units supply electromagnetic workholding devices with direct current. In addition, the integrated polarity reversal device and microcontroller reduce the residual holding force between the magnetically held workpieces and the workholding device caused by remanence. This makes it easier to remove the workpieces from the magnetic chuck and to remove any swarf generated. At the same time, the residual field strength in the workpiece is dissipated almost completely.

For parts which are particularly difficult to magnetise, the controller offers a number of advanced polarity reversal programs. When ordering a magnetic chuck and polarity reversal control unit together, you will of course receive optimised settings for time and magnetic action.

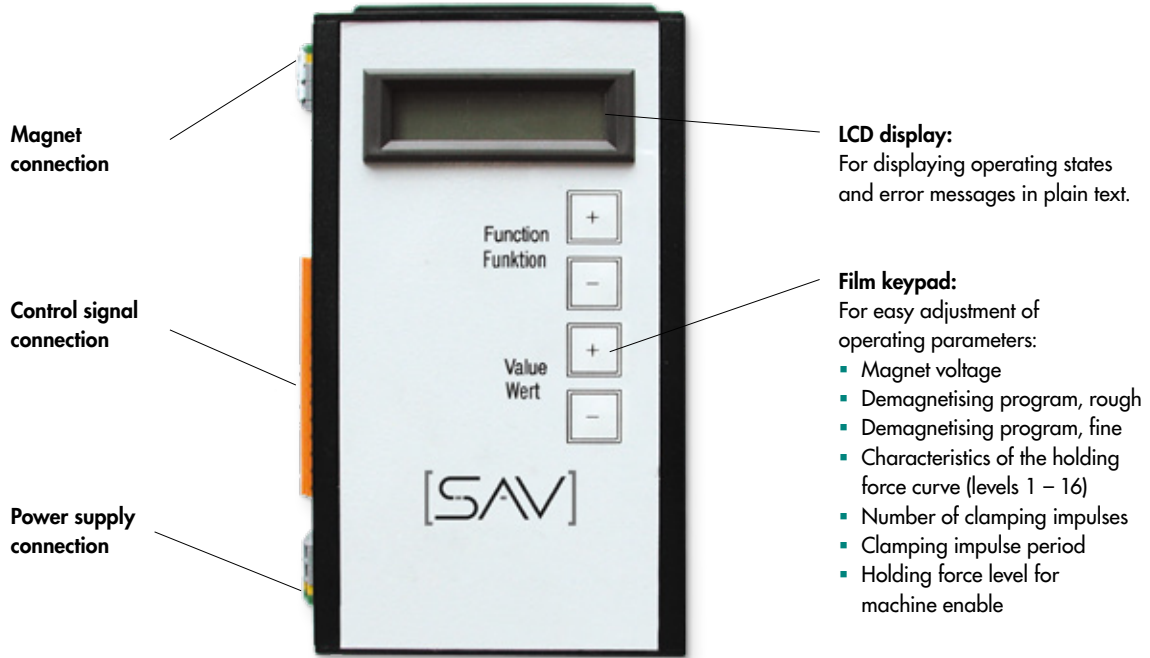
For your safety, the device permanently monitors the power source, its own power components and all connecting cables including the magnetic coil. An LCD display acts as a signal generator.

**PERFORMANCE CHARACTERISTICS**

- Small and compact
- Can be integrated into any machine control cabinet
- User-friendly with LCD plain text display and film keypad
- Universal for all magnet types and voltages
- Reliable and safe operation

**ELECTRICAL DATA**

Order number	Type	DC in V	max. in A	AC in V	DC in kW	A	Mains transformer required
	Control	Magnet voltage	Magnet current	Power supply	max. magnetic power	Fuse	
876.10 -_- T-24 / 7 / 230	E 1	24	7	230	168	4	yes (T)
876.10 -_- T-24 / 15 / 230	E 2	24	15	230	360	6.3	yes (T)
876.10 -_- T-24 / 25 / 230	E 3	24	25	230	600	6.3	yes (T)
876.10 -_- O-110 / 6 / 230	E 4	110	6	230	660	4	no (O)
876.10 -_- O-110 / 16 / 230	E 5	110	16	230	1760	16	no (O)
876.10 -_- O-110 / 30 / 230	E 6	110	30	230	3300	25	no (O)
876.10 -_- T-110 / 6 / 400	E 7	110	6	400	660	4	yes (T)
876.10 -_- T-110 / 16 / 400	E 8	110	16	400	1760	16	yes (T)
876.10 -_- T-110 / 30 / 400	E 9	110	30	400	3300	25	yes (T)



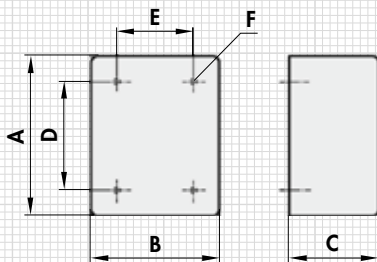
GEOMETRIC DATA

Control cabinet version (S) protection rating IP 54

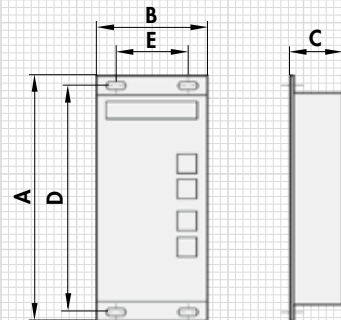
Order number	Type	mm						kg
		Contr.	A	B	C	D	E	
876.10-S-T-24/7/230	E 1	250	400	150	205	355	∅10	14.0
876.10-S-T-24/15/230	E 2	250	500	150	205	455	∅10	20.0
876.10-S-T-24/25/230	E 3	500	400	250	455	355	∅10	32.0
876.10-S-O-110/6/230	E 4	300	250	155	260	210	∅8	10.0
876.10-S-O-110/16/230	E 5	250	400	150	205	355	∅10	14.0
876.10-S-O-110/30/230	E 6	250	400	150	205	355	∅10	16.0
876.10-S-T-110/6/400	E 7	500	400	250	455	355	∅10	28.0
876.10-S-T-110/16/400	E 8	500	400	250	455	355	∅10	38.0
876.10-S-T-110/30/400	E 9	600	400	250	555	355	∅10	54.0

Installation version (E) protection rating IP 00

Order number	Type	mm						kg
		Contr.	A	B	C	D	E	
876.10-E-T-24/7/230	E 10	220	120	95	210	85	∅5	2.0
876.10-E-T-24/15/230	E 11	260	120	95	250	85	∅5	3.0
876.10-E-T-24/25/230	E 12	320	120	95	310	85	∅5	6.0
876.10-E-O-110/6/230	E 13	220	160	95	210	85	∅5	2.0
876.10-E-O-110/16/230	E 14	260	160	95	250	85	∅5	3.0
876.10-E-O-110/30/230	E 15	350	160	100	325	225	∅8	8.0
876.10-E-T-110/6/400	E 16	220	160	95	210	85	∅5	2.0
876.10-E-T-110/16/400	E 17	260	160	95	250	85	∅5	3.0
876.10-E-T-110/30/400	E 18	350	160	100	325	225	∅8	6.0



Dimensional drawing for control cabinet version (S)



Dimensional drawing for installation version (E)

ORDERING EXAMPLE

Designation	SAV no. - version - mains transformer - rated magnet voltage/max. magnet current/power supply
Electronic polarity-reversing control unit	SAV 876.10 - E - O - 110/6/230