SPECIFICATION NUMBER HF004-0000-01

TITLE : GROUP BURNING JIG (FOR DIN & BS TUBULAR CELLS)

MACHINE REFERENCE NUMBER HF004-0000

1.0 PROCESS

Group burning of Din and BS motive power tubular cells.

2.0 DESCRIPTION

The jig comprises a support stand, jig box and top burning irons.

The stand consist of a base plate mounted on 4 adjustable stainless steel feet.

A support frame for carrying the burning jig is attached to the base plate via a central screw, which allows the frame/jig box to be rotated and also the working height to be adjusted to suit the operator.

The jig box is designed to align and hold the plates/separators during the burning operation and can pivot about the support frame to facilitate easy loading of the plates and separators. The box has a moveable bottom plate which can be set to suit various plate heights, also a screw operated clamp is fitted on the end of the box to clamp the elements together during burning.

Top burning irons comprising combs and dam irons fit on top of the jig box and position the plate lugs and terminal straps.

3.0 OPERATION

The jig is operated within a ventilated assembly booth to give a safe working environment. Plates and separators are fed to the operator on roller conveyors positioned on each side of the jig. The jig is loaded by hand with the jig in an inclined position and then swung back into the vertical position. The top irons are positioned, straps located and the groups burned up using a hand burning torch. After burning the top irons are removed and the elements are removed by hand or by powered hoist depending on the size, transferred to the boxing position and lowered into the container.

4.0 OUTPUT

Depending on the size and number of plates in the group, an average of approximately 100 groups/shift can be obtained.

5.0 SERVICE REQUIREMENTS

Burning Torch - Butane gas 0.2 M3/hour.
(or equivalent)

Oxygen 0.25 M3/hour

Hoist (electrical) 0.5 kW at 38OV 3PH 50 Hz.

6.0 SPACE REQUIREMENT

The complete jig with feed conveyors and ventilated assembly booth will occupy a floor space of approximately 1.7 M x 1.7 M x 2.7 M high.

7.0 GENERAL COMMENT

A suitable fan/exhaust system will be required suitable for an air flow of approximately 9000 M3,/hour from the assembly booth.