ASSEMBLY BENCHES FOR TRANSFORMER’S CORE

TARGET

The BNI allows to assemble main cores for distribution transformer with Step Lap and no Step Lap system, for sheets with holes and not. The BNI T1 allows to assemble main cores for distribution transformer mainly ranging from 50 to 1,000 Kva, the BNI T3 from 160 to 4,000 Kva and the BNI T5 from 160 to 10,000 Kva. With the use of the present core assembly benches, the core is assembled without the top leg, to allow the insertion of the transformer coils.

MAIN FEATURES

The advantages of using the BNI assembly benches result in:

- **Fast assembling work**, because the operator finds all the necessary positioning references during insertion of the sheets;
- **Reduced losses**, because core is assembled more precisely and not damaged during tilting and unloading phase;
- **Reduce set-up time**, by handwheel & measuring instruments.

Different cores can be assembled in the following way:

1. Using central pins for Step Lap reference in sheets with holes
2. Using side guides for references in sheets without holes
CORE ASSEMBLY BENCHES COMPOSITION

MAIN MACHINE:
(a) Vertically pivoting table through hydraulic cylinders
(b) N. 6 adjustable side guides with measuring instruments
(c) N. 8 reference pins with height adjustment
(d) N. 3 top legs reference
(e) Supporting system to extract completed core after assembly
(f) Hydraulic unit for tilting
(g) Control panel

ACCESSORIES:
(1) N. 7 heads (2 for each leg, 1 for central leg and 2 for bottom yoke)

TECHNICAL DATA

<table>
<thead>
<tr>
<th></th>
<th>BNI T1</th>
<th>BNI T3</th>
<th>BNI T5</th>
</tr>
</thead>
<tbody>
<tr>
<td>GENERAL</td>
<td>approx.</td>
<td>1000 Kg</td>
<td>2000 Kg</td>
</tr>
<tr>
<td>CORE DIMENSIONS</td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>(A) Legs length</td>
<td>min/max</td>
<td>320/800 mm</td>
<td>500/1420 mm</td>
</tr>
<tr>
<td>(B) Jokes length</td>
<td>min/max</td>
<td>400/820 mm</td>
<td>400/1470 mm</td>
</tr>
<tr>
<td>(C) Core width</td>
<td>max</td>
<td>200 mm</td>
<td>300 mm</td>
</tr>
<tr>
<td>(D) Stacking height</td>
<td>max</td>
<td>200 mm</td>
<td>300 mm</td>
</tr>
<tr>
<td>Weight (without top joke)</td>
<td>max</td>
<td>1000 Kg</td>
<td>3000 Kg</td>
</tr>
<tr>
<td>CORE FEATURES (Different values upon request)</td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>Diameter of pins for sheet holes</td>
<td>10 mm</td>
<td>10 mm</td>
<td>10 mm</td>
</tr>
<tr>
<td>Displacement between points</td>
<td>7 mm</td>
<td>7 mm</td>
<td>7 mm</td>
</tr>
</tbody>
</table>

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(e) Supporting system to extract completed core after assembly
(f) Hydraulic unit for tilting
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