



**ROTHER**  
TECHNOLOGIE

INNOVATIV  
PRODUKTIV  
NACHHALTIG

**ATS**<sup>®</sup> AEROSOL  
TROCKENSCHMIERUNG

the 1990s, the number of people in the UK who are aged 65 and over has increased from 10.5 million to 13.5 million (13.5% of the population).

There are a number of reasons why the number of people aged 65 and over has increased. One of the main reasons is that people are living longer. The life expectancy at birth in the UK is now 78 years for men and 82 years for women. This is a significant increase from the 1950s, when life expectancy at birth was 71 years for men and 76 years for women. Another reason is that people are having children later in life. This means that there are more people in the 65-74 age group than there were in the 1950s.

The increase in the number of people aged 65 and over has led to a number of challenges for the UK government. One of the main challenges is the increasing cost of social security benefits.

The cost of social security benefits has increased significantly in the 1990s. This is due to a number of factors, including the increase in the number of people aged 65 and over, and the increase in the cost of living.

The government has taken a number of measures to reduce the cost of social security benefits. One of the main measures is to increase the state pension age.

The state pension age is currently 65 for men and 60 for women. The government has announced that it will increase the state pension age to 67 for men and 62 for women by the year 2020.

Another measure is to reduce the amount of social security benefits that people can receive. The government has introduced a number of measures to reduce the amount of social security benefits that people can receive, including the introduction of the New State Pension.

The New State Pension is a new pension scheme that will be introduced in the year 2018. It will be a flat-rate pension, meaning that everyone who has paid National Insurance contributions will receive the same amount.

The amount of the New State Pension will be £10 per week. This is a significant increase on the current state pension, which is £8.05 per week for men and £6.90 per week for women.

The government has also introduced a number of measures to reduce the cost of social security benefits for people who are not eligible for the state pension. These measures include the introduction of the New State Pension for people who have not paid National Insurance contributions.

The New State Pension for people who have not paid National Insurance contributions will be £5 per week. This is a significant increase on the current state pension for people who have not paid National Insurance contributions, which is £3.50 per week.

The government has also introduced a number of measures to reduce the cost of social security benefits for people who are not eligible for the state pension and the New State Pension. These measures include the introduction of the New State Pension for people who have not paid National Insurance contributions and the New State Pension for people who have not paid National Insurance contributions.

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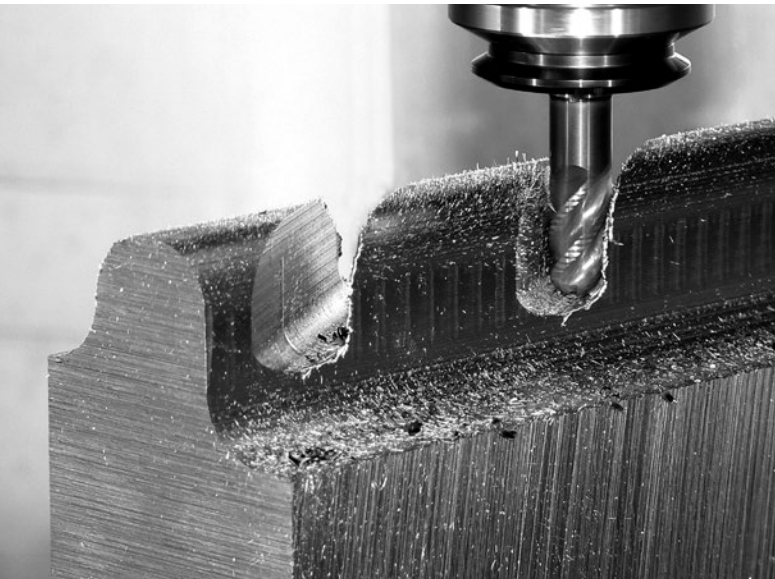
**PRODUKTREIHE**  
INNOVATIV, PRODUKTIV, NACHHALTIG  
08/2016

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## AEROSOL MASTER®

DAS SCHMIERSYSTEM, DAS  
NEUE MASSSTÄBE SETZT

Mit geringem Adaptionaufwand kann die Produktivität in der zerspanenden Fertigung an Bearbeitungszentren, Transferstraßen, Dreh- und Fräsmaschinen und Bohrmaschinen mit unserer Zukunftstechnologie, der Aerosol-Trockenschmierung (ATS), enorm gesteigert werden.

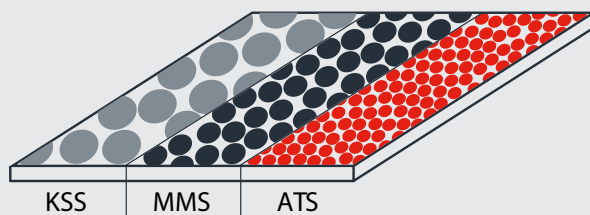
In einem breiten Materialspektrum souverän unterwegs, erzeugt der AEROSOL MASTER® ein äußerst feines Aerosol mit Schmierpartikeln im Mikrobereich. Unsere Devise – Hitze verhindern statt bekämpfen – hat großen Einfluss auf Produktivität und Qualität:

- wartungsarm
- bedienerfreundlich
- einfache Adaption
- kontinuierliche Aerosolerzeugung
- keine Druckschwankungen am Werkzeug



Außerhalb der Werkzeugmaschine wird ein Aerosol generiert. Hierzu wird dem Aerosol-Aggregat Druckluft zugeführt. Die Aerosolerzeugung erfolgt in einem Behälter, der einen gewissen Vorrat an Schmiermedium beinhaltet. Der Füllstand dieses Behälters wird von der integrierten Steuerung überwacht.

Je nach Typ erfolgt die Nachfüllung manuell oder automatisch über ein Nachfüllaggregat. Herkömmliche Einkanalssysteme sind sehr stark vom Differenzdruck an der Düse und von der Transportgeschwindigkeit abhängig. Je kleiner der Differenzdruck, um so geringer ist die Aerosolerzeugung. Je höher die Transportgeschwindigkeit, um so größer ist die austragbare Ölmenge. Diese wiederum wird in erheblichem Maße vom Kühlkanaldurchmesser und der Luftversorgung bestimmt. Beim AEROSOL MASTER® sind Aerosolerzeugung und Transportluft weitestgehend entkoppelt. Der Differenzdruck wird geregelt, wodurch eine kontinuierliche Aerosolerzeugung und ein konstanter Aerosolfluss gewährleistet werden und somit keine systembedingten Druckschwankungen am Werkzeug entstehen.



Vergleich Schmiermittelauftrag

AEROSOL TROCKENSCHMIERUNG (ATS)  
**HITZE VERHINDERN STATT BEKÄMPFEN** –  
 DAS IST DIE FORMEL FÜR ATS!

Aus kleinsten Mengen Schmierstoff wird ein äußerst feines Aerosol erzeugt. Dies wird konstant geregelt und verlustfrei der Werkzeugschneide zugeführt. Optimaler Schmierpartikelauflage reduziert wirkungsvoll das Entstehen von Reibungswärme.

- Konstantes Aerosol durch die Spindel bis 42.000 rpm
- Kaum Reibung
- Keine prozesskritische Temperaturentwicklung





**LUBRICATION  
SOLUTION**





### **AEROSOL MASTER® 500** DIE VARIANTE FÜR GLEICHBLEIBENDE ANFORDERUNGEN – DIREKT ANSTEUERBAR

Der AEROSOL MASTER® 500 ist eine Variante für einfache Bearbeitungen, bei denen eine immer gleichbleibende Aerosolmenge erforderlich ist, wie z.B. beim Bohren oder Sägen.

Der AEROSOL MASTER® 500 wird über die Maschinensteuerung angesteuert. Es gibt eine manuelle Einstellmöglichkeit, um die Aerosolmenge optimal an den Zerspanprozess anzupassen.

Mit einem Nachfüllaggregat können bis maximal sechs AEROSOL MASTER® 500 automatisch befüllt werden.



### **AEROSOL MASTER® 800** DIE VARIANTE FÜR UNTERSCHIEDLICHE ANFORDERUNGEN – DIREKT ANSTEUERBAR

Der AEROSOL MASTER® 800 ist für Bearbeitungsprozesse ausgelegt, bei denen drei verschiedene Aerosolmengen ausreichen.

Der AEROSOL MASTER® 800 wird über die Maschinensteuerung angesteuert. Es gibt drei manuelle Einstellmöglichkeiten, um die Aerosolmenge optimal an den Zerspanprozess anzupassen.

Mit einem Nachfüllaggregat können bis maximal sechs AEROSOL MASTER® 800 automatisch befüllt werden.



### **AEROSOL MASTER® 1000**

**DIE ANTWORT AUF GLEICHBLEIBENDE ANFORDERUNGEN**

Der AEROSOL MASTER® 1000 ist eine Variante für einfache Bearbeitungen, bei denen eine immer gleichbleibende Aerosolmenge erforderlich ist, wie z.B. beim Bohren oder Sägen.

Der AEROSOL MASTER® 1000 verfügt über eine Kleinsteuerung und die Möglichkeit die Aerosolmenge manuell einzustellen und exakt an die Anforderungen anzupassen. Die Befüllung des AEROSOL MASTERS® 1000 erfolgt manuell.



### **AEROSOL MASTER® 4000**

**DIE LÖSUNG FÜR UMFANGREICHE BEARBEITUNGEN**

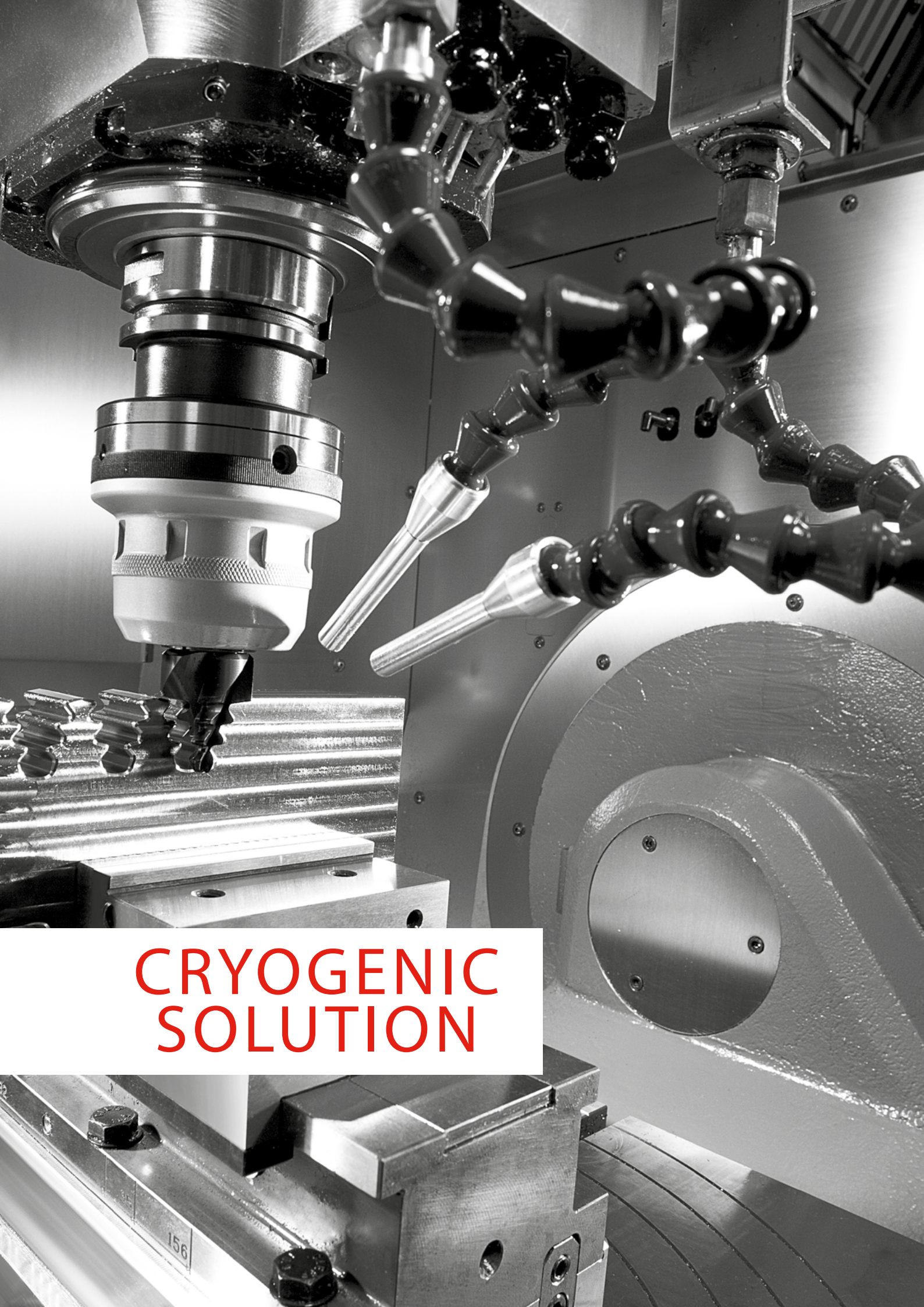
Der AEROSOL MASTER® 4000 ist für Bearbeitungsprozesse ausgelegt, bei denen viele verschiedene Aerosolmengen gefordert sind. Es lassen sich 30 Programme vorwählen, die dann über eine Anbindung zur Maschine direkt abgerufen werden. So eignet er sich für umfangreiche Bearbeitungen wie sie z.B. bei Bearbeitungszentren der Fall sind.

Der AEROSOL MASTER® 4000 verfügt über eine leistungsfähige Steuerung und die Option einer ProfiBus- oder ProfiNet-Anbindung für die Kommunikation mit der Maschine.

Mit einem Nachfüllaggregat können bis maximal sechs AEROSOL MASTER® 4000 automatisch befüllt werden.







**CRYOGENIC  
SOLUTION**

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## AEROSOL MASTER 4000cryolub®

HIGHTECHINNOVATION FÜR  
HIGHTECHZERSPANUNG

Der AEROSOL MASTER 4000cryolub® beinhaltet die Kombination von ATS und der kryogenen Kühltechnologie cryolub®.

Ist die Primärfunktion ATS zur Prozesskühlung in speziellen Anwendungen nicht ausreichend, kommt der AEROSOL MASTER 4000cryolub® ins Spiel. Er kombiniert ATS mit einem speziellen Kühlgas (AKZ/IKZ). Mit dieser neuen Kühlschmiertechnologie cryolub® lässt sich bei Bedarf die Zerspanungskontaktzone auf bis zu  $-78^{\circ}\text{C}$  abkühlen. Die Kühlleistung lässt sich ebenso wie die Aerosolsättigung bedarfsgerecht und somit bauteil- und materialabhängig einstellen.

Der AEROSOL MASTER 4000cryolub® ist wie der AEROSOL MASTER® 4000 für Bearbeitungsprozesse ausgelegt, bei denen viele verschiedene Aerosolmengen gefordert sind.

Es lassen sich 30 Programme vorwählen, die dann über eine Anbindung zur Maschine direkt abgerufen werden. So eignet er sich für umfangreiche Bearbeitungen wie sie z.B. bei Bearbeitungszentren der Fall sind.

Der AEROSOL MASTER 4000cryolub® verfügt über eine leistungsfähige Steuerung und die Option einer ProfiBus- oder ProfiNet- Anbindung für die Kommunikation mit der Maschine.

Mit einem Nachfüllaggregat können bis maximal sechs AEROSOL MASTER 4000cryolub® automatisch befüllt werden.

## ÜBERSICHT

### AEROSOL MASTER® PRODUKTREIHE

	AEROSOL MASTER® 500	AEROSOL MASTER® 800	AEROSOL MASTER® 1000	AEROSOL MASTER® 4000	AEROSOL MASTER 4000cryolub®
Einstellung	manuell 1-fach	manuell 3-fach	manuell 1-fach	automatisch	automatisch
Programme	-	-	-	30	30
Befüllung	automatisch	automatisch	manuell	automatisch	automatisch
Nachfüllaggregat	ja	ja	nein	ja	ja
Kühlgas	nein	nein	nein	nein	ja
Kühlleistung	-	-	-	-	bis zu -78°C
Innenkühlkanäle	0,5-6,0mm	0,5-6,0mm	0,5-6,0mm	< 0,5-6,0mm	< 0,5-6,0mm

## TECHNISCHE DATEN

### AEROSOL MASTER®

	AEROSOL MASTER® 500	AEROSOL MASTER® 800	AEROSOL MASTER® 1000	AEROSOL MASTER® 4000	AEROSOL MASTER 4000cryolub®
Abmessung (HBT)	600x400x210 mm	600x600x210 mm	600x600x210 mm	600x600x210 mm	600x600x210 mm
Platzbedarf (HBT)	750x440x630 mm	750x640x830 mm	750x640x830 mm	750x640x830 mm	750x640x830 mm
Gewicht	30 kg	35 kg	38 kg	40 kg	43 kg
Füllmenge	2,3 l	2,3 l	2,3 l	2,3 l	2,3 l
Nutzmenge	1,7 l	1,7 l	1,7 l	1,7 l	1,7 l
Spannungsversorgung	24 VDC	24 VDC	230 VAC 1~	24 VDC	24 VDC
Stromaufnahme	1,5 A	2,5 A	0,5 A	4 A	4 A
Eingangsdruck	6-10 bar	6-10 bar	6-10 bar	6-10 bar	6-10 bar
Druckluft Güteklasse	5 ISO 8573-1	5 ISO 8573-1	5 ISO 8573-1	5 ISO 8573-1	5 ISO 8573-1
Druckluftanschlussleistung	1 Nm <sup>3</sup> /min bei 6 bar	1 Nm <sup>3</sup> /min bei 6 bar	1 Nm <sup>3</sup> /min bei 6 bar	1 Nm <sup>3</sup> /min bei 6 bar	1 Nm <sup>3</sup> /min bei 6 bar
Luftverbrauch*	10-1000 NI/min	10-1000 NI/min	10-1000 NI/min	10-1300 NI/min	10-1300 NI/min
Ölmenge**	0-250 ml/h	0-250 ml/h	0-250 ml/h	0-350 ml/h	0-350 ml/h
Kühlgasverbrauch***					3kg/h-10 kg/h
Kühlgasversorgung					min. 55 max. 65 bar
Füllstandüberwachung	4- Punkt, 24 VDC	4- Punkt, 24 VDC	4- Punkt, 24 VDC	4- Punkt, 24 VDC	4- Punkt, 24 VDC
Aerosolbehälterdruck	max. 10 bar	max. 10 bar	max. 10 bar	max. 10 bar	max. 10 bar
Aerosoldruck	0,5-9 bar	0,5-9 bar	0,5-9 bar	0,5-9 bar	0,5-9 bar

\* abhängig vom Innenkühlkanaldurchmesser und Behälterdruck

\*\* abhängig vom Innenkühlkanaldurchmesser, Behälterdruck und Schmierstoff

\*\*\* abhängig vom zu zerspannenden Material und den verwendeten Düsen/ Werkzeugen

# PARAMETERLISTE

## AEROSOL MASTER®

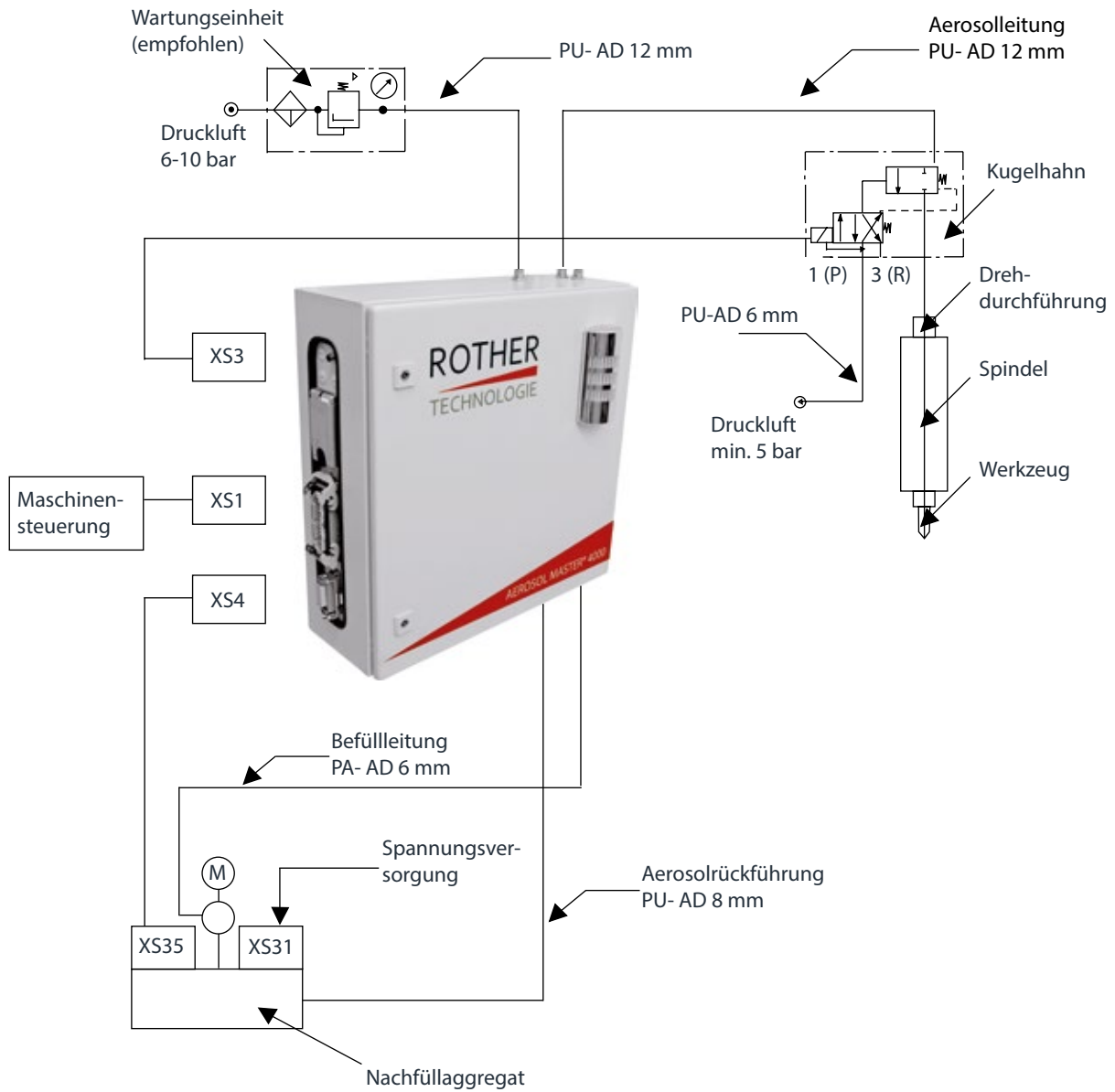
Kühlkanal- durchmesser (mm)	<0,5		0,5-1,5		1,5-2,5		2,5-3,0		3,0-3,5		3,5-4,0		4,0-4,5		4,5-5,0		5,0-6,0	
	Düsendruck [bar]	Behälterdruck [bar]	Düsendruck [bar]	Behälterdruck [bar]	Düsendruck [bar]	Behälterdruck [bar]	Düsendruck [bar]	Behälterdruck [bar]	Düsendruck [bar]	Behälterdruck [bar]	Düsendruck [bar]	Behälterdruck [bar]	Düsendruck [bar]	Behälterdruck [bar]	Düsendruck [bar]	Behälterdruck [bar]	Düsendruck [bar]	Behälterdruck [bar]
AEROSOL MASTER®																		
Programmnummer																		
1 (variabel)	-	-																
2 (variabel)	-	-																
3 (variabel)	-	-																
4			*	5,4														
5			**	5,4														
6			***	5,4														
7					*	4,7												
8					**	4,7												
9					***	4,7												
10							*	4,0										
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16											*	2,6						
17											**	2,6						
18											***	2,6						
19													*	1,9				
20													**	1,9				
21													***	1,9				
22															*	1,2		
23															**	1,2		
24															***	1,2		
25																	*	0,5
26																	**	0,5
27																	***	0,5
28	Luftprogramm (25%)																	
29	Luftprogramm (50%)																	
30	Luftprogramm (75%)																	

HINWEIS: Der Düsendruck muss höher sein als der Behälterdruck.

- \* Ölanteil gering
- \*\* Ölanteil mittel
- \*\*\* Ölanteil hoch

# INSTALLATIONSPLAN

AM BEISPIEL AEROSOL MASTER® 4000





## NACHFÜLLAGGREGATE

### DIE GARANTIE FÜR PROZESSSICHERHEIT

Unsere Nachfüllaggregate gewährleisten eine kontinuierliche Fortsetzung des Bearbeitungsprozesses. Sie dienen der Arbeitssicherheit und sind sehr bedienerfreundlich.

NACHFÜLLAGGREGATE	BEHÄLTERINHALT	AEROSOLRÜCKFÜHRUNG
NFA 1 für 1 AEROSOL MASTER®	10 Liter	ja
NFA 4 für 4 AEROSOL MASTER®	27 Liter	ja
NFA 5 für 5 AEROSOL MASTER®	27 Liter	ja
NFA 6 für 6 AEROSOL MASTER®	27 Liter	ja

## TECHNISCHE DATEN

### NACHFÜLLAGGREGAT (10 LITER)



Abmessung (HBT)	494x553x364 mm
Gewicht	ca. 22 kg
Behälterinhalt	10 l (NG12)
Umgebungstemperatur	0 °C - 40 °C
Schutzart	IP 55
Förderstrom	0,375 l/min
Druck	25 bar
Feinheit Ölfilter	12 µ
Spannungsversorgung	400 VAC 3~/N/PE
Absicherung	6 A
Füllstandsüberwachung	2- Punkt, 24 VDC

## ÖL

### ATS-ÖL ZUM SCHMIEREN UND KÜHLEN

AEROSOL MASTER lubricant c ist unsere Eigenentwicklung für die ATS-Technologie. Es ermöglicht eine ressourcenschonende und energieeffiziente Fertigung bei geringstem Ölverbrauch und behält seine hervorragende Schmiereigenschaften bei bis zu -78°C.

ARTIKEL	Einsatzgebiet
AM lubricant c-al	Aluminium, Kunststoff, Buntmetall, Stahl
AM lubricant c-st	Stahl, Schwerzerspannung
AM lubricant c-ti	Titan



## SERVICE

DAS GEHEIMNIS DES ERFOLGES IST, DEN STANDPUNKT DES ANDEREN ZU VERSTEHEN Henry Ford

Unser Anliegen ist es, die Anforderungen unserer Kunden zu kennen und zu verstehen. Dann können wir individuell beraten, um Zerspanungsprozesse zu optimieren und deren Produktivität zu steigern. So entstehen langjährige Geschäftsbeziehungen auf der Basis von Vertrauen und Wertschätzung.

Durch die Zusammenarbeit mit Forschungsinstituten erhalten wir Einblicke in die Bearbeitungswelt von morgen, so können wir unsere Kunden in die Zukunft begleiten. INNOVATIV, PRODUKTIV, NACHHALTIG

the 1990s, the number of people in the UK who are aged 65 and over has increased from 10.5 million to 13.5 million (1990-2000) (ONS 2001).

There is a growing awareness of the need to address the needs of older people in the workplace. The Department of Health (2000) has published a strategy for older people, which includes a commitment to 'improve the lives of older people in the workplace'. The Department of Work and Pensions (2000) has also published a strategy for older people, which includes a commitment to 'improve the lives of older people in the workplace'.

The purpose of this paper is to explore the needs of older people in the workplace and to identify ways in which these needs can be met.

The paper is organized as follows. Section 2 discusses the needs of older people in the workplace. Section 3 discusses ways in which these needs can be met. Section 4 discusses the implications of the findings for practice. Section 5 discusses the implications of the findings for research.

## 2. Needs

The needs of older people in the workplace can be categorized into three main areas: physical, psychological and social.

**Physical needs:** Older people may have physical limitations that affect their ability to perform certain tasks. These limitations may include reduced strength, reduced endurance, reduced flexibility, and reduced vision. These limitations may also affect their ability to work long hours or in noisy or hot environments.

**Psychological needs:** Older people may have psychological limitations that affect their ability to perform certain tasks. These limitations may include reduced memory, reduced concentration, and reduced problem-solving skills. These limitations may also affect their ability to work in a fast-paced or high-pressure environment.

**Social needs:** Older people may have social limitations that affect their ability to perform certain tasks. These limitations may include reduced social skills, reduced communication skills, and reduced ability to work in a team. These limitations may also affect their ability to work in a customer-facing or sales-oriented environment.

The needs of older people in the workplace are complex and multifaceted. It is important to recognize these needs and to develop strategies to address them.

## 3. Meeting needs

There are a number of ways in which the needs of older people in the workplace can be met. These ways can be categorized into three main areas: physical, psychological and social.

**Physical needs:** Physical needs can be met by providing older people with appropriate work environments and equipment. This may include providing ergonomic workstations, adjustable desks, and chairs. It may also include providing older people with appropriate work schedules and breaks.

**Psychological needs:** Psychological needs can be met by providing older people with appropriate training and support. This may include providing older people with training in new technologies and software. It may also include providing older people with support in the form of mentors and coaches.

**Social needs:** Social needs can be met by providing older people with opportunities to interact with colleagues and customers. This may include providing older people with opportunities to work in teams and to participate in social activities. It may also include providing older people with opportunities to provide feedback and to be consulted on their views.

The needs of older people in the workplace are complex and multifaceted. It is important to recognize these needs and to develop strategies to address them.

## 4. Implications for practice

The findings of this study have a number of implications for practice. These implications can be categorized into three main areas: physical, psychological and social.

**Physical implications:** The findings of this study suggest that older people may have physical limitations that affect their ability to perform certain tasks. This suggests that employers should provide older people with appropriate work environments and equipment.

**Psychological implications:** The findings of this study suggest that older people may have psychological limitations that affect their ability to perform certain tasks. This suggests that employers should provide older people with appropriate training and support.

**Social implications:** The findings of this study suggest that older people may have social limitations that affect their ability to perform certain tasks. This suggests that employers should provide older people with opportunities to interact with colleagues and customers.

The needs of older people in the workplace are complex and multifaceted. It is important to recognize these needs and to develop strategies to address them.

## 5. Implications for research

The findings of this study have a number of implications for research. These implications can be categorized into three main areas: physical, psychological and social.



Wir wurden für den hohen wirtschaftlichen, technologischen, gesellschaftlichen und ökologischen Nutzen unserer Technologie ausgezeichnet.

# ROTHER TECHNOLOGIE

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