

# Foot operated spot welders Items 4640-4644 - 16-25 kVA

Rocker arm, foot operated, spot welder, with TE90 microprocessor welding control unit. Nominal power at 50% d.c. from 16 to 25 kVA

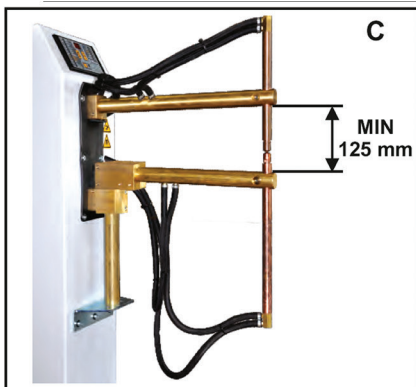
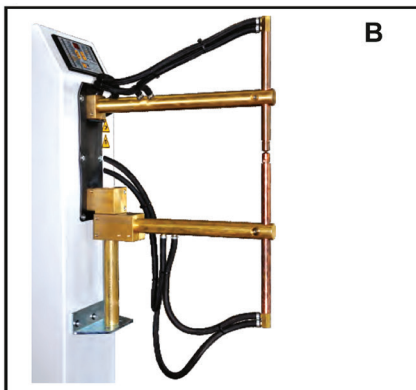
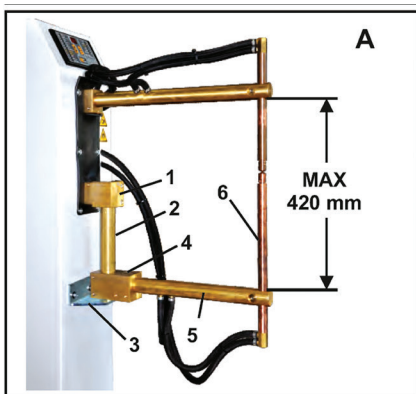
# TECNA<sup>®</sup>

## Features

TECNA spot welders are designed to meet every need of spot welding. The new stationary ergonomic frame designed by TECNA helps to facilitate the operator's work. The control unit has been positioned frontally to allow the operator to view the welding data even during the working cycle.

## MAIN WELDER FEATURES

- Arms adjustable in length allowing a better working flexibility.
- Chrome-copper electrode-holders for long life and heavy duty service, designed for straight and angled fitting.
- Adjustable electrode stroke.
- Epoxy resin coated transformer.
- Water-cooled transformer, arms and electrodes.
- Microprocessor control unit TECNA TE90.
- Adjustable electrode force; a microswitch starts the welding cycle when the desired pre-set value is reached.
- The foot pedal is adjustable in length.



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| ITEM                              |                 | • 4640 | 4641  | •4642  | • 4643 | 4644   |
|-----------------------------------|-----------------|--------|-------|--------|--------|--------|
| Nominal power at 50%              | kVA             | 16     | 20    | 20     | 25     | 25     |
| Maximum welding power             | kVA             | 35     | 48    | 39     | 68     | 55     |
| No load secondary voltage         | V               | 3.4    | 4     | 4      | 4.6    | 4.6    |
| Maximum short circuit current     | kA              | 12.5   | 14.5  | 12     | 18     | 14.5   |
| Maximum welding current on steel  | kA              | 10     | 11.6  | 9.6    | 14.4   | 11.6   |
| Thermal current 100%              | A               | 3300   | 3500  | 3500   | 3800   | 3800   |
| Supply voltage 50Hz *             | V               | 415    | 415   | 415    | 415    | 415    |
| Cables section L=10 m             | mm <sup>2</sup> | 6      | 10    | 10     | 16     | 16     |
| Cables section L=30 m             | mm <sup>2</sup> | 10     | 10    | 10     | 16     | 16     |
| Delayed fuses                     | A               | 32     | 40    | 40     | 50     | 50     |
| Min. electrodes throat depth      | mm              | 230    | 230   | 380    | 230    | 380    |
| Max. electrode force (6 bar)      | daN             | 240    | 240   | 150    | 240    | 150    |
| Electrode stroke                  | mm              | 8-44   | 8-44  | 10-60  | 8-44   | 10-60  |
| Max. electrodes throat depth      | mm              | 550    | 550   | 700    | 550    | 700    |
| Max. electrode force (6 bar)      | daN             | 95     | 95    | 80     | 95     | 80     |
| Electrode stroke                  | mm              | 15-85  | 15-85 | 15-105 | 15-85  | 15-105 |
| Short circuit current with L max. | kA              | 8.4    | 10    | 8.8    | 13     | 10.5   |
| Arms diameter                     | mm              | 36     | 40    | 40     | 40     | 40     |
| Electrode-holders diameter        | mm              | 19     | 22    | 22     | 22     | 22     |
| Standard electrodes cone diameter | mm              | 12.7   | 14.8  | 14.8   | 14.8   | 14.8   |
| Water cooling                     | l/min           | 2.5    | 3     | 3      | 3.7    | 3.7    |
| Aerial noise produced             | dB(A)           | < 70   | < 70  | < 70   | < 70   | < 70   |
| Measure conditions                |                 |        |       |        |        |        |
| Working stroke                    | mm              | 20     | 20    | 20     | 20     | 20     |
| Welding time                      | cycles          | 21     | 17    | 26     | 14     | 20     |
| Welding current                   | kA              | 9.4    | 11    | 9      | 13.5   | 11     |
| Working rating in welds/min       |                 | 10     | 10    | 10     | 10     | 10     |
| Net weight (approximately)        | kg              | 135    | 143   | 146    | 145    | 148    |

\* Different voltages and frequencies on request

• Normal stocked models / All other models ordered on request

## 16 kVA ELECTRODES



Art-3720  
Straight

Art-3721  
Offset

Art-3722  
Angled

Art-3723  
Bent

Art-3724  
Flat

Art-3625  
Swivel



Art-4726



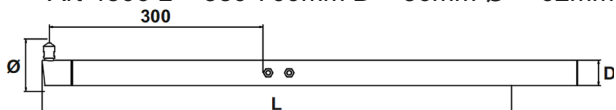
Art-4727



Art-4729



Art-4506 L = 380-700mm D = 36mm Ø = 62mm



Art-4509 L = 380-700mm D = 360mm Ø = 45mm

