

Pneumatic spot welders - Items 4645-4649 - 16-25 kVA

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

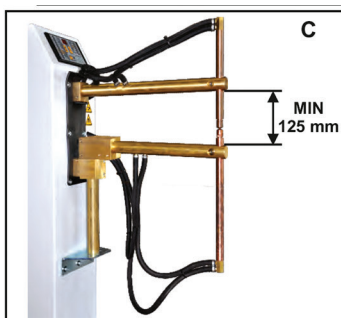
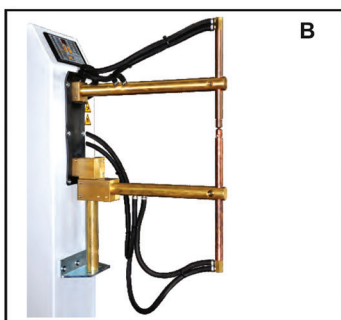
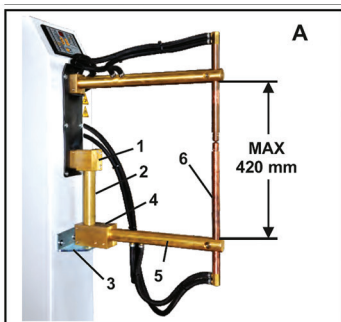
TECNA[®]

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. The pneumatic commands and the compressed air pressure gauge have been placed at the top for easier adjustment and reading.

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.
- The air operated lubrication free cylinder eliminates oil mist.
- Electrode force adjustment with air filter reducer with gauge.
- Semi-automatic drainage system.
- Electrode speed control valves, shock absorber for cylinder's end of stroke and air discharge silencers.
- Two-stage electric foot pedal, that besides its normal use in automatic and single spot mode, allows the operator to bring the pieces together and to weld them only when correctly positioned.
- Pre-arrangement for the connection of a second electric two-stage foot pedal item 70284.
- The addition of the second foot pedal allows to recall two different adjustments of time- current. This function is helpful when different kinds of welding are to be performed on the same piece.



Pneumatic spot welders

Items - 16-25 kVA

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ITEM		4645	4646	4647	• 4648	4649
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 ²	6	10	10	16	16
Cables section L=30 m	mm ²	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	165	240	165
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	115	115	90	115	90
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
Compressed air supply	bar	6.5	6.5	6.5	6.5	6.5
Air for 1000 spots (6 bar)	Nm ³	4.3	4.3	4.3	4.3	4.3
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	133	141	144	143	146

* Different voltages and frequencies on request

• Normal stocked models / All other models ordered on request

20-25 kVA ELECTRODES



Art-3620
Straight



Art-3621
Offset



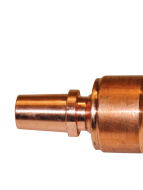
Art-3622
Angled



Art-3623
Bent



Art-3624
Flat



Art-3625
Swivel



Art-4726



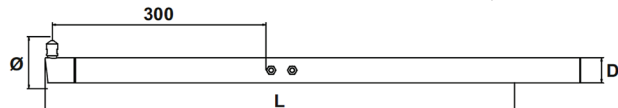
Art-4727



Art-4729



Art-4567 L = 380-700mm D = 40mm Ø = 65mm



Art-4568 L = 380-700mm D = 40mm Ø = 50mm

