

TECNA ROCKER ARM SPOT WELDERS

MAIN WELDER FEATURES

- Rocker arm pneumatic welder with TE90 microprocessor welding control unit.
- Adjustable arms up to 320mm, enabling to adjust the welder according to the work exigencies.
- Chrome-copper electrodes holders for heavy duty and long life, designed for both straight and angled assembling.
- Adjustable electrode stroke, enabling to reach to max working rate.
- Water cooled transformer, with epoxy resin coated windings.
- Water cooled arms, electrode holders and electrodes.
- Synchronous SCR contactor insulated from cooling water circuit with protection thermostat.
- All models have been designed for both single and automatic cycle.
- Two stage electric foot control for clamping and welding pieces only if correctly positioned.
- The welder has been designed for connecting a second two stage electric foot control. This additional electric foot enables the recalling of the twin pre-setting for time and current, useful when it is necessary to carry out two different welds on the same piece.
- 24Vdc 5 way solenoid valve.
- Double effect pneumatic cylinder, lubrication free against oil mist.
- Electrode force adjustable by means of built in compressed air filter unit with gauge-pressure, with semi-automatic moisture discharger.
- Electrode speed regulators (both opening and closing), cylinder end stroke shock absorber, and silencers for compressed air discharge, assuring the minimum noise.



TECHNICAL DATA

ITEM		4607N	4608N	4609N	4610N	4611N
Nominal Power at 50%	kVA	16	20	20	25	25
maximum welding power	kVA	35	48	39	68	55
Short circuit current	kA	12.5	14.5	12	18	14.5
Max. weld current on alum.	kA				16.3	
Max weld current on steel	kA	10	11.6	9.6	14.4	11.6
Thermal current 100%	A	3300	3500	3500	3800	3800
No load secondary voltage	V	3.4	4	4	4.6	4.6
Supply voltage 50Hz*	V	400	400	400	400	400
Cables section L=30m	mm ²	10	10	10	16	16
Delayed fuses	A	32	40	40	50	50
Min. electrode throat depth	mm	230	230	380	230	380
Max. electrode force (6 bar)	daN	240	240	165	240	165
Electrode stroke	mm	8 to 44	8 to 44	10 to 60	8 to 44	10 to 60
Max. electrode throat depth	mm	550	550	700	550	700
Max electrode force (6 bar)	daN	115	115	90	115	90
Electrode stroke	mm	15 to 85	15 to 85	15 to 105	15 to 85	15 to 105
Arm dia.	mm	36	40	40	40	40
Electrode holder dia.	mm	19	22	22	22	22
Standard electrode cone dia.	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)						
stroke 20mm	Nm ³	2.8	2.8	2.8	2.8	2.8
max. stroke	Nm ³	4.3	4.3	4.3	4.3	4.3
Air supply hose	mm	8	8	8	8	8
Water cooling	l/min	2.5	3	3	3.7	3.7
Aerial noise produced	dB(A)	< 70	< 70	< 70	< 70	< 70
Measure condistions						
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
work rating in welds/min		10	10	10	10	10
Net weight (approx.)	kg	114	122	125	124	127