

AUTOSPOT

PNEUMATIC INDUSTRIAL SPOT WELDING GUNS

PN 8^{8kVA}

12^{12kVA}

18^{18kVA}

25^{25kVA}

36^{36kVA}

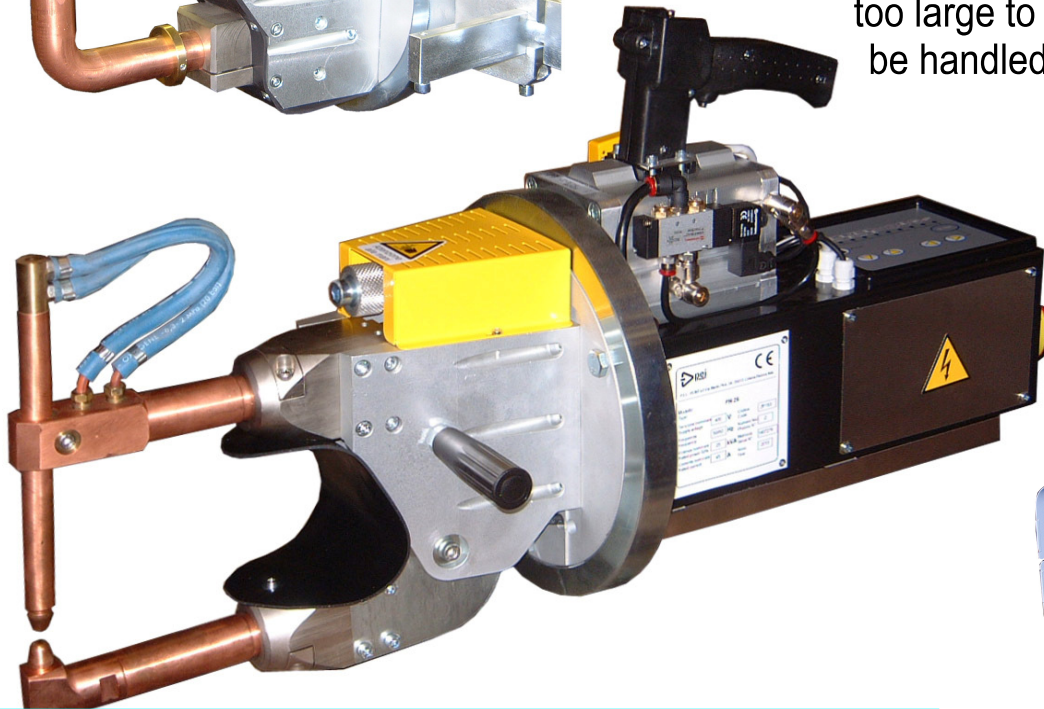
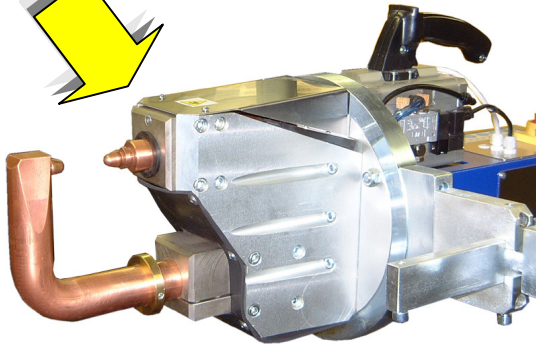
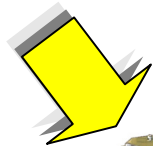
42

The guns in the AUTOSPOT range are suitable for use in most industrial applications where resistance welding is the preferred process but the workpiece is too large to be handled

SSZG C

PN 18C^{18kVA}

25C^{25kVA}



SSZG C ROSS-I-SS

- Fully gimballed suspended guns.
- Adjustable for neutral balance in all planes.
- Designed and constructed for the most demanding industrial use.
- Easy to use touch pad digital control- model PX1600 (Programmable)
- Four transformer sizes to cover most popular welding requirements.
- Balancers and watercoolers available to complete the package

Separate control box available on all models Standard on PN42

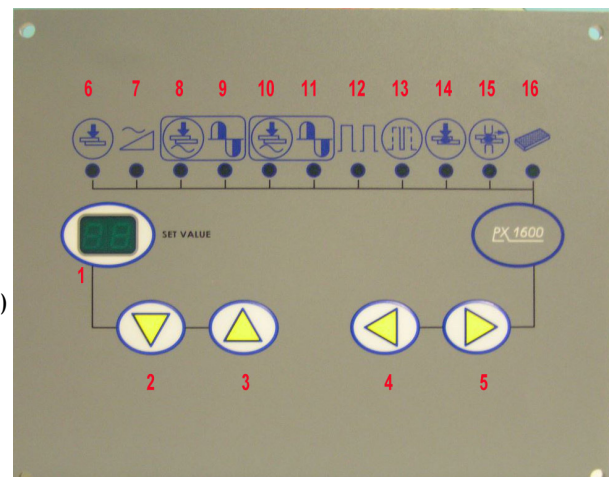


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- ❖ Modern design concept and modular construction ensure reliable operation and enables easy maintenance.
- ❖ Gun mass located centrally through gimbal ring for effortless rotation
- ❖ Working stroke adjustable. Wide electrode gap at the touch of a lever.
- ❖ Series water-cooling ensures effective cooling of all parts of the gun and arms.
- ❖ Different arm lengths, 200-800 mm, and various electrode configurations available.
- ❖ Pressure only stroke can be followed by weld cycle without prior release.
- ❖ Isolation switch with power, water and air connections mounted at rear of gun.
- ❖ No additional control boxes required - PX1600 control built into gun. (Except PN42)
- ❖ PN42 has separate control box.

PX1600 CONTROL FUNCTIONS

1. Displays chosen parameter value and program number
2. Adjusts value down
3. Adjusts value up
4. Selects parameter for adjustment or display. (moves to left)
5. Selects parameter for adjustment or display. (moves to right)
6. Pre weld squeeze time 0-99 cycles
7. Slope up of weld power 0-20 cycles
8. Weld time (set 1) 0-99 cycles
9. Weld power (set 1) 1-99% of transformer output
10. Weld time (set 2)
11. Weld power (set2)
12. Number of pulses 1-20 (If set 2 or higher weld time is 20 cycles max)
13. Time off between pulses 0-99 cycles
14. Post weld forge time 0-99 cycles
15. If set 2 or higher gives repeat weld 0-99 cycles (time between cycle)
16. Energy compensation - for use on dirty or oxidised sheets



TECHNICAL DATA		PN18	PN25	PN36	PN42	PN25C
Power @50% Duty cycle	kVA	18	25	36	42	25
Power Supply (400v 50Hz)	kVA	13	18	25	30	18
Welding Current Max.	kA	11.4	12.8	15.6	18.4	12.8
Electrode Force (200mm arms)	daN	250	250	540	540	330
Welding capacity on steel	mm	3.0+3.0	3.5+3.5	4.5+4.5	5 + 5	3 + 3
Welding capacity on cross wires	mm	10+10	10+10	18+18	20+20	12+12
Throat gap (Standard)	mm	150	150	180	180	92
Arms length	mm	200-800	200-800	200-800	200-800	-
Electrodes opening	mm	20-50	20-50	20-50	20-50	40
Water flow required	l/min	5	5	5	5	5
Dimensions	W mm	240	240	270	360	300
	L mm	480	485	570	770	650
	H mm	385	385	385	425	400
Weight (gun only)	kg	44	52	83	85	60



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