

SPOT / PROJECTION WELDING MACHINES

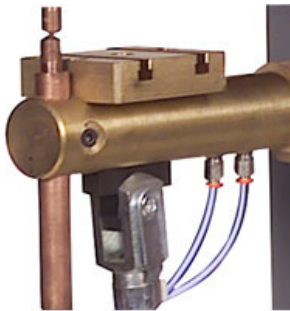
Pneumatic - Linear head

with PX1600 Digital synoptic control
or PY600 Constant Current control

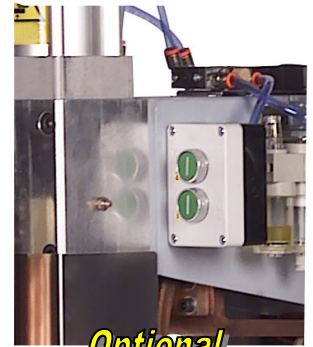
PF 136 ^{35kVA}
PF 151 ^{50kVA}
PF 181 ^{80kVA}



*Optional
high-lift
cylinder*



*Optional
lower platen
(fitted to PF181)*



*Optional
concomitant
safety buttons*

**Versatile
modern
machines
suitable for
spot and
projection
welding.
Ideal for weld
nuts etc.**



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PF136, PF151 and PF181

- Linear action machines suitable for spot and projection welding, cross wire work with bar holders etc. Ideal for weld nuts up to M10
- Rigid top arm with cylinder acting directly on top platen / electrode holder ensuring linear movement and fast response.
- Lower arm adjustable for height and can be fitted with platen.
- Main transformer, arms and electrode holders are fully water cooled.
- All machines can be fitted with an adjustable High-Lift cylinder with manual or electric valve operation - useful for access over flanges etc. and for electrode replacement.
- Optional Concomitant hand push buttons (for safety)

PF 151 and 181

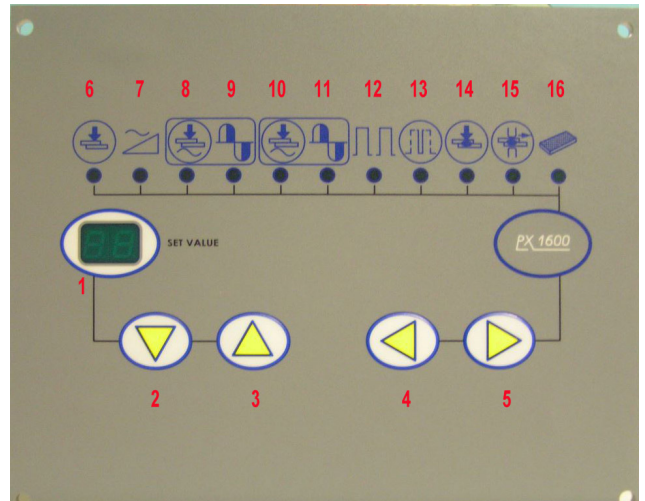
- Lower arm adjustable bracing strut.

PF 181

- Fitted with platen on lower arm

PX1600 Digital Control

1. Displays chosen parameter value or programme 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



		PF136	PF151	PF181
POWER @ 50% DUTY CYCLE	kVA	35	50	80
SHORT CIRCUIT CURRENT	kVA	18.5	21.5	25
MAX.SEC.WELDING CURRENT	kA	14.8	17.2	20
ELECTRODE FORCE @ 6 BAR	daN	180	300	300
SECONDARY VOLTAGE	V	5.2	5.8	6.75
SUPPLY 50HZ 1PH	V	400	400	400
FUSE RATING (delayed type)	A	63	90	140
WATER FLOW REQUIRED	L/min	4	4	4
AIR PRESSURE	bar	6	6	6
THROAT GAP	mm	60 - 270	60 - 270	60 - 270
ARM LENGTH	mm	450	450	450
ELECTRODE STROKE	mm	60	60	60
DIMENSIONS LxWxH	mm	1010	x 330	x 1600
WEIGHT	kg	285	290	320

