

APPLICATION AREAS

DALEX Spot welding guns of the series 32 are applied in the welding trade and are used industrially.

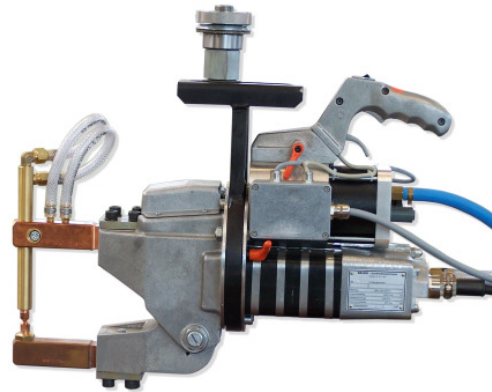


fig. Series 32

TECHNICAL DATA	3228-4	3238-4
Power rating at 50 % d.c:	16 kVA	16 kVA
Sec. short-circuit current:	13,5 kA	13,5 kA
Throat gap:	130 mm	130 mm
Electrode force:	270 daN	270 daN
Welding power:	Steel Sheet 3+3 mm, max. 4+4 mm	Steel Sheet 3 + 3 mm, max. 4 + 4 mm
Compatible welding control:	B 200 Free-stand. weld. contr: with slide-in MPS10	RZ 15 Z 32
Compatible water re cooler:	COOL 1	COOL 1
Compatible spring balancer:	D5/45	D5/45

TECHNICAL DETAILS

- high dot sequencing via double cylinder
- incl. hand control valve (3238-4)
- 5/2-way solenoid valve
- water-cooled gun and electrode arms
- distortion-free square electrode arms
- low-deflection square electrode arms for optimum performance of the electrode force
- rotation-resistant square mounting in gun in gun body
- intensively-cooled welding transformer and secondary circuit
- close Cardan ring with safety hanger
- universal usage possible via an all-round mounting system
- welding transformer cast resin sandwich construction
- welding quality remains constant via the same sandwich construction
- toggle-joint system for raising electrode force
- connecting cable in standard 10m length and low connection load
- fusing 25 A

Spotwelding Gun Type 3228-4 / 3238-4

09/2006

Technical Data* acc. to DIN 44753 / ISO669			3228-4	3238-4	
Electrical part	Throat depth	mm	170	170	
	Machine power	Power rating, 50 % ED	kVA	16	16
		Continuous rating	kVA	11,3	11,3
		Max. short-circuit power	kVA	46,7	37,3
		Max. welding power	kVA	37,3	46,7
	Machine voltage	Secondary idling voltage	V	3,4	3,5
		Number of regulating steps		0	0
	Mains connection	Rated primary voltage	V	380	400
		Rated primary current	V	42,1	40
		Rated frequency	Hz	50	50
Supply power		kVA	28	28	
Primary short-circuit current		A	123	116	
Main switch / Fusing		A	25	25 1)	
Wire range for cable length shorter = 15 m		mm ²	4	4	
Secondary current	Rated operating current	kA	4,7	4,5	
	Continuous current	kA	3,32	3,2 2)	
	Short-circuit current	kA	13,5	13,5	
	Max. welding current	kA	10,8	10,8	
	Perm. duty cycle at highest welding current	%	9,5	8,8	
Mechanical part	Cylinder EH	Electrode stroke max.	mm	48 (0 – 48 Stroke adjustment))	----
		Electrode force min. / max.	daN	270	----
		Max. movement at 10 mm stroke	min ⁻¹	200	----
		Air consumption for 1000 strokes	m ³	0,6	----
	Cylinder DH	Electrode stroke max. work stroke + approach stroke max.	mm	75/50+25 (0-25 Stroke adjustment)	75/50+25 (0-25 Stroke adjustment)
		Electrode force max	daN	270	270
		Max. movements at 10 mm stroke	min ⁻¹	250	50
		Air consumption for 1000 strokes	m ³	0,85	0,85 3)
	Spot mounting	Throat gap min. / max.	mm	130	130
		Electrode arm diameter, height x width	mm	34 x 24 Spigots	30 x 24 Sigots
Electrode holder Ø		mm	20	20	
Electrode holder, adjustability		mm	----	----	
Spot electrode seat no. / outer Ø		mm	1/12,5	1/12,5	
Compressed air	Pipe conn. nominal width / conn. thread	mm	NW 10/R ^{3/8}	NW 10/R ^{3/8}	
	Operating pressure min. / max.	bar	6/10	6/10	
Cooling water	Pipe conn. nominal width / conn. thread		NW 8/R ^{1/4}	NW 8/R ^{1/4}	
	Operating pressure min. / max.	bar	2/5	2/5	
	Consumption at max. loading	l/min ⁻¹	6	6	
Gun dimensions	Width x depth x height	mm	Gun 205 x 495 x 425 Hanger 70 x 300 x 960 Space reqd. compl. 405 x 495 x 1100	Gun 195 x 495 x 420 4) Hanger 70 x 300 x 960 Space reqd. compl. 405 x 495 x 1100	
	Gun weight excl. balancer connecting cable	kg	34 excl. cable and hanger 39,5 compl.	35,7 excl. armatures 38	
	Welding values	Steel sheet 2)	mm	3 + 3, max. 4 + 4 mm 1)	3 + 3, max. 4 + 4 mm 5)
	Round steel 15 % penetration	mm	----- 3)	10 + 10 5)	
Power stages	Thyristor power stage		1/60 L	1/60 L	

Notes:

- 1) operating class gL
- 2) at max. transformer level
- 3) at operating pressure 6 bar, stroke max.
- 4) excl. electrode mounting
- 5) subject to influences

Technical alterations reserved.
*Details for shortest throat depth.