

DALEX

SCHWEISSTECHNIK

APPLICATION AREAS

DALEX Spot welding guns of the Series 35 meet the highest of demands, also in case of non-ferrous metals.

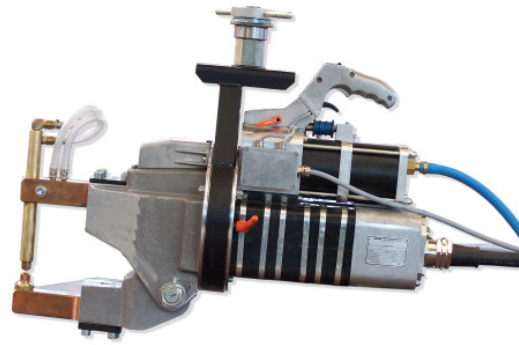


fig. 3528-4

TECHNICAL DATA	3528-4
Power rating at 50 % d.c:	63 kVA
Sec. short-circuit current:	31 kA
Throat gap:	170 mm
Electrode force:	730 daN
Welding power:	Steel sheet 5 + 5 mm, max. 6 + 6 mm
Compatible welding control:	B 200 Free-standing welding control with slide-in in MPS 10
Compatible water re cooler:	COOL 2
Compatible spring balancer:	Subject to throat depth of the fittings

TECHNICAL DETAILS

- model with double stroke cylinder
- high dot sequencing via low air consumption
- gun and electrode arms, water-cooled
- distortion-free square electrode arms
- low-deflection square electrode arms for optimum performance of the high electrode force
- rotation-resistant square mounting in gun body
- easy handling via the built-in pneumatic control
- intensively-cooled welding transformer and secondary circuit
- closed Cardan ring with safety hanger
- universal usage via an all-round mounting system
- welding transformer cast resin sandwich construction, with cut strip-wound core
- welding quality remains constant via the same sandwich construction
- toggle-joint system for raising electrode force
- connecting cable in standard 10m length and low connected load
- fusing 100 A

Series 35

SPOT WELDING GUN

Spotwelding Gun Type 3528-4

Technical Data* acc. to DIN 44753 / ISO 669			3528-4	
Electrical Part	Throat depth	mm	170	
	Machine power	Power rating, 50 % d.c.	kVA	63
		Continuous rating	kVA	44,6
		Max. short-circuit power	kVA	220
		Max. welding power	kVA	176
	Machine voltage	Secondary idling voltage	V	7
		Number of regulating steps		0
		Rated primary voltage	V	400
	Mains connection	Rated primary current	A	158
		Rated frequency	Hz	50
		Supply power	kVA	132
		Primary short-circuit current	A	550
		1) Main switch / Fusing	A	100
	Secondary current	Wire range for cable length shorter = 15 m	mm ²	25
		Rated operating current	kA	8,77
		2) Continuous current	kA	6,2
		Short-circuit current	kA	31
		Max. welding current	kA	24,8
		Perm. duty cycle at highest welding current	%	6,3
Mechanical Part	Cylinder DH	Electrode stroke max / working stroke + operational stroke max.	mm	50 i.e. 0-50 stroke adj.
		Electrode force max.	daN	730 i.e. 365 7)
		Max. movements at 10 mm stroke	min ⁻¹	375
		3) Air consumption for 1000 strokes	m ³	2,5
	Spot mounting	Throat gap	mm	170
		Electrode arm diameter height x width	mm	45 x 30 Spigots
		Electrode holder Ø	mm	25
		Electrode holder, adjustability	mm	-----
		Spot electrode seat no. / outer Ø	mm	2/18
	Compressed air	Pipe conn. nominal width / conn. thread	mm	NW 13/R/ 1/2"
		Operating pressure min. / max.	bar	6/10
	Cooling water	Pipe conn. nominal width / conn. thread		NW 8/R/ 1/4"
		Operating pressure min. / max.	bar	2/5
		Consumption at max. loading	l/min ⁻¹	6
	Gun dimensions	4) Width x depth x height	mm	Gun 275 x 670 6) x 535 Hanger 85 x 355 x 970 Space reqd. compl. 500 x 670 6) x 1170
		4) Weight gun excl. balancer connecting cable	kg	98
	Welding values	5) Steel sheet C-content smaller = 0,2 %	mm	5 + 5, max. 6 + 6
		5) Round steel C-content smaller = 0,2 %	mm	15 + 15
	Power stages	Thyristor power stage		1/500 W

Notes:

- 1) operating class gL
- 2) at max. transformer level
- 3) at operating pressure 6 bar stroke max.
- 4) subject to influences
- 5) excl. electrode mounting
- 6) depth plus 45 mm
- 7) models with extended electrode force range

Technical alterations reserved.

*Details for shortest throat depth.