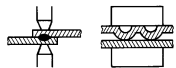


DALEX

SCHWEISSTECHNIK



A
SPOT
Welding machine



B
SPOT/PROJECTION
Welding machine



C
PROJECTION
Welding machine

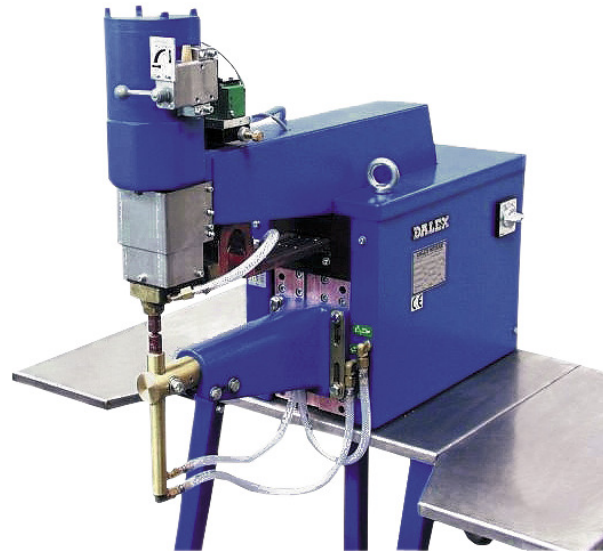


fig. PMS 10-4 T in model A
as spot welding machine

TECHNICAL DATA

Power rating at 50 % d.c:	16 or 32 kVA
Throat depth:	200, 350 or 550 mm
Electrode force:	65 -390 daN or 20-390 daN
Electrode stroke:	max. 65 mm Hub

TECHNICAL DETAILS

- machine frame and transformer form one unit
- non-distortion construction of the arms with welding fittings
- close coupling of the secondary circuits with good performance factor
- special electrode force cylinder with precision guide and external rotational protection
- electrode force can be infinitely regulated in pressure-reducing valve
- speed of working and return strokes of the cylinders can be regulated separately via throttle
- welding transformer fitted with water cooling and with thermal protective switch
- primary and secondary coils are vacuum cast
- lower arm made from solid cast brass, height infinitely adjustable
- 8-step switch as standard for power regulation, and compressed air service unit, consisting of pressure filter, regulator and manometer

EXTRA EQUIPMENT

- double stroke cylinder (DH), 45 + 20 mm Hub (not with model C)
- double stroke cylinder with travel for working stroke (DHZ), 0 - 45 mm working stroke + 20 mm operational stroke (not with Model C)
- cylinder with extended force range 20 - 390 daN, 65 mm stroke
- current-free touchdown of upper electrode via double-foot pedals (only with models A-EH)
- machine table with stainless steel top
- stainless steel worktops left and right
- pressure-compensating tool with rubber springs to compensate the workpiece tolerances and inaccuracy of the tools. Rapid and powerful repetition of movement of upper tool when welding
- connecting cable set between machine and control unit, standard length of primary and control leads ca. 3000 mm
- synchronised thyristor control as slide-in option

PMS 10-4 T

Resistance Welding machine

Resistance Welding machine Type PMS 10-4 T

TECHNICAL DATA acc.to DIN 44753

09/2006

valid for machines model A			Table spot welding machine															
Technical data for model B and C upon request			PMS 10-4 T / 16 kVA			PMS 10-4 T / 32 kVA												
Group	Throat depth ⁷⁾	mm	200	350	550	200	350	550										
Electrical Part	Machine Power	Power rating (50 % d.c.)	kVA			16			32									
		Continuous output	kVA			11,3			22,6									
		Maximum short-circuit power	kVA			80			62,9									
		Maximum welding power	kVA			64			55,4									
	Machine voltage	Secondary idling voltage	V						3,6(1,8/2,0/2,2/2,4/2,7/3,0/3,3/3,6)									
		Number of regulating steps							8									
	Mains connection	Rated primary voltage	V						400									
		Rated frequency	Hz						50									
		Supply power	kVA			48			41,6			37,7						
		Fusing (carrier)	A			50			36			36						
		Wire range ⁶⁾	mm ²			6			10									
	Secondary current	Rated operating current	kA			4,16			4,12			4,1						
		Permanent current ⁴⁾	kA			2,94			2,91			2,9						
		Short-circuit current	kA			20,7			17,8			16,3						
		Highest welding current	kA			16,6			14,2			13,1						
permit. duty cycle at highest weld. cur.		%			3,2			4,3			5							
Cylinder EH	Electrode stroke max.	mm						65										
	Electrode force min. / max.	daN						65-390 i.e. 20-390 ⁸⁾										
	Max. movements / 10mm stroke	min ⁻¹						400										
	Air consumption / 1000 strokes ⁵⁾	m ³						0,65										
Cylinder DH, DHZ	Electrode stroke max. work str. + op. str.	mm						65 / DH = 45 + 20 / DHZ = 0 - 45 + 20 - 65										
	Electrode force min. / max.	daN						65-390 i.e. 20-390 ⁸⁾										
	Max. movements / 10mm stroke	min ⁻¹						400										
	Air consumption / 1000 strokes ⁵⁾	m ³						0,75										
Spot mounting "A"	Throat gap min. / max.	mm						50/130										
	Electrode arm-Ø	mm						45										
	Electrode holder-Ø	mm						20										
	Electrode holder adjustability	mm						135										
Projection mounting "B" and "C"	Clamping plate length x width	mm			100 x 100			---			100 x 100							
	Clamping plate sep. min. / max.	mm			50/210			---			50/210							
	T-grooves / separation mm x no.	mm			8 DIN 650/63 x 2			---			8 DIN 650/63 x 2							
Comp. air	Pipe connection.							NG 13 - G½										
	Operating pressure min. / max.	bar						6/10										
Cooling water	Pipe connection in / out							NG 10 - G 3/8										
	Operating pressure min. / max. ¹²⁾	bar						2/5										
	Consumption at max. loading	l/min ⁻¹						4										
Machine dimensions	Width x depth x height ¹⁰⁾	mm						1100 x 805/955/1155 x 1270										
	Weight machine / cabinet ⁹⁾	kg			165/170			175/180			185/190							
Shipping data	Gross weight ⁹⁾	kg			325			355			385							
	Box: Width x depth x height ¹¹⁾	mm						625 x 905/1055/1255 x 1600										
	Volume	m ³			0,9			1,1			1,3							
Op. Part	Welding values	Sheet steel C-content < 0,2 % ²⁾	mm			5 + 5			4 + 4			3 + 3						
		Brass sheet ³⁾	mm			3 + 3			2 + 2			1 + 1						
		Aluminium sheet ³⁾	mm			1 + 1			0,8 + 0,8			0,5 + 0,5						
		Round steel Ø C-content < 0,2 % ²⁾	mm			16 + 16			14 + 14			12 + 12						
Power stage	Thyristor power stage	IW						1/60 L										
Notes	Technical alterations reserved. The table contents refer to standard models.																	
	1) operation class gL 2) C-Content ≤ 0,2 % 3) with synchronised control 4) with max. transformer level 5) at operating pressure 6 bar, stroke 20 mm						6) cable length < 15 m 7) with pre mounted electrode holder + 45 bis 85 mm 8) with extended electrode force range 9) with machine table and platens (table = 18 kg, each plate = 6 kg)						10) with double stroke height + 95 mm, with double stroke with setting stroke + 130 mm 11) platens screwed off 12) with closed circuit cooling = difference pressure between coolant forward motion/return motion					