



TWIN SPOT MODULAR SPOT WELDING UNITS

PM30 series

These modular double-spot welding units are particularly suitable in welding sheet components that are accessible from only one side.

They are pneumatically operated and fully water-cooled by one circuit passing through SCR, transformer and electrodes.

The structure is in welded steel, treated and machined.

The electronic control regulating all of weld parameters is fixed on the structure.

The units are designed with the weld cylinders for electrode movements in the front, and the weld transformer at the rear.

A positioning system located in the upper part allows the rotation of the unit.

The combination of the rotation of these units with their transversal movement allows the electrodes to cover a wide work area, particularly suitable both for use as single units or for using several ones on special fixtures or special purpose machines.



TECHNICAL DATA		
Nominal power at 50% duty cycle	KVA	30
Nominal primary voltage	V	400/230
Nominal frequency	Hz	50
Short circuit current	KA	19
Max secondary weld current	KA	15
Secondary current at 100%	KA	4,4
Secondary voltage	V	4,8
Intermittence at max weld current	%	8,5
Cable dia. Up to 30 m. line	mm ²	16/400V – 25/230V
Max electrode pressure at 6 atm (600 KPa) short arms	daN	150
Max distance between electrodes	mm	60
Max weld capacity (soft steel, shorts arms)	mm	1,2
Max weld capacity (cross wires short arms)	ømm	10+10
Compressed air pressure	KPa	600
Water consumption	L/min	5
Air consumption	MC/1000p	3,8
Actuation	ELECTROPNEUMATIC	
Cooling	WATER	
Dimensions BxLxH	mm	150x300x610
Weight	Kg	65