

SEAM-SPOT WELDING MACHINES T/T.I./L -SERIES

The structure of these seam-spot welding machines is made in welded steel. They are heat-treated and machined to

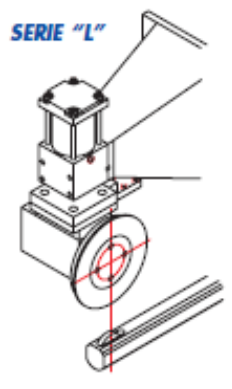
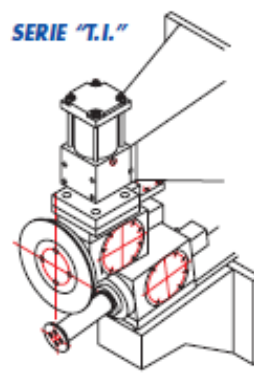
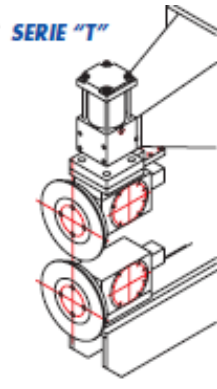
guarantee a high precision, rigidity and stress free structure.

The seam welding heads are fully ball raced and feature silver-plated friction contacts, precisely machined to ensure excellent contact for the welding current. They are also fully water-cooled.

Control of the heads is by three-phase synchronous motors equipped with inverter technology to ensure fine adjustment of the speed and of the weld movement.

The welding transformer is water-cooled and vacuum impregnated to guarantee the best continuity of seam-spot welding.

The digital electronic control is MICRO 8 type.



| TECHNICAL DATA | | Rulli T60 | Rulli T80 | Rulli | Rulli | Rulli L60 | Rulli L80 | Rulli |
|---|-----------------|-------------------|-------------------|-------------------|-------------------|-------------------|-------------------|-------------------|
| Nominal power at 50% duty cycle | KVA | 60 | 80 | 120 | 60 | 60 | 80 | 120 |
| Max short circuit power | KVA | 72 | 96 | 144 | 72 | 72 | 96 | 144 |
| Nominal primary voltage | V | 400 | 400 | 400 | 400 | 400 | 400 | 400 |
| Nominal frequency | Hz | 50 | 50 | 50 | 50 | 50 | 50 | 50 |
| Secondary voltage | V | 4,3 | 5,27 | 7,62 | 4,3 | 4,3 | 5,27 | 7,62 |
| Permanent secondary current | KA | 12 | 14 | 16 | 12 | 12 | 14 | 16 |
| Short circuit current | KA | 16 | 21 | 28 | 16 | 16 | 21 | 28 |
| Max secondary weld current | KA | 12 | 14 | 16 | 12 | 12 | 14 | 16 |
| Supply power | KVA | 67 | 96 | 136 | 67 | 67 | 96 | 136 |
| Line cable cross section (up to 40 m. from main switch) | mm ² | 35 | 50 | 75 | 35 | 35 | 50 | 75 |
| Weld force on electrodes (at 6 bars) | daN | 450 | 450 | 900 | 450 | 450 | 450 | 900 |
| Max weld capacity on mild steel sheets(S) | mm | 1,2+1,2 | 1,5+1,5 | 2+2 | 1,2+1,2 | 1,2+1,2 | 1,5+1,5 | 2+2 |
| Drive on (*) | | 1/2/3 | 1/2/3 | 1/2/3 | 2 | 1 | 1 | 1 |
| Weld speed | mm/s | 1÷500 | 1÷500 | 1÷500 | 1÷500 | 1÷500 | 1÷500 | 1÷500 |
| Actuation | | PNEUMATIC | | | | | | |
| Cooling | | WATER | | | | | | |
| Work throat depth | mm | S/M | S/M | S/M | S/M | S/M | S/M | S/M |
| Arm diameter | mm | - | - | - | - | 70 | 70 | 70 |
| Upper wheel diameter | mm | 200÷300 | 200÷300 | 200÷300 | 200÷300 | 200÷300 | 200÷300 | 200÷300 |
| Lower wheel diameter | mm | 200÷300 | 200÷300 | 200÷300 | 60÷80 | 80 | 80 | 80 |
| Vertical stroke of upper seam wheel | mm | 60 | 60 | 60 | 60 | 60 | 60 | 60 |
| Air consumption (mc/1000) | | 4,6 | 4,6 | 9,2 | 4,6 | 4,6 | 4,6 | 9,2 |
| Water consumption | l/min | 4 | 4 | 5 | 4 | 4 | 4 | 5 |
| Pressure of compressed air (1bar= 100KPa) | KPa | 600 | 600 | 600 | 600 | 600 | 600 | 600 |
| "S" type overall dimens.(**) | mm | 1260x790 x1590 | 1260x790 x1590 | 1260x790 x1735 | 1260x790 x1590 | 1260x790 x1590 | 1260x790 x1590 | 1260x790 x1735 |
| "M" type overall dimens.(**) | mm | 1800x790 x1590 | 1800x790 x1590 | 1800x790 x1735 | - | 1800x790 x1590 | 1800x790 x1590 | 1800x790 x1735 |
| "S" type weight (**) | Kg | 960 | 1010 | 1030 | 960 | 940 | 990 | 1010 |
| "M" type weight (**) | Kg | 1120 | 1170 | 1190 | - | 1030 | 1080 | 1110 |

(*) DRIVE ON

1 UPPER HEAD
2 LOWER HEAD
3 BOTH HEADS WITH DIFFERENTIAL GEAR

(**) WORK THROAT DEPTH

S L= 450 mm
M L= 1100 mm