

Modular  
double-point  
welding unit  
PM30

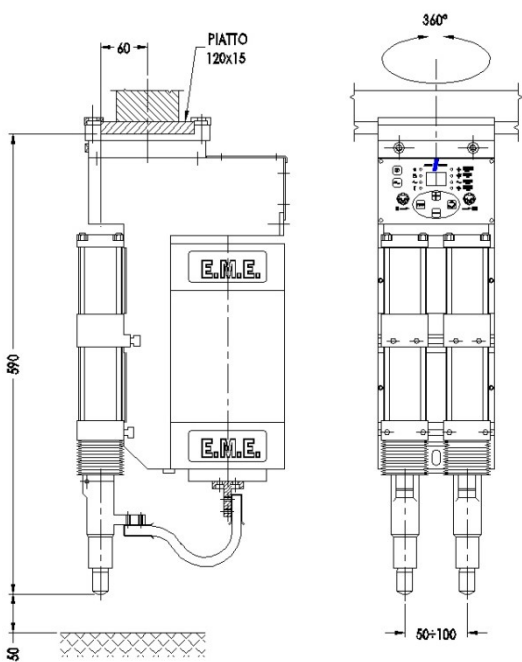


# Modular double-point welding unit PM30

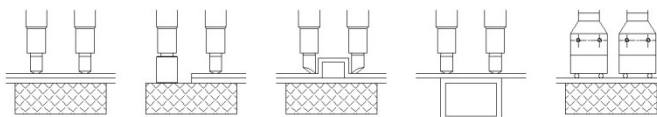
## PM30 MODULAR DOUBLE-SPOT WELDING UNIT

PM 30 modular double-spot welding unit with 30KVA power at 50%.

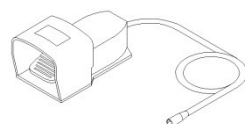
Modular resistance welding unit with double spot, especially suitable in welding of sheets accessible only from one side. Pneumatically operated and integrally cooled through single circuit for: SCR, transformer, electrode holder and electrodes. Built with an electro-welded steel structure and machined on a machine tool in which the electronic control for the adjustment of the welding parameters is entirely inserted. At the front are the pneumatic cylinders of electrode movement and at the rear the welding transformer. A special system mounted in the upper part of the unit allows it to be rotated and positioned. The combination of the rotation possibilities with the transverse displacement of the welding cylinders allows the electrodes to cover a large area, making it particularly suitable for single use as well as on special equipment.



### Welding methods

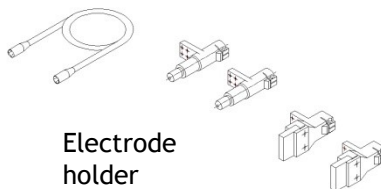


### Accessories



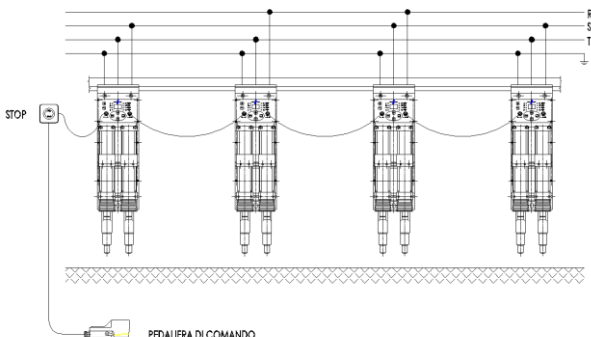
Control Pedal

Connection cable



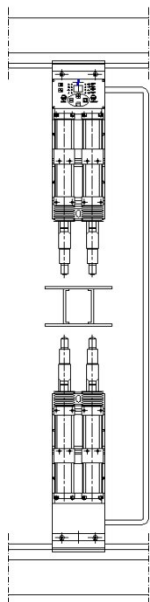
Electrode holder

# Modular double-point welding unit PM30



## MULTIPLE APPLICATIONS

The easy connection between the electric lines, compressed air lines and cooling water lines allows the user to create multiple welding systems which are both economically advantageous and perform technical integrations for complex systems.



## PUSH-PULL

The PUSH-PULL system is carried out connecting a secondary unit without the electronic part to a primary unit. This system allows welding of pieces which can't be welded with the standard unit.

## "MICRO3" DIGITAL WELD CONTROL BOARD

"MICRO3" synchronous digital electronic control board to set the weld parameters such as squeeze time, welding time, forging time, power measuring, possibility to exclude the unit, command for Weld/Don't weld test cycles, thermal protection of limit temperatures and connection connectors for input start command and communication with other spot-welding units. A special feature of this control board allows the performance of cycles of electrical cascade or pneumatic cascade according to the type of welding to be performed.



# Modular double-point welding unit PM30

TECHNICAL FEATURES	PM30
Nominal power at 50% ED	30 KVA
Nominal voltage	400 – 230 V
Nominal frequency	50 Hz
Short circuit current	19 KA
Maximum welding current	15 KA
Secondary current at 100% ED	4,4 KA
Vacuum secondary voltage	4,8 V
Permanent secondary current	1,6/3,5 KA
Duty cycle at maximum welding current	8,5 %
Power cable section	16 mm <sup>2</sup> 400V
Up to 30m line	25 mm <sup>2</sup> 230V
Max force at the electrodes	150 daN
Max electrode stroke	60 mm
Min/max distance between the electrodes	50/100 mm
Max welding capacity on mild steel	1,2 mm
Max welding capacity on cross wires	10+10 mm
Compressed air supply	600 KPA
Capacity	5 l/min
Air consumption (nominal pressure)	3,8 MC/1000PT
Operation	Electropneumatic
Cooling	Water
Dimension L x W x H	150 x 300 x 610 mm
Weight	65 Kg