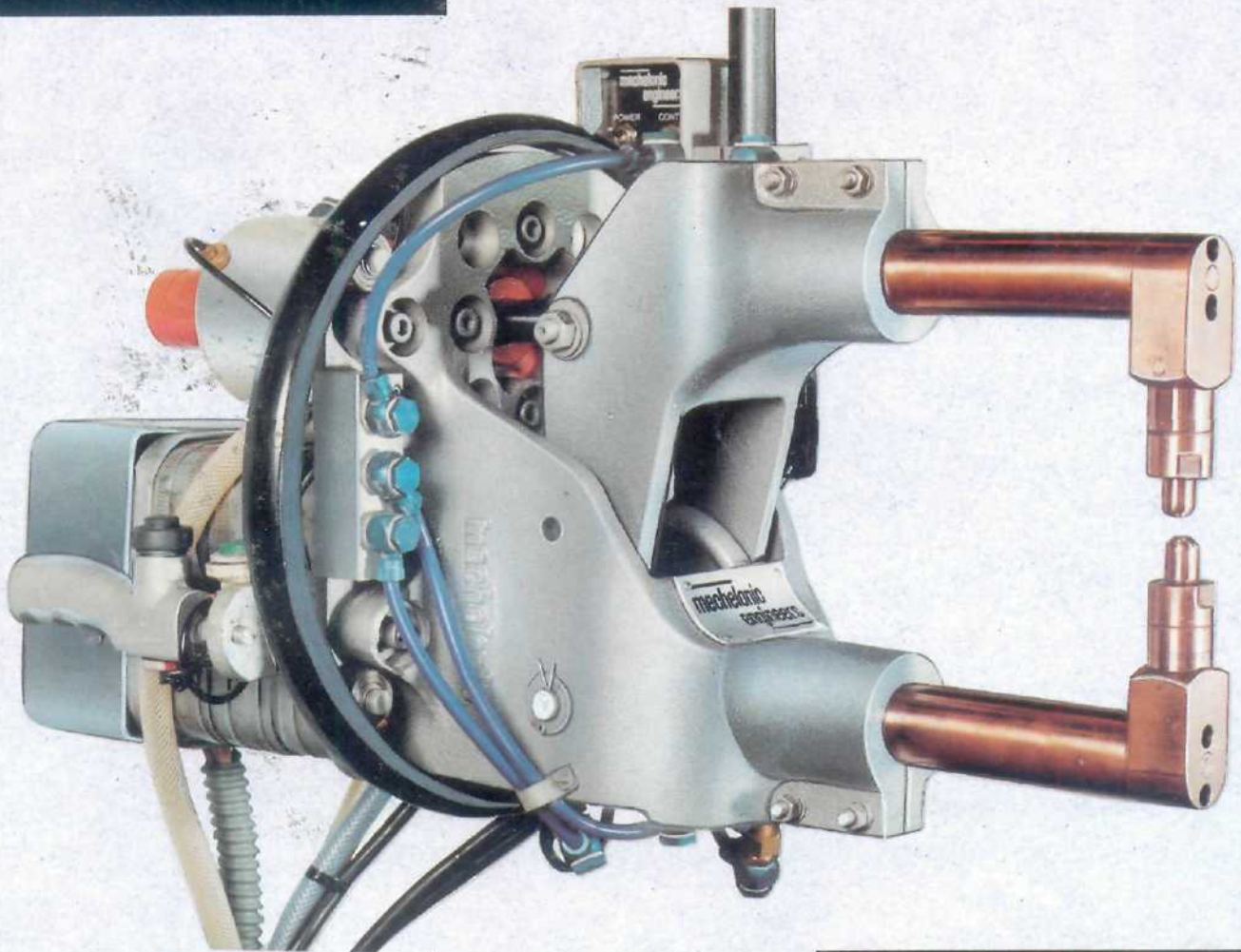


**mechelonic
engineers**



**PORTABLE
INTEGRAL
SPOT WELDING
GUNS**

MODEL : IT

GENERAL :

Integral type Transformers with gun are designed for minimising the transformer rating by avoiding cable length. These spot welding guns are for high-speed production of metal fabrication shop, particularly for the manufacture of automobile bodies and sub-assemblies. A variety of guns with different Throat depth and gap are available for difficult and complex welding set up.

SPECIFICATION :

Nominal rating :

20, 30 and 40 KVA

Type:

Portable suspension type spot welding guns with built-in transformer incorporated with pneumatic accessories such as filter, lubricator and regulator, solenoid valve, pressure gauge and pneumatic cylinder completely assembled and ready for operation. The arm material is generally as per IWMA type class 2 or class 3.

Suspension System :

Suitable suspension system will be supplied as per customer's requirement.

Cooling System :

Transformer and welding guns are water-cooled, inner-connecting hoses for water cooling within the assembly are provided.

Welding Transformer:

Transformer of special type, primary and secondary epoxy moulded, built with 'C' core material, secondary water-cooled, with thermal switch protection from overloading.

Welding Guns :

Welding guns of various types such as Scissor type and 'C' type,

pneumatically actuated, of various throat depths and gaps will be supplied depending on the applications.

Throat Depth & Gap :

Throat depth of 250 mm to 750 mm will be provided with the gun. The throat gap will be in the range of 160 mm to 300 mm.

Weld Initiation :

By means of electrical thump switch provided on the gun handle.

Electrode Control System :

Electrode movement of air-operated guns by actuation of a heavy duty air cylinder.

Compressed Air / Electrode Force :

Air 1.5 kg/cm² sq. - 7 kg. /cm. sq. (20 - 100 p.s.i.) acting in the air cylinder provides the electrode force and electrode force is adjusted through the air pressure regulator.

Electronic Control:

Electronic control model ME-201 - CMOS Integrated Circuit based OR Microprocessor based control model ME-101 can be supplied along with the machine as per the job demand and customer's choice.

SERVICE REQUIREMENTS :**Power Supply :**

415 V, single phase, 50 cycles.
Machine suitable for connection
to 2 lines of 3 phase supply.
Main supply cable 2 core type.
Disconnect switch fuses of

recommended size to be
provided by the customer.

Compressed Air:

Customer to provide air supply
at recommended flow volume
at a minimum pressure of
5.6 kg / cm sq. (80 p.s.i)

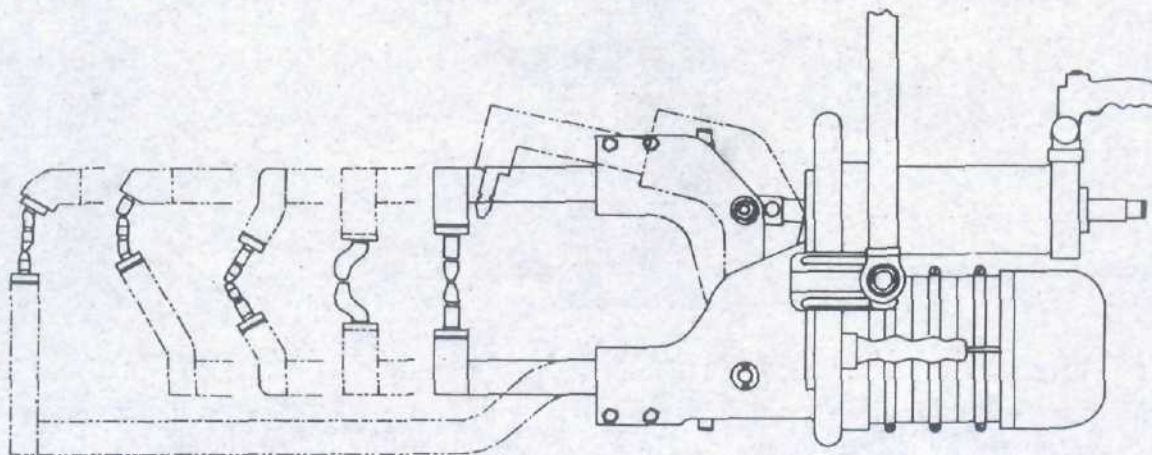
Cooling Water :

Cooling water at minimum
2.6 kg / cm. sq. pressure and
temperature below 30 degree
centigrade at flow rate of
25 ltrs. per minute to be
provided by the customer.

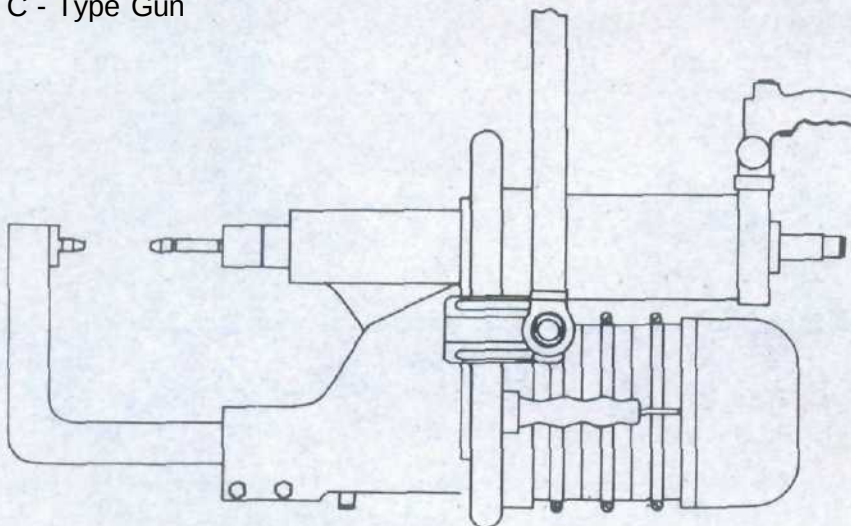
TECHNICAL DATA

Machine Model	No.	IT-20	IT-30	IT-40
Nominal Rating	KVA	20	30	40
Max. available currents (Short circuit) +15%	AMPS	12,000	15,000	19,000
Min. cooling water required :				
i) For Transformer and Gun	LPM	10	10	10
ii) For Thyristors	LPM	10	10	10
Maximum Electrode Force	KGF	400	400	400
Electrode	MT2 or ISO raper as desired by the cusomer.			
Welding Guns :	Generally as per the specifications given. The final gun drawings will be provided to the cusomer and will rake rheir approval before manufacruring.			

S - Type Gun



C - Type Gun



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