

# TECNA®

## Pneumatic Spot Welders • 35-50 kVA

4660 • 4661 • 4662 • 4663

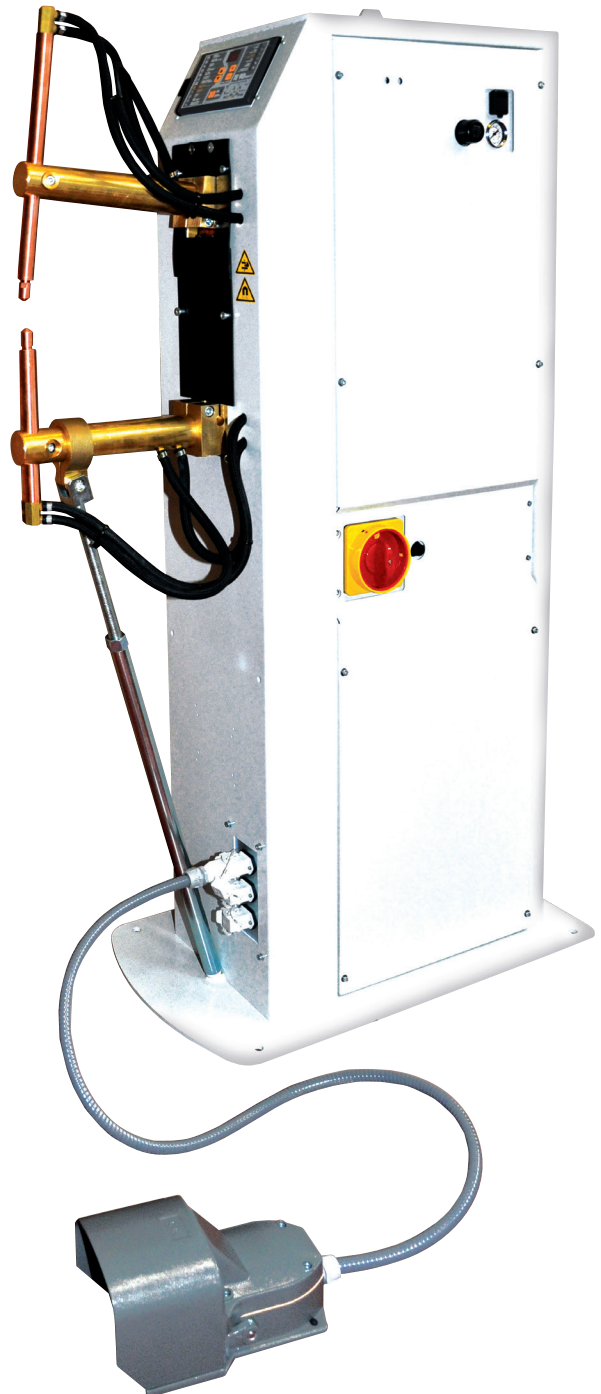
The pneumatic commands and the compressed air pressure gauge have been placed at the top for easier reading and adjustment

The control unit has been positioned on the front of the machine to allow the operator to view the welding data even during the working cycle



### Key Features

- Chrome-copper electrode holders for long life and heavy duty service, designed for straight and angled fitting
- Water cooled epoxy resin coated transformer
- Water cooled arms, electrodes and electrode holders
- Microprocessor control unit TECNA TE101
- USB port for data storage (only with TE550)
- The air operated lubrication free cylinder eliminates oil mist
- Protected filter assembly with gauge
- Two stage electric foot control for clamping the welding pieces in the correct position prior to welding
- Pre-connected for additional electric foot pedal for the direct recalling of welding program No.2. This function is helpful when different kinds of welding are to be performed on the same piece
- Arms: gap 280mm, adjustable depth 320mm (Option 4638)
- Adjustable electrodes stroke for max. working rate



Order Code		4660	4661	4662	4663
Nominal power @ 50%	kVA	35	35	50	50
Maximum welding power	kVA	75	62	104	82
Maximum short circuit current	kA	17.5	14	21	16.5
Thermal current 100%	A	4500	4500	5700	5700
No load secondary voltage	V	5.4 (4)	5.4 (4)	6.1	6.1
Supply voltage 50Hz *	V	400	400	400	400
Cables section L=30m	mm <sup>2</sup>	16	16	35	35
Delayed fuses	A	63	63	100	100
Insulation class		F	F	F	F
Min. throat depth	mm	280	480	280	480
Max. electrode force (@ 6 bar)	daN	425	260	425	260
Electrode stroke	mm	5 - 50	5 - 75	5 - 50	5 - 75
Max. throat depth	mm	600	800	600	800
Max. electrode force (@ 6 bar)	daN	210	160	210	160
Electrode stroke	mm	5 - 95	5 - 120	5 - 95	5 - 120
Max. short circuit current with max. throat depth	kA	12.9	10.9	14.3	12.2
Gap min. (option 4638)	mm	195	195	195	195
Gap max. (option 4638)	mm	500	500	500	500
Max. short circuit current max. gap (option 4638)	kA	11	11	12.6	12.6
Arms diameter	mm	50	50	50	50
Electrode holders diameter	mm	25	25	25	25
Standard electrodes cone diameter	mm	14.8	14.8	14.8	14.8
Compressed air supply	bar	6.5	6.5	6.5	6.5
Air for 1000 spots (6 bar)	Nm <sup>3</sup>	6.2 - 4.8	6.2 - 4.5	6.2 - 4.8	6.2 - 4.5
Water cooling	l/min	4	4	4	4
Aerial noise produced	dB(A)	<70	<70	<70	<70
<b>Measure conditions</b>					
Working stroke	mm	20	20	20	20
Welding time	cycles	14	21	15	24
Welding current	kA	13.1	10.5	16	12.4
Working rating in welds/min		15	15	15	15
Net weight (approximately)	Kg	218	223	228	233

\* Different voltages & frequencies on request