

## Spot Welding Machine SL

rocker arm, pneumatically-operated

### Technical Data:

type:	SL 100	SL 200
power rating at 50%:	8/12kVA	20/30/50kVA
rated voltage:	400V/50Hz	
throat depth:	130-300mm	130-500mm
throat gap:	160mm	205mm
electrode force max:	360daN	420daN
electrode holder-Ø:	16mm	25mm
electrode seat:	Mk1	Mk1/Mk2
start:	foot switch	



### Technical Details:

- solid machine frame
- high powered transformer
- throat depth infinitely adjustable
- electrode force can be infinitely regulated
- pressure air service unit
- main switch acc. to VDE 0113
- 3m connecting lead

### Extra Equipment:

- throat depth 380-700mm (only at SL 200)
- double foot pedal for operation mode „currentless contact“
- special parts for invisible welding of stainless steel
- welding control MPS 10  
5-times 8 welding programs



### Welding Control:

#### RS 17 (standard)

- 5-times-synchronised-welding control
- 2 welding programs
- single spot and series spot
- upslope and impulse function
- automatic mains recognition of 50/60Hz
- mains voltage compensation
- status display via LED's
- international operating symbols



- **Tube arm**  
for spot welding of cylindrical parts



- **Angle shaped electrode holder**  
for welding of steel profiles



- **Vice electrode**  
for welding of one sheet disc on one rod. The rod carry the current and is clamped in a vice electrode



- **Pendular and arbor electrode holder**  
for welding of wire fences



## Spot Welding Machine SL 102/104 + SL 202/204/206

technical Data acc. to DIN 44753 / ISO 669

Type		SL102	SL 104	SL 202	SL 204	SL 206		
Article-no.		11-101-103	11-101-105	11-101-202	11-101-204	11-101-206		
Throat depth	mm	130-300		130-500				
Machine power	Power rating (50%)	kVA	8	12	20	30	50	
	Continuous output	kVA	5,65	8,48	14,1	21,2	35	
	Maximum short-circuit power	kVA	22,7	36	56,8	108	150	
	Maximum welding power	kVA	18,2	28,8	45,4	86,4	120	
Machine voltage	Secondary idling voltage	V	2,6	3,2	3,7	5,2	5,9	
	Number of regulation Steps		0					
Mains connection	Rated primary voltage	V	400					
	Rated frequency	Hz	50/60					
	Supply power	kVA	13,65	21,6	30	55,2	80	
	Fusing (carrier)	A	63/25	63/25	63/35	63/63	63/63	
	Wire range (cable length < 15m)	mm <sup>2</sup>	2,5	2,5	6	10	16	
Secondary current	Rated operating current	kA	1,75	3,79	5,4	5,8	8,2	
	Permanent current	kA	1,24	2,68	3,8	4,1	5,8	
	Short-circuit-current	kA	9,1	11,2	15	20	25	
	Highest welding current	kA	7,3	8,9	12	16	20	
	Permit. Duty cycle at highest weld cur.	%	2,88	9,07	10	6,5	8,4	
Cylinder EH single stroke	Electrode stroke max.	mm	50		50			
	Electrode force max.	daN	360		420			
	Max. movements at 10mm stroke	min <sup>-1</sup>	60		60			
	Air consumption / 1000 strokes	m <sup>3</sup>	0,1		0,1			
Spot mounting	Throat gap	mm	160		205			
	Electrode arm-Ø	mm	32		45			
	Electrode holder-Ø	mm	16		25			
	Spot electrode seat		Mk1		Mk1/Mk2			
Comp. air	Pipe connection		NG 16 / G ½"		NG 16 / G ½"			
	Operating pressure max.	bar	6		6			
Cooling water	Pipe connection in / out		NG 8 / G ¼"		NG 8 / G ¼"			
	Operating pressure max.	bar	5		5			
	Entry temperature	°C	18		18			
	Consumption at max. loading	l/min	4		4			
Machine measurements	Width x depth x height	mm	360 x 785 x 1150		430 x 1.190 x 1.260			
	Weight	kg	115	122	180	196	200	
Power stage	Thyristor power stage		RS_17_LS		RS_17_LS			
Welding values	Steel sheet (C-content ≤ 0,2%)	mm	1,5+1,5		4+4		5+5	6+6
	CrNi sheet	mm	0,75+0,75		1+1		1+1	1+1
	Round steel-Ø (C-content ≤ 0,2%)	mm	max. 6+6		max. 8+8		max. 12+12	max. 16+16

Technical alterations reserved. The table contents refer to standard models.

### Water recooling units:

#### Air-Water Recooler

cooling to no more than 5-8°C above the ambient temperatures

Type LWK 17  
Article-no. 40-186-017

Cooling power 2kW  
Rated voltage 230V/50Hz  
Pump power 0,25kW  
Water tank capacity 10l



#### Cooling-Water Recooler

with a fully-hermetic motor compressor and electronic thermostat with LCD display

Type IK-V 07/B  
Article-no. 40-186-072

Cooling power 0,9kW  
Rated voltage 230V/50Hz  
Pump power 0,25kW  
Water tank capacity 6l

