

# Foot operated spot welders Items 4640-4644 - 16-25 kVA

Rocker arm, foot operated, spot welder, with TE90 microprocessor welding control unit. Nominal power at 50% d.c. from 16 to 25 kVA

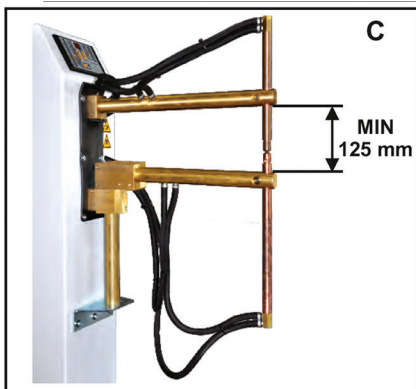
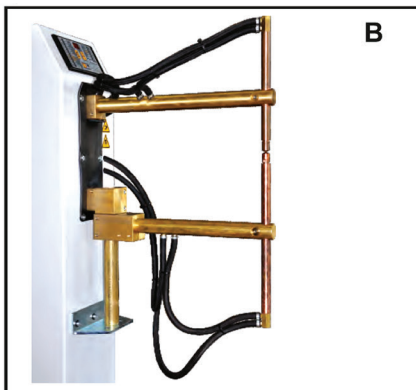
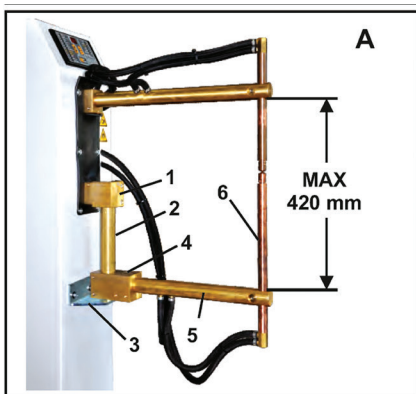
# TECNA<sup>®</sup>

## Features

TECNA spot welders are designed to meet every need of spot welding. The new stationary ergonomic frame designed by TECNA helps to facilitate the operator's work. The control unit has been positioned frontally to allow the operator to view the welding data even during the working cycle.

## MAIN WELDER FEATURES

- Arms adjustable in length allowing a better working flexibility.
- Chrome-copper electrode-holders for long life and heavy duty service, designed for straight and angled fitting.
- Adjustable electrode stroke.
- Epoxy resin coated transformer.
- Water-cooled transformer, arms and electrodes.
- Microprocessor control unit TECNA TE90.
- Adjustable electrode force; a microswitch starts the welding cycle when the desired pre-set value is reached.
- The foot pedal is adjustable in length.



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ITEM		• 4640	4641	•4642	• 4643	4644
Nominal power at 50%	kVA	16	20	20	25	25
Maximum welding power	kVA	35	48	39	68	55
No load secondary voltage	V	3.4	4	4	4.6	4.6
Maximum short circuit current	kA	12.5	14.5	12	18	14.5
Maximum welding current on steel	kA	10	11.6	9.6	14.4	11.6
Thermal current 100%	A	3300	3500	3500	3800	3800
Supply voltage 50Hz *	V	415	415	415	415	415
Cables section L=10 m	mm <sup>2</sup>	6	10	10	16	16
Cables section L=30 m	mm <sup>2</sup>	10	10	10	16	16
Delayed fuses	A	32	40	40	50	50
Min. electrodes throat depth	mm	230	230	380	230	380
Max. electrode force (6 bar)	daN	240	240	150	240	150
Electrode stroke	mm	8-44	8-44	10-60	8-44	10-60
Max. electrodes throat depth	mm	550	550	700	550	700
Max. electrode force (6 bar)	daN	95	95	80	95	80
Electrode stroke	mm	15-85	15-85	15-105	15-85	15-105
Short circuit current with L max.	kA	8.4	10	8.8	13	10.5
Arms diameter	mm	36	40	40	40	40
Electrode-holders diameter	mm	19	22	22	22	22
Standard electrodes cone diameter	mm	12.7	14.8	14.8	14.8	14.8
Water cooling	l/min	2.5	3	3	3.7	3.7
Aerial noise produced	dB(A)	< 70	< 70	< 70	< 70	< 70
Measure conditions						
Working stroke	mm	20	20	20	20	20
Welding time	cycles	21	17	26	14	20
Welding current	kA	9.4	11	9	13.5	11
Working rating in welds/min		10	10	10	10	10
Net weight (approximately)	kg	135	143	146	145	148

\* Different voltages and frequencies on request

• Normal stocked models / All other models ordered on request

### 16 kVA ELECTRODES



Art-3720  
Straight

Art-3721  
Offset

Art-3722  
Angled

Art-3723  
Bent

Art-3724  
Flat

Art-3625  
Swivel



Art-4726



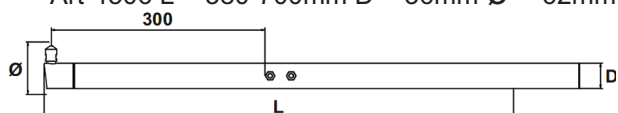
Art-4727



Art-4729



Art-4506 L = 380-700mm D = 36mm Ø = 62mm



Art-4509 L = 380-700mm D = 360mm Ø = 45mm

