

SPARE PARTS

The first number of the code has the following meaning:

- 1... standard components widely available from industrial suppliers (e.g. screws, washers, nuts, etc.).
- 2... commercial components which, providing that the same quality parameters are adopted, can be purchased anywhere (filter lubricator regulator units, thyristors, pressure gauges, hoses, switches etc.).
- 3... components manufactured by TECNA.
- 4... components manufactured by TECNA.
- 5... electronic circuits and assemblies manufactured by TECNA.
- 7... assemblies composed of parts belonging to any or all of the above codes but which for the sake of simplicity are available ready-assembled.

All spare parts, standard, commercial or TECNA, are available from TECNA. When ordering please always state: item, code number, quantity, voltage and frequency, the number and year of manufacture. The number followed by an asterisk warns that you must state both voltage and working frequency.

REMEDIES FOR WELDS IMPERFECTIONS

This chapter has been introduced in order to facilitate the troubleshooting of the most common imperfections caused by a wrong adjustment. Notice that each one can be caused by different causes as there are many parameters affecting the welding process. The following table specifically refers to low carbon steel spot welding, but, with the due considerations, it can be useful also for other applications.

FAULT	POSSIBLE CAUSE	POSSIBLE REMEDY
Weak welding	Low welding current.	Increase it.
	Low welding time.	Increase it.
	Too high electrodes force.	Reduce pressure.
	Lacking electrodes maintenance or too high electrodes diameter.	Clean and line up the electrodes, restore their dimensions.
	Faulty pieces contact.	Increase the electrodes force.
Spatter of melted material	Paint or dirt among pieces.	Clean the pieces.
	Inadequate electrodes cooling.	Check the cooling circuit.
	Faulty pieces contact or pieces and electrodes faulty contact.	Increase the electrodes force by increasing pressure.
	Too high welding current.	Reduce it.
	Too high welding time.	Reduce it.
	Too small electrodes diameter.	Adjust diameter to the value shown on the table.
	Inadequate welding force.	Increase pressure.
	Electrodes faulty clamping of the pieces.	Check stroke.
Burned welds or welds showing either craters or fissures.	Too high welding current.	Reduce it.
	Inadequate welding force.	Increase welding pressure.
	Oxidised pieces to weld.	Clean them by means of emery paper.
	Faulty pieces contact or pieces and electrodes faulty contact.	Increase electrodes force.
	Faulty pieces lining up.	Correct it.
	Electrodes tips deformations.	Restore them to the correct seize.
Pieces stuck weld on the electrode	Too high welding current.	Reduce it.
	Inadequate electrodes diameter.	Restore it to the correct dimensions
	Inadequate welding force.	Increase the welding pressure.
Electrodes and connections reduced life (position 81)	Under-seized electrode in comparison with the work to carry out.	Check both seize and contact diameter.
Secondary connection reduced life and oxidation.	Heating caused by an inadequate clamping of the flexible connection.	Carefully tighten the clamping screws.
	Too high heating caused by a too high welding rate.	Reduce it.

7911	7913	7915	POS.	QT.	CODICE	DENOMINAZIONE	DENOMINATION	DENOMINATION	DENOMINACION	BEZEICHNUNG
.	.	.	1	1	10087	Vite	Screw	Vis	Tornillo	Schraube
.	.	.	2	2	10319	Cuscinetto	Bearings	Roulements	Cojnetes	Lager
.	.	.	3	1	38044	Sospensione	Suspension	Suspension	Suspension	Kreiselaufhängung
.	.	.	4	1	31360 31370	Boccola	Bush	Bague	Casquillo	Büchse
.	.	.	5	1	44450	Protezione	Protection	Protection	Proteccion	Schutz
.	.	.	6	1	10090	Rondelle	Washers	Rondelles	Arandelas	Scheiben
.	.	.	7	1	44002	Anello	Ring	Bague	Aro	Ring
.	.	.	8	1	10425	Dado	Nut	Ecrou	Tuerca	Mutter
.	.	.	9	2	10416	Rivetti	Rivets	Rivets	Remaches	Nieten
.	.	.	10	4	10660	Viti	Screws	Vis	Tornillos	Schrauben
.	.	.	11	9	10008	Rondelle	Washers	Rondelles	Arandelas	Scheiben
.	.	.	12	1	38021	Porta braccio	Arm-holder	Porte-bras	Portabrazo	Armhalter
.	.	.	13	4	10023	Viti	Screws	Vis	Tornillos	Schrauben
.	.	.	14	10	10054	Anelli di fermo	Circlips	Bague de tenue	Anillos elasticos	Feststellringe
.	.	.	15	1	30126	Biella	Rod	Bielle	Biela	Pleuelstange
.	.	.	16	1	10083	Vite	Screw	Vis	Tornillo	Schraube
.	.	.	17	1	10369	Dado	Nut	Ecrou	Tuerca	Mutter
.	.	.	18	2	30097	Isolanti	Insulators	Isolants	Aislante	isolierer
.	.	.	19	1	30071	Asse	Axe	Axe	Eje	Achse
.	.	.	20	2	30042	Assi	Axes	Axes	Ejes	Achsen
.	.	.	21	1	30124	Leva	Lever	Levier	Leva	Hebel
.	.	.	22	1	31265	Silenziatore	Silencer	Silencieux	Silenciador	Stossdämpfer
.	.	.	23	2	10285	Spine	Pins	Goupilles	Clavijas	Stifte
.	.	.	24	1	49158	Impugnatura	Handle	Poignee*	Empunadura	Griff
.	.	.	25	2	10158	Dadi	Nuts	Ecrous	Tuercas	Muttern
.	.	.	26	1	38642	Pulsante	Push-button	Poussoir	Pulsador	Knopf
.	.	.	27	1	31266	Perno	Pin	Tourillon	Perno	Stift
.	.	.	28	1	20585	Raccordo	Connection	Raccord	Racord	Anschluss
.	.	.	29	1	20077	Distributore	Distributor	Distributeur	Distribuidor	Verteller
.	.	.	30	2	10311	Viti	Screws	Vis	Tornillos	Schrauben
.	.	.	31	2	10277	Rondelle	Washers	Rondelles	Arandelas	Scheiben
.	.	.	32	1	30248	Stelo	Stem	Tige	Vastago	Spindel
.	.	.	33	m.0,5	20588	Tubo	Tube	Tuyau	Tubo	Schlauch
.	.	.	34	1	38583	Supporto	Support	Support	Soporte	Halter
.	.	.	35	4	10501	Viti	Screws	Vis	Tornillos	Schrauben
.	.	.	36	1	30127	Boccola	Bushing	Douille	Casquillo	Bochse
.	.	.	37	1	31245	Molla	Spring	Ressort	Muelle	Feder
.	.	.	38	1	30118	Pistone	Piston	Piston	Piston	Kolben
.	.	.	39	1	10080	O Ring	O Ring	O Ring	Aro	O-Ring
.	.	.	40	1	10028	Vite	Screw	Vis	Tornillo	Schraube
.	.	.	41	1	31247	Cilindro	Cylinder	Verin	Cilindro	Zylinder
.	.	.	42	1	10196	Anello di fermo	Circlip	Bague d'arret	Anillo elastico	Feststellring
.	.	.	44	1	30373	Pistone TOR	Piston	Piston	Piston	Kolben
.	.	.	46	1	30381	Molla	Spring	Ressort	Muelle	Feder
.	.	.	47	1	10500	O Ring	O Ring	O Ring	Aro	O-Ring
.	.	.	48	1	44407	Supporto	Support	Support	Soporte	Halter
.	.	.	49	1	31244	Leva	Lever	Levier	Leva	Hebel
.	.	.	50	3	10120	O Ring	O Ring	O Ring	Aro	O-Ring
.	.	.	51	3	20584	Raccordi	Connections	Raccords	Racords	Anschlosse
.	.	.	52	3	20587	Raccordi	Connections	Raccords	Racords	Anschlosse
.	.	.	53	1	30040	Passacavo	Cable guide	Guide du cable	Pasabornes	Kabelschutz
.	.	.	54	1	10065	Rondella	Washer	Rondelle	Arandela	Scheibe
.	.	.	55	2	10195	Viti	Screws	Vis	Tornillos	Schrauben
.	.	.	56	1	20000	Microinterruttore	Microswitch	Microinterrupteur	Microinterruptor	Mikroschalter
.	.	.	57	1	30130	Isolante	Insulator	Isolant	Aislante	isolierer
.	.	.	58	3	10044	Viti	Screws	Vis	Tornillos	Schrauben
.	.	.	59	1	31243	Fermacavo	Cable clamp	Serre-cable	Pasabornes	Kabelklemme
.	.	.	60	3	31249	Spina	Pin	Goupille	Clavija	Stift
.	.	.	61	2	30848	Resche	Nippel	Nippel	Pitorro	Nippel
.	.	.	62	2	20401	Fascette	Clamps	Colliers	Abrazaderas	Schellen
.	.	.	63	1	31267	Pomello	Knob	Molette	Pomo	Knopf

7911	7913	7915	POS.	QT.	CODICE	DENOMINAZIONE	DENOMINATION	DENOMINATION	DENOMINACION	BEZEICHNUNG
.	.	.	64*	1	50142	Timer	Timer	Temporisateur	Temporizador	Zeitgeber
.	.	.	64	1	50143	Timer/Pulse	Timer/P	Timer/P	Timer/P	Timer/P
.	.	.	65	1	20060*	Cavo aliment. m. 4	Mains cable 4 m	Cable reseau 4 m	Cable alimentacion 4 m	Anschlusskabel 4 m
.	.	.	66	1	31264	Manopola	Knob	Molette	Mango	Griff
.	.	.	67	2	10463	Viti	Screws	Vis	Tornillos	Schrauben
.	.	.	68	1	10498	Vite	Screw	Vis	Tornillo	Schraube
.	.	.	69	1	10497	Vite	Screw	Vis	Tornillo	Schraube
.	.	.	70	1	49159	Impugnatura	Handle	Poignee	Empunadura	Griff
.	.	.	71	6	10326	Viti	Screws	Vis	Tornillos	Schrauben
.	.	.	72	m 4	20101	Tubo aria	Air hose	Tuyau air	Tubo de aire	Luftschlauch
.	.	.	73	1	20229	Manometro	Pressure gauge	Manometre	Manometro	Manometer
.	.	.	74	1	20070	Filtro riduttore	Filter unit	Filtre detendeur	Filtro reductor	Druckreduzierfilter
.	.	.	75	1	47212	Calotta posteriore	Back housing	Carter posterior	Carcasa posterior	Hinteres Gehäuse
.	.	.	76	4	10066	Viti	Screws	Vis	Tornillos	Schrauben
.	.	.	77	1	44426*	Trasformatore	Transformer	Transformateur	Transformador	Transformator
.	.	.	78	1	31250	Bobina	Coil	Bobine	Bobina	Spule
.	.	.	79	1	30090	Fermo	Stop	Arret	Tope	Feststeller
.	.	.	80	1	32419	Connessione	Connection	Connexion	Conexion	Anschluss
.	.	.	81	1	38022	Connessione	Connection	Connexion	Conexion	Stromband
.	.	.	82	1	30160	Asse	Axe	Axe	Eje	Achse
.	.	.	83	1	32426	Asse	Axe	Axe	Eje	Achse
.	.	.	84	1	32416	Targa	Plate	Plaque	Tarjeta	Schild
.	.	.	85	4	10028	Viti	Screws	Vis	Tornillos	Schrauben
.	.	.	86	4	10088	Cuscinetti	Bearings	Roulements	Cojinetes	Lager
.	.	.	87	4	10024	Rondelle	Washers	Rondelles	Arandelas	Scheiben
.	.	.	88	4	10013	Viti	Screws	Vis	Tornillos	Schrauben
.	.	.	88	4	10060	Viti	Screws	Vis	Tornillos	Schrauben
.	.	.	89	1	49142	Calotta anteriore	Front housing	Carter avant	Carcasa anterior	Vorderes Gehäuse
.	.	.	90	2	20033	Fascette	Circlips	Circlips	Abrazadera	Schellen
.	.	.	91	2	10147	Viti	Screws	Vis	Tornillos	Schrauben
.	.	.	92	1	10101	Vite	Screw	Vis	Tornillo	Schraube
.	.	.	93	2	30075	Isolanti	Insulators	Isolants	Aislantes	Isolierer
.	.	.	94	1	30078	Isolante	Insulator	Isolant	Aislante	Isolierer
.	.	.	95	1	30076	Isolante	Insulator	Isolant	Aislante	Isolierer
.	.	.	96	4	10009	Dadi	Nuts	Ecrous	Tuercas	Muttern
.	.	.	97	1	20451	Connettore	Connector	Connecteur	Conector	Anschluss
.	.	.	98	1	10059	Vite	Screw	Vis	Tornillo	Schraube
.	.	.	99	1	30159	Isolante	Insulator	Isolant	Aislante	Isolierer
.	.	.	100	1	30079	Isolante	Insulator	Isolant	Aislante	Isolierer
.	.	.	101	1	38020	Portabraccio	Arm holder	Porte-bras	Portabrazo	Armhalter
.	.	.	102	2	30074	Isolanti	Insulators	Isolants	Aislantes	Isolierer
.	.	.	103	1	10061	Vite	Screw	Vis	Tornillo	Schraube
.	.	.	104	1	30070	Protezione	Protection	Protection	Proteccion	Schutz
.	.	.	105	1	30088	Isolante	Insulator	Isolant	Aislante	Isolierer
.	.	.	106	2	20080	Fascette	Clamps	Colliers	Abrazadera	Schellen
.	.	.	107	m 9	20082	Tubo	Tube	Tuyau	Tubo	Schlauch
.	.	.	108	4	20452	Contatti	Contacts	Contacts	Contactos	Kontakte
.	.	.	109	1	.	Spina	Plug	Fiche	Enchufe	Stecker
.	.	.	110	1	44171	Calotta	Housing	Carter	Carcasa	Gehaose
.	.	.	110	1	44847	Calotta	Housing	Carter	Carcasa	Gehaose
.	.	.	111	1	20002	Impugnatura	Handle	Poignee	Empunadura	Griff
.	.	.	112	1	10316	Vite	Screw	Vis	Tornillo	Schraube
.	.	.	113	2	10804	Rondelle	Washers	Rondelles	Arandelas	Scheibe
.	.	.	114	1	10483	Rondelle	Washers	Rondelles	Arandelas	Scheiben
.	.	.	115	2	10654	Anello	Ring	Bague	Aro	Ring
.	.	.	116	1	31370	Rondella	Washer	Rondelle	Arandela	Scheibe
.	.	.	117	m 0,35	20081	Tubo acqua	Water cable	Tuyau eau	Tubo	Wasserschlauch
.	.	.	118	1	44341*	Trasformatore	Transformer	Transformateur	Transformador	Transformator
.	.	.	119	2	10148	Rondelle	Washers	Rondelles	Arandelas	Scheiben
.	.	.	120	5	10627	Dadi	Nuts	Ecrous	Tuercas	Muttern
.	.	.	121	3	10098	Rondelle	Washers	Rondelles	Arandelas	Scheiben
.	.	.	122	1	21234	Innesto	Coupling	Raccord	Racord	Einsatz
.	.	.	123	1	21233	Rubinetto automatico	Automatic tap	Robinet automatique	Valvula automatica	Autom. hahn
.	.	.		1	70231	Cilindro completo	Complete cylinder	Vérin complet	Cilindro completo	Zylinder kompl.



