

Kirpekar

PROJECTION WELDING MACHINE



PROJECTION WELDING MACHINE APPLICATIONS

- ★ Automobile Industries
- ★ Switchgear Industries (Press Parts Projection Welding)
- ★ Refrigeration Industries
- ★ Consumer Appliances
- ★ Shock Absorbers
- ★ Nut & Stud Welding
- ★ Widow Regulator

PROJECTION WELDING MACHINE FEATURES

- ★ Fabricated rigid steel frame structure
- ★ Frictionless RAM for Quick Response
- ★ Deflection Free Precision Movement
- ★ Top & Bottom 'T' Slot Tables
- ★ Adjustable Lower Arm (Optional)
- ★ Low Impedance Transformer (AC, 3 Phase DC and MFDC)
- ★ Microprocessor based Welding Controller Kirpekar-make
- ★ Frictionless RAM with LM guides
- ★ Deflection Free precise movement

OPTIONAL ACCESSORIES (EXTRA COST)

- ★ Water Flow Indicator
- ★ Water Flow Switch
- ★ Pressure Switch
- ★ Non Return Valve
- ★ Chiller Unit
- ★ Fume Extractor
- ★ Anti Vibration Pads
- ★ Photo Guard
- ★ MCB/MCCB
- ★ Fixture

PROJECTION WELDING STANDARD SPECIFICATION

Model	KPW-75	KPW-100	KPW-150	KPW-300
TRANSFORMER				
Capacity at 50 % Duty Cycle	75 KVA	100 KVA	150 KVA	300 KVA
Rated Input Voltage	415 V	415 V	415 V	415 V
Max. Short Circuit Current in KA	25	30	35	50
WELD HEAD				
Cylinder dia X Stroke in mm	150 X100	150 X 100	200 X100	250 X100
Max. Weld Force at 6 bar in kgf	600	800	1400	2000
Throat Depth in mm	200	200	200	200
Throat Gap adjustment in mm	200 - 400	200 - 400	200 - 400	200
T Slot Table size in mm	150 X 150	150 X 150	250 X 250	250 X 250
Cooling Water Volume in l/mm	40	40	40	40
Machine Size in mm *(W X D X H) (Approx)	690 X 1240 X 2540	690 X 1240 X 2540	690 X 1240 X 2540	690 X 1240 X 2540
Machine Working Height in mm	900-1000	900-1000	900-1000	900-1000

Based on product improvements etc., appearance (as shown in the picture) and performance are subject to change without notice.

*Machine Size- W X D X H – Width X Depth X Height (Approx)

Projection Welding Machine also available

- 3 Phase DC
- MFDC (Medium Frequency Direct Current)

Facility Data

Specification Model	Nominal Power	Welding Power			Control Power		Compressed Air				Cooling Water (See note (3))				Earth Cable	
		Voltage	Fuse Capacity	Connecting Cable See Note 1	Voltage	Connecting Cable	Pressure	Air Volume (See Note (2))	Charging Hose Inner Dia.	Compressor Capacity	Pressure	Inlet Temp.	Flow Volume	Hose Inner Diameter		
														Water Feed		Water Exhaust
KVA	V	A	mm ²	V	mm ²	Kgf/cm ²	L/mm	mm	KW	Kgf/cm ²	°C	L/mm	mm	mm	mm ²	
KPW 75	75	415	250	80	24	1.25	5 ~ 7	120	9.5	1.5	1 ~ 3	Less than 30 ^o	20	12.7	19	14
KPW 100	100	415	250	90	24	1.25	5 ~ 7	120	9.5	1.5	1 ~ 3	Less than 30 ^o	20	12.7	19	14
KPW 150	150	415	300	100	24	1.25	5 ~ 7	120	9.5	1.5	1 ~ 3	Less than 30 ^o	20	12.7	19	14
KPW 300	300	415	600	110	24	1.25	5 ~ 7	120	9.5	1.5	1 ~ 3	Less than 30 ^o	20	12.7	19	14

Notes:

- 1) Connection cable has the min. section indicated, heat wise. The cable size may be enlarged according to wiring method and distance.
- 2) Compressed air volume indicates the atmospheric volume with 20mm electrode stroke, welding speed of 30s.p.m. and 5 kgf/cm² air pressure
- 3) The Compressor capacity is fixed by this volume.
- 4) Industrial water with electric resistance over 500 Ω-cm is used.

SPECIFICATION

Model Name	KE - AC - 2B														
Welding Power Supply Voltage	220/415 V AC 50 Hz														
Control Power Supply Voltage	24 V AC 50 Hz														
Control Method	Primary Current Feedback														
Timer Setting	<table border="0"> <tr> <td>SCHEDULES</td> <td>15</td> </tr> <tr> <td>PRE-SQUEEZE</td> <td>00-99 Cycles</td> </tr> <tr> <td>SQUEEZE</td> <td>00-99 Cycles</td> </tr> <tr> <td>Weld Cycles (I,II,III)</td> <td>00-99 Cycles</td> </tr> <tr> <td>COOL Cycles (I,II)</td> <td>00-99 Cycles</td> </tr> <tr> <td>HOLD Cycles</td> <td>00-99 Cycles</td> </tr> <tr> <td>OFF</td> <td>00-99 Cycles</td> </tr> </table>	SCHEDULES	15	PRE-SQUEEZE	00-99 Cycles	SQUEEZE	00-99 Cycles	Weld Cycles (I,II,III)	00-99 Cycles	COOL Cycles (I,II)	00-99 Cycles	HOLD Cycles	00-99 Cycles	OFF	00-99 Cycles
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HOLD Cycles	00-99 Cycles														
OFF	00-99 Cycles														
Current Setting Range in %	00 - 99% 00 - 50 kA														
Valve Voltage	24 V DC														
Counter Range	0000-9999														
Dimension (in mm)	120 (W) X 220 (H) X 90 (D)														
Weight (In Kg)	2 Kg														

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Versatile Easy to operate Microprocessor based control unit Kirpekar's easy to use KE-AC-2B contact current resistance weld controls. This system allows the weld control to quickly respond to changes in current during welding.

Advantage

- (i) Secondary Feedback Constant Current Control.
- (ii) Upto 15 schedules can be stored in its memory for instant recall.
- (iii) Built in weld monitor : Allows viewing of all programs, parameters etc.
- (iv) Production Counter and job counter.



Registered Office & Works

KIRPEKAR ENGINEERING (P) LTD.

Plot No: 8 A, Rasoni Industrial Park, MIDC, Phase II, Hinjewadi, at Post Maan, Tal. Mulshi, District Pune: 411 057. INDIA
Tel: +91-20 6674 1600 / 07. Telefax: +91-20 6674 1601. Email: sales@kirpekarengg.com Website: www.kirpekarengg.com

Sales Office : ▶ Pune ▶ New Delhi ▶ Chennai ▶ Bangalore ▶ Ludhiana ▶ Ahmedabad
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