

PROJECTION WELDING MACHINE

Kirpekar



PROJECTION WELDING MACHINE APPLICATIONS

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

Features

- * Fabricated rigid steel frame structure
- * Frictionless RAM for Quick Response
- * Deflection Free Precision Movement
- * Top & Bottom 'I' Slot Tables
- * Adjustable Lower Arm (Optional)
- * Low Impedance Transformer (AC, MFAC and MFDC)
- * Microprocessor based Welding Controller Kirpekar-make
- * Frictionless RAM with LM guides
- * Deflection Free precise movement

Standard Specifications

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/min	40	40	40	40
Machine Size in mm *(W X D X H) (Approx)	680 X 1240 X 2540	680 X 1240 X 2540	680 X 1240 X 2540	680 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	Welding Power				Control Power				Compressed Air				Cooling Water (See note (3))				Earth Cable
	Maximal Power	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/min	mm	KW	Kgf/cm ²	°C	L/min	mm	mm	mm	
KPW 75	75	415	250	(8)	24	1.25	5 " 7	120	9.5	1.5	1 " 3	Less than 30	20	12.7	19	14	
KPW 100	100	415	250	95	24	1.25	5 " 7	120	9.5	1.5	1 " 3	Less than 30	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	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	20	12.7	19	14	

Notes:

1) Connecting cable has the min. section indicated, heat wire. 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 - 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	SCHEDULES 15 PRE-SQUEEZE 00-99 Cycles SQUEEZE 00-99 Cycles Weld Cycles 00-99 Cycles (I,II,III) COOL Cycles 00-99 Cycles (I,II) HOLD Cycles 00-99 Cycles OFF Cycles
Current Setting Range	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)	3 Kg

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Features of KEPL Controller:

- Versatile
- User Friendly
- Microprocessor based control unit
- Quick feedback system

Advantages :

- (i) Secondary Feedback Constant Current Control.
- (ii) Up to 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.
- (v) Program Lock Facility.
- (vi) Inbuilt system for water & air pressure error signals



OPTIONAL ACCESSORIES (EXTRA COST)

- * Water Row Indicator
- * Water Row Switch
- * Pressure Swab
- * Non lcom valve
- * Chiller Unit
- * Fume Extractor
- * Anti Vibration Pads
- * Photo Guard
- * MCB/MCCB
- * Fixture

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Registered office & Works:

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