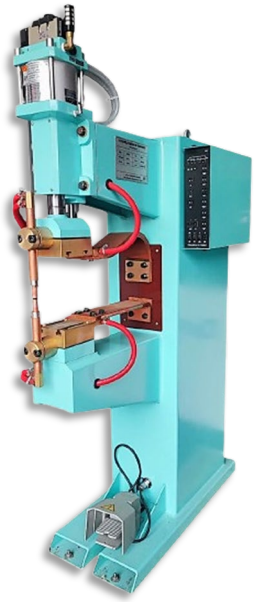
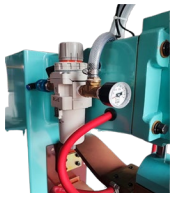
AC SPOT (PROJECTION) WELDER





ADVANTAGE & CHARACTERISTICS :

- √ The machine frame is designed for impact resistance, vibration resistance, and high rigidity, and is precision-machined to ensure accurate mounting and load strength of all components.
- √ An aluminum-alloy cylinder barrel, low-damping seals, and low-friction piston rings are combined in the cylinder, and an externally-piloted, high-flow solenoid directional valve is fitted to deliver faster response and extremely sensitive follow-up performance, achieving exceptionally high welding speed.
- √ The secondary circuit adopts an insulated connection between the pressurizing cylinder seat and the upper arm, allowing welding fixtures to be mounted directly on the lower seat without risk of short-circuiting—simple and practical.
- √ The main welding circuit uses a fully internal water-cooled resistance-welding transformer and water-cooled, high-power SCR elements, providing robust power output.
- √ The unit can be flexibly paired with a variety of digital or microcomputer controllers to meet high-, medium-, and low-spec welding requirements.
- √ The cooling-water circuit features independent flow indicators and regulators for each line, and the main inlet is fitted with a water filter to prevent blockages.
- √ The highly efficient pneumatic layout minimizes line damping and air-supply loss; key pneumatic components are imported, premium-grade brands for long life and high reliability.
- √ Operation is straightforward: ergonomic design makes setup, lubrication, maintenance, and servicing quick and easy.

MODEL	A	B	C	D	E	F	G	H	J	K	L	M	N
DN-25	980	405	1535	500	250	810	755	800	320	260	-	405	-
DN-63	1035	450	1670	500	265	840	805	850	360	300	-	410	-
D(T)N-63	1035	450	1670	500	265	840	805	850	360	300	220	410	200
D(T)N-100	1065	560	1670	460	270	835	865	910	400	340	220	380	240
D(T)N-200	1210	620	1885	450	315	845	1055	1100	460	400	250	350	300

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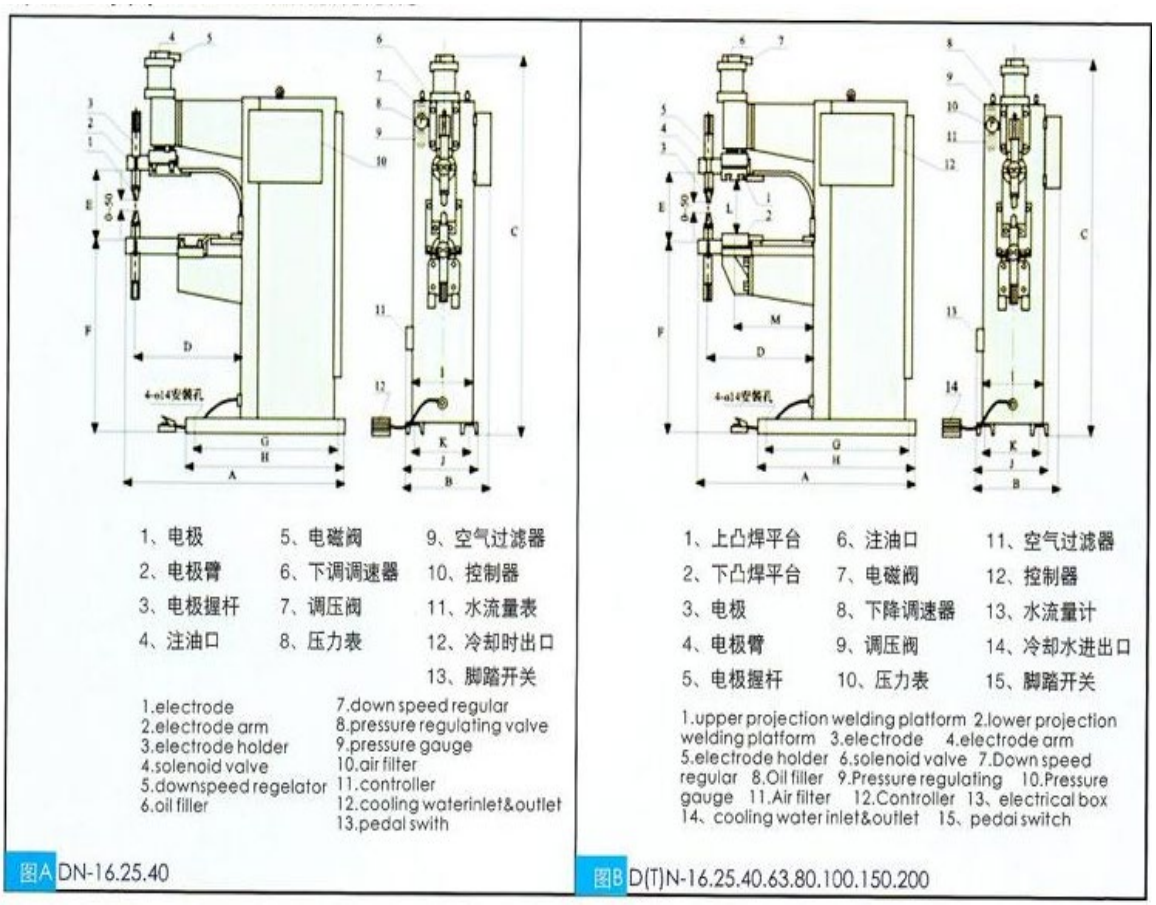

MODEL	DN-25	D(T)N-63	D(T)N-100	D(T)N-200
Rated Capacity (KVA)	25	63	100	200
Rated Primary Voltage (V)	380			
Rated Frequency (Hz)	50/60			
Max Short Circuit Current (A)	13500	22000	31500	42000
Load Duty Cycle (%)	50			
Arm Extension Dimension (mm)	220*500	220*500	220*450	250*450
Max Pressure Supply (N)	3900	6000	6000	10000
Electric Electrode Stroke (mm)	60	30/60	30/60	40/100
Water Cooling Volume (L/min)	3	4	8	12
Weight (kg)	220	340	400	790
Electrode Head (mm)	13	16	16	20
Electrode Lever (mm)	20 x 180	25 x 190	25 x 190	32 x 200
Electrode Arm (mm)	50 x 150	60 x 200	60 x 200	80 x 240
Projection Welding Platform (mm)	-	110*130	120*130	150*160
Overrid Welding of Two Pieces Low Carbon Steel	-	3.5+3.5	4.5+4.5	6.0+6.0

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Key Advantage Summary

- √ Analog control = maximum stability
- √ Multi-stage welding = stronger welds
- √ Easy adjustment = high productivity

Technical Explanation – Analog Spot Welding Controller (SKD2)

This spot welding machine is equipped with a new-generation analog welding IC timer (SKD2), designed for high stability, precise timing control, and long-term reliability, especially in industrial production environments.

1) Analog IC Control – High Reliability

- Uses analog IC-based timing control, not software-dependent.
- Immune to software crash, memory loss, or program corruption.
- Ideal for factories requiring consistent welding quality over long operating hours.
- Excellent resistance to electrical noise and voltage fluctuation.

2) Multi-Stage Welding Sequence Control

The controller supports a complete spot welding cycle, ensuring strong and uniform weld nuggets:

- SQ (Squeeze Time)

Ensures electrodes fully clamp the workpiece before current flows.

- WI / HEAT I (Pre-Heat)

Preheating stage to stabilize resistance and reduce spatter.

- CO (Cool Time)

Short cooling interval between weld pulses.

- WI / HEAT II (Main Weld)

Primary welding current for nugget formation.

- HO (Hold Time)

Maintains electrode pressure after welding to strengthen joint.

- OF (Off Time)

Ends the cycle and prepares for the next weld.

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Each stage is controlled by independent rotary / digital dial timers, allowing precise adjustment.

3) Adjustable Welding Parameters

- Weld Time I & II – Dual-pulse welding for thicker or coated materials.
- Heat / Current Control – Fine tuning for different metal thickness.
- Cool Time & Hold Time – Improves weld strength and appearance.
- Slow Up Function – Gradual current rise to reduce electrode wear and spatter.

4) Visual Status Indicators

- LED indicators display current welding stage in real time.
- Power, Heat, and COSϕ (power factor) indicators for monitoring machine condition.
- Helps operators quickly diagnose operation status.

5) Simple, Operator-Friendly Design

- No programming required – set and weld.
- Mechanical switches and dials ensure:
- Easy maintenance
- Low failure rate
- Suitable for semi-skilled operators
- Ideal for high-volume repetitive spot welding.

6) Industrial Applications

Suitable for:

- Sheet metal fabrication
- Wire mesh welding
- Automotive parts
- Stainless steel & mild steel spot welding
- Furniture and rack manufacturing

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