

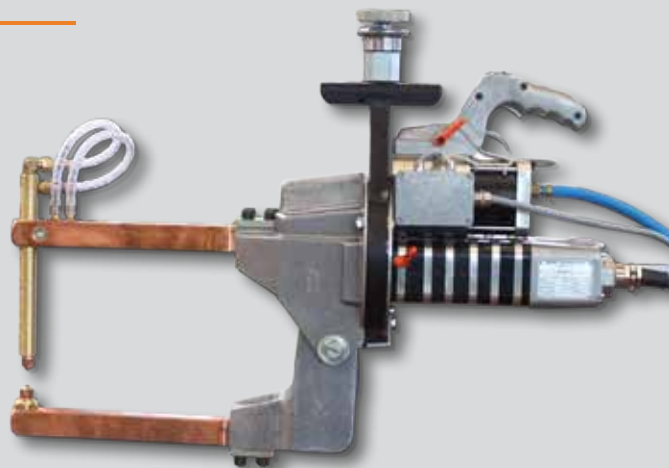
SPOT WELDING GUNS

33

3328-6

APPLICATION AREA

DALEX Spot welding guns of the series 33 find application in series operations for industrial usage.



TECHNICAL DATA

Type	3328-6
Power rating at 50 % d.c.	25 kVA
Sec. short-circuit current	22,5 kA
Throat gap	118 mm
Electrode force	600 daN
Welding power	Steel sheet 4 + 4 mm
Compatible welding control	B 200 Free stand. weld. contr. with slide in MPS 10
Compatible control unit	COOL 1
comp. spring balancer (throat depth 170-350 mm)	D5/60
comp. spring balancer (throat depth 500-800 mm)	D5/75

TECHNICAL DETAILS

- double stroke cylinder
- User-friendly stroke adjustment
- gun and electrode arms, water-cooled
- distortion free square electrode arms with electrode radiation-welded heads
- low-deflection square electrode arms for optimum performance of the electrode force
- rotation-resistant square mounting in gun body
- sliding section for longer horizontal positioning
- electro-pneumatic long stroke - operation
- intensively-cooled welding transformer and secondary circuit
- universal usage possible via an cylinder with 600 daN electrode force
- throat gap in two variations
- closed Cardan ring with safety hanger
- universal usage possible via an all-round mounting system
- welding transformer cast resin sandwich construction
- welding quality remains constant via the same sandwich construction
- toggle-joint system for raising electrode force
- connecting cable in standard 10m length and low connected load
- fusing 63 A

SPOT WELDING GUN Type 3328-6

Technical Data acc. to DIN 44753 / ISO 669			3328-6				
Throat depth	mm		170	350	500	650	800
Machine power	Power rating, 50 % d.c	kVA	25				
	Continuous rating	kVA	17,7				
	Max. short-circuit power	kVA	110	93	83,5	76	68,5
	Max. welding power	kVA	88	75	67	55	
Machine voltage	Secondary idling voltage	V	4,75	4,75	4,75	4,75	4,75
	Number of regulating steps		0				
Mains connection	Rated primary voltage	V	400				
	Rated primary current	A	66				
	Rated frequency	Hz	50				
	Supply power	kVA	66	56	50	45,5	41
	Primary short-circuit current	A	290	245	220	200	180
	1) Main switch / Fusing	A	63				
	Wire range for cable length shorter = 10 m	mm ²	10				
Secondary current	Rated operating current	kA	5,1	5,1	5	4,95	4,95
	2) Continuous current	kA	3,6	3,6	3,55	3,5	3,5
	Short-circuit current	kA	22,5	18,5	16,5	15	13,5
	Max. welding current	kA	18	14,8	13,2	12	10,8
	Perm. duty cycle at highest welding current	%	4	5,9	7,2	8,2	10,5
Cylinder DH	Electrode stroke max. work stroke + approach stroke max.	mm	51/33+0-18 ⁶⁾	91/58+0-33 ⁶⁾	127/80+0-44 ⁶⁾	157/101+0-56 ⁶⁾	120/122+0-68 ⁶⁾
	7) Electrode force max.	daN	600 (633)	335 (358)	240 (263)	195 (208)	150 (172)
	Max. movements at 10 mm stroke	min ⁻¹	100				
	3) Air consumption for 1000 strokes	m ³	1,1				
Spot mounting	Throat gap	mm	118 i.e. 248 ⁸⁾				
	height x width	mm	35 x 35 / 34 x 34,5 = Spigots				
	Electrode holder Ø	mm	25				
	Electrode holder, adjustability	mm	155				
	Spot electrode seat no. / outer Ø	mm	8/18				
Compressed air	Pipe conn. nominal width / conn. thread	mm	NG 10 (hose connector)				
	Operating pressure min. / max.	bar	6/10				
Cooling water	Pipe conn. nominal width / conn. thread		NG 10 (hose connector)				
	9) Operating pressure min. / max.	bar	2/5				
	Consumption at max. loading	l/min ⁻¹	6				
Gun dimensions	4) Width x depth x height excl. fittings	mm	Gun 338 x 610 x 425; Hanger 70 x 300 x 960 Space reqd. compl. 433 x 610 x 1200				
	4) Weight / Gun / hanger compl. excl. fittings	kg	46/5,5/51,5				
Welding values	Steel sheet	mm	4 + 4	3,5 + 3,5	3 + 3	2,5 + 2,5	2 + 2
	Round steel 15 % penetration	mm	12 + 12				
Power conductor	5) Thyristor power stage		1/60 L				

Notes:

- 1) operation class gL
- 2) at. max transformer level
- 3) at operating pressure 6 bar
- 4) subject to influences
- 5) relative duty cycle & max. current time during the total time see separate loading diagram

- 6) stroke travel by working stroke
- 7) measured value at 6 bar operating pressure () = theoretical values
- 8) incl. extended electrode throat gap
- 9) by circulatory cooling=pressure difference between recooling and cooling water in/out

Technical alterations reserved.
*Details for shortest throat depth.