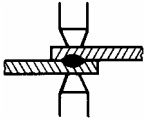


DALEX

WELDING TECHNOLOGY



rocker-arm –
SPOT- welding machine



fig. Series SF / SL 100

TECHNICAL DETAILS

- 1-time synchronised welding control with thyristor power stage
- welding power finely adjustable
- digital current and time setting
- overload protection via thermal contact
- electrode holder axially adjustable
- throat depth infinitely adjustable
- main switch acc. to VDE 0113
- 3 m connecting lead excl. plug
- conforms to the standards VDE 0545-1, EN 60204-1, EN 50 240, EN 292 parts 1+2, EN 1050
- CE - displayed

TECHNICAL DATA SF / SL 102 / 104

Power rating at 50 %:	8 kVA / 12 kVA
Secondary short-circuit current:	9,1 kA / 11,2 kA
Standard throat depth	130 – 300 mm
Throat gap:	160 mm
Electrode force max (SF):	220 daN
Electrode force max (SL):	360 daN

Series SF / SL 100

Resistance welding machines

DALEX Spot welding machines SF / SL 102 / 104

Technical Data* acc. to DIN 44753 / ISO 669			SF / SL 102	SF / SL 104	
Throat depth		mm	130 – 300	130 – 300	
Electrical Part	Machine power	Power rating (50% d.c.)	kVA	8	12
		Continuous output	kVA	5,65	8,48
		Maximum short-circuit power	kVA	22,7	36
		Maximum welding power	kVA	18,2	28,8
	Machine voltage	Secondary idling voltage	V	2,6	3,2
	Mains connection	Rated primary voltage	V	400	400
		Rated frequency	Hz	50	50
		Continuous output	kVA	13,65	21,6
		Main switch acc. to VDE	A	63	63
		Safety classification GL	A	25	25
		Wire range (cable length smaller = 15 m)	mm ²	2,5	2,5
	Secondary current	Rated operating current	kA	1,75	3,79
		Continuous current	kA	1,24	2,68
		Short-circuit current	kA	9,1	11,2
		Highest welding current	kA	7,3	8,9
		Permitted duty cycle at highest welding current	%	2,88	9,07
Mechanical Part	Spot mounting	Throat gap	mm	160	160
		Electrode arm Ø	mm	32	32
		Electrode holder Ø	mm	16	16
		Electrode holder, adjustability	mm	105	105
		Spot electrode seat no./outer Ø	mm	1/12,5	1/12,5
		Electrode stroke max.	mm	50	50
	Electrode force max.	daN	220 / 360	220 / 360	
	Compressed air	3) Max. movements	strokes/min	60	60
		3) Air consumption / 1000 strokes	m ³	0,1	0,1
		3) Pipe connection		NG16 – G1/2	NG16 – G1/2
		3) Operating pressure max.	bar	6	6
	Cooling water	Pipe connection in / out		NG 8 – G ¼	NG 8 – G ¼
Operating pressure max.		bar	5	5	
Consumption at max. loading		l/min	4	4	
Machine measurements	width x depth ²⁾ x height	mm	360 x 785 x 1150	360 x 785 x 1150	
	Weight ca.	kg	115	122	
Operational Part	Welding values	1) Sheet steel C-content smaller = 0,2 %	mm	1,5 + 1,5 max. 2,5 + 2,5	3 + 3 max. 3,5 + 3,5
		CrNi sheet	mm	1 + 1	1 + 1
		Round steel Ø C-content smaller = 0,2 %	mm	5 + 5 max. 6 + 6	6 + 6 max. 8 + 8

Notes:

- 1) dependant on size influences
- 2) Indication incl. foot pedal
- 3) only SL

Technical alterations reserved.

*details for shortest throat depth.