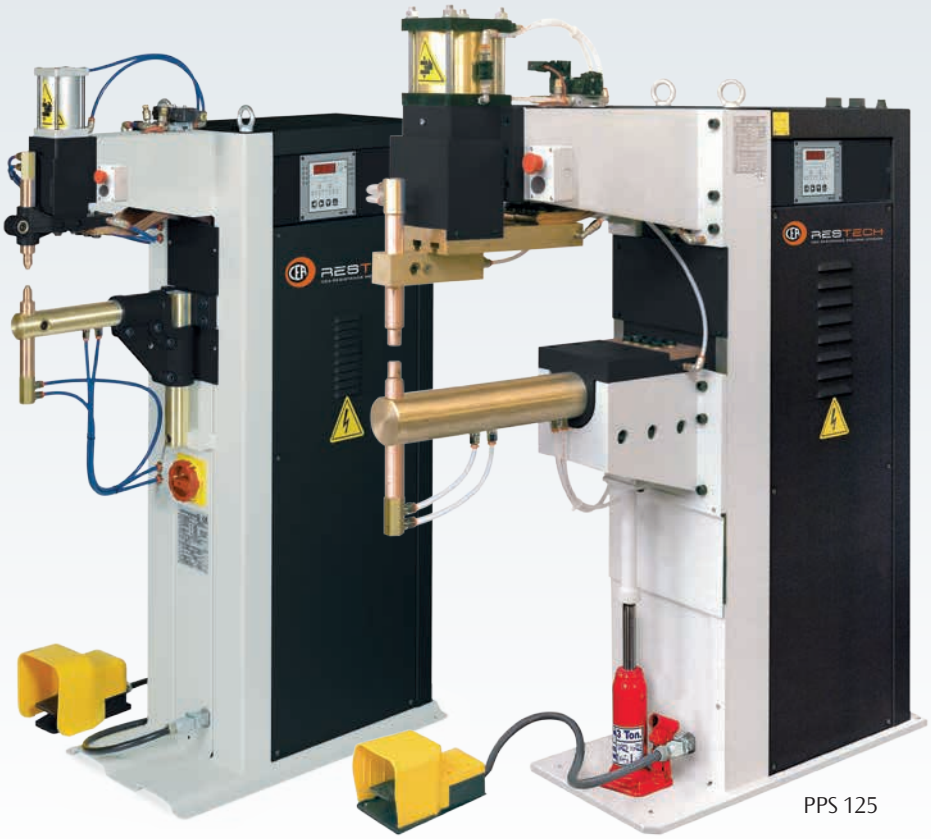
PPS

RESTECH
CEA RESISTANCE WELDING DIVISION

VERTICAL STROKE SPOT WELDERS

PPS models, developed appositely for spot welding jobs, fully satisfy a wide range of the heaviest large production industrial applications. Equipped with a microprocessor control, upon request they can be supplied in special configurations or fitted with an optional safety concomitant push button external unit.



PPS 125

1~ AC DIGITAL 888

PPS 35 - 60

- Lower round arm with adjustable height and lateral adjustment
- Lower arm holder can be adjusted for use with larger arm gap

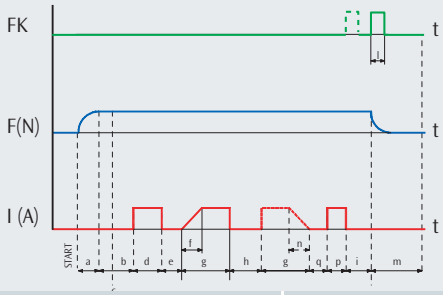
PPS 125

- Upper head low friction driving system for precision welding

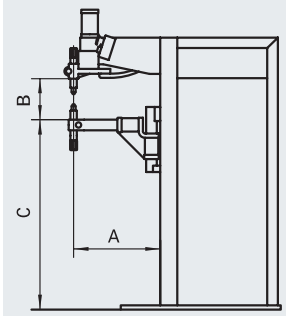
- Excellent welding on all weldable metals
- Synchronous ignition SCR group with phase shift welding current adjustment to eliminate initial transient
- Thermostatic protection on the SCR group
- High welding currents with low consumption
- Self-lubricated pneumatic components to eliminate oil deposits and to safeguard the environment from contaminants
- Water cooled secondary circuit, i.e. electrodes, electrodeholders and transformer, to avoid overheating
- Water cooled copper electrodeholders with adjustable height
- Electrode force adjustable by pressure reducer group equipped with a manometer and filter for automatic air impurity expulsion
- Upper electrode movement by self-lubricated double effect pneumatic cylinder fitted with speed regulator, end stroke shock-absorber and silencer for compressed air discharge
- Manual valve for upper head descent without pressure for cleaning, centering and ordinary maintenance of the electrodes
- Solenoid valve to control welding cylinder
- Cycle stop emergency button

WS 708 ELECTRONIC CONTROL

- 8 programs
- Half period welding time
- Pre-heating current
- Two 24 V DC solenoid valves
- 50/60 Hz frequency
- Mains voltage compensation
- Error message
- Weld/no weld switch
- Single or multi spot



	FUNCTIONS	WS 708
a	Pre-squeeze time	•
b	Squeeze time	•
c	Pressure contact	•
d	Preheating time	•
e	Cooling time	•
f	Slope up time	•
g	Welding time	•
	Welding current	•
h	Pulse interval time	•
i	Holding time	•
l	Cycle end contact	•
m	Pause time	•

PPS				PPS 35	PPS 60	PPS 125
	A		mm	395	435	500
	A (Optional)		mm	-	650	700
	B	MIN.	mm	140	180	170
		MAX.	mm	400	510	320
	C	MIN.		690	615	710
		MAX.		950	945	860
			Ø mm	50	60	88
			Ø mm	30	35	35

TECHNICAL DATA		PPS 35	PPS 60	PPS 125
Single phase input 50/60 Hz	V	400	400	400
Rated power at 50%	kVA	35	60	125
Short circuit power	kVA	86	142	368
Max. welding power	kVA	69	113	294
Installed power	kVA	20	38	80
Cross section connecting cables	mm^2	25	35	95
Delayed fuse	A	63	100	250
Open Circuit Voltage	V	4,5	5,9	11,5
Short circuit current	kA	19	24	32
Max. welding current	kA	15,2	19,2	25,6
Thermal secondary current at 100%	kA	3,9	7,2	7,68
Work stroke	mm	60	65	100
Max. electrode force (6 bar)	daN	230	470	900
Water consumption at 300 kPa (3 bar)	l/min	6	7	8
Dimensions	↗ mm	1005	1070	1370
	→ mm	410	430	420
	↑ mm	1425	1520	1750
Weight	kg	200	335	700

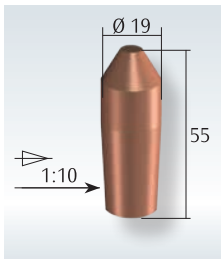
Other voltages on request.

Technical features might change without notice.

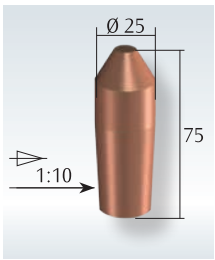
OPTIONAL

- Safety concomitant push button external unit (optional)
- Different length arms (optional)
- Lower arms with pressed-in electrode (for entering pipes or boxes) and longer electrodeholder on the upper arm (Optional)

Push button external unit



Electrode PPS 35/60



Electrode PPS 125