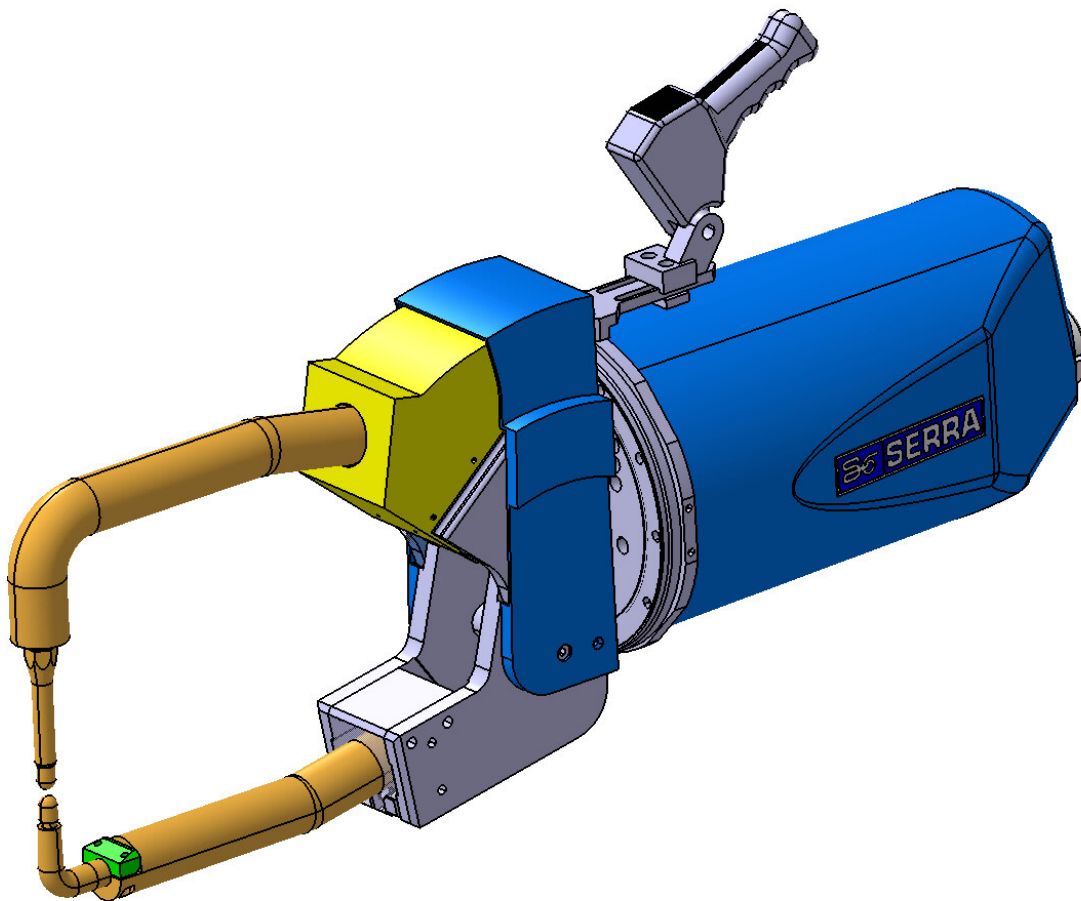


# ***MANUAL WELDGUN***

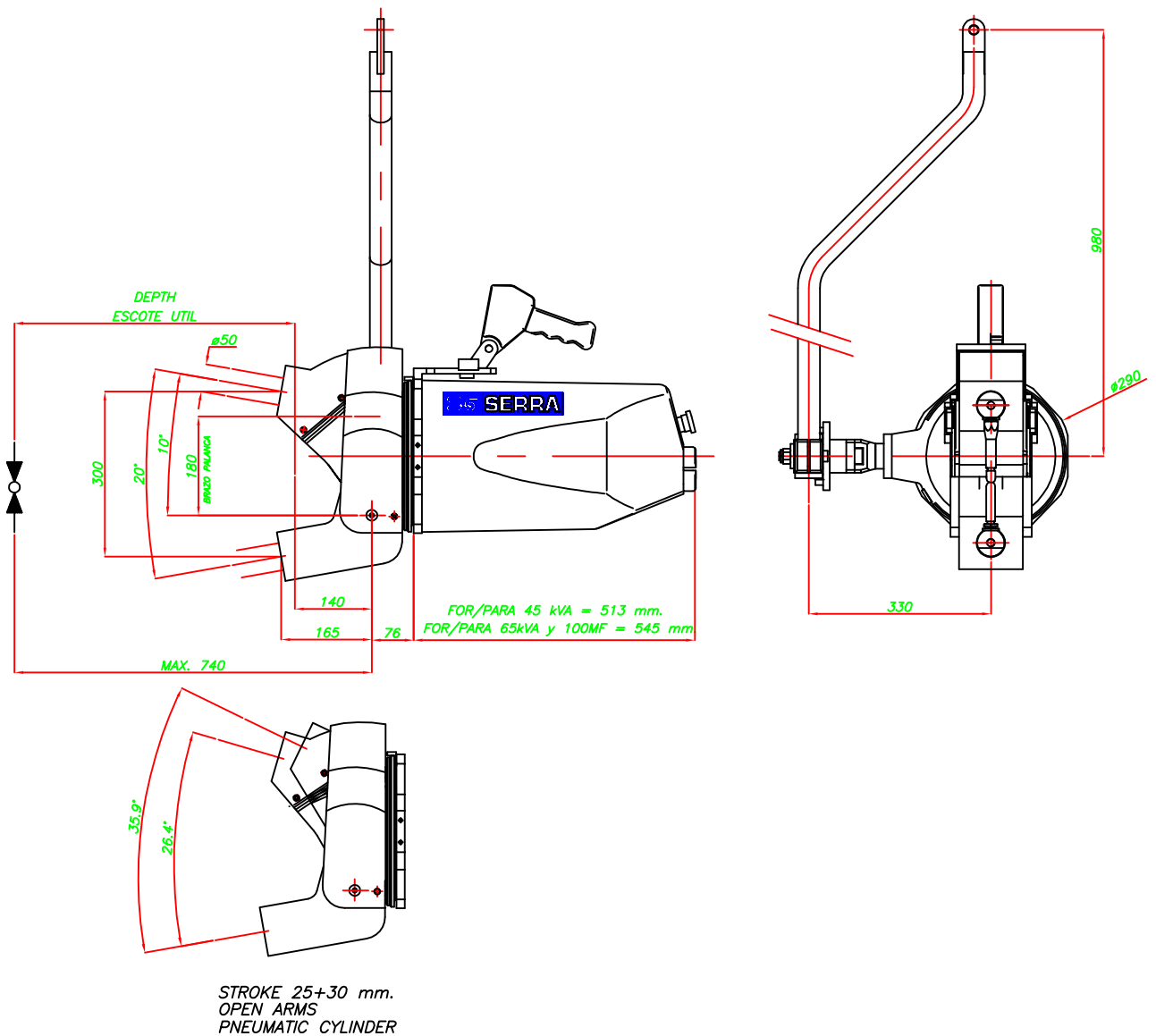
## ***XP TYPE***



**QUALITY  
MANAGEMENT**  
Certificate

Welding equipment manufacturer  
according to ISO 9001





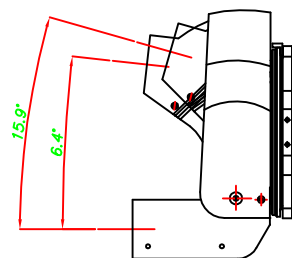
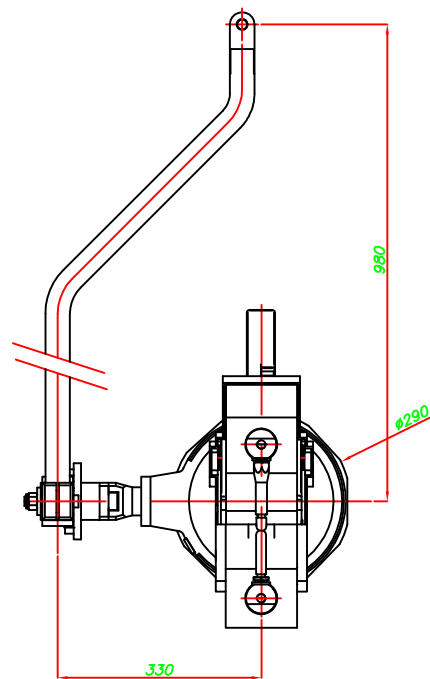
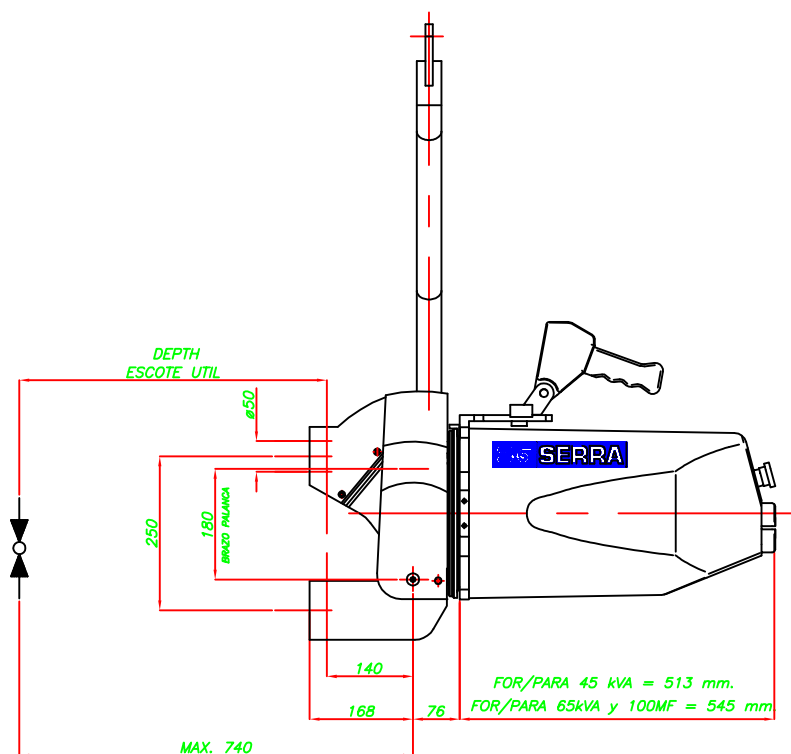
| TECHNICAL DATA |        |           |
|----------------|--------|-----------|
| TRAFO          | KVA/V. | 45/7.1    |
|                | KVA/V. | 65/8.5    |
|                | KVA/V. | 100/10 MF |

| MAX. FORCE AT ELECTRODES |                    |
|--------------------------|--------------------|
| UNIT FORCE               | PNEUMATIC CYLINDER |
| ARM LENGTH               | AT 8 bar           |
| 200 mm.                  | ----               |
| 300 mm.                  | 695 daN.           |
| 400 mm.                  | 566 daN.           |
| 500 mm.                  | 478 daN.           |
| 600 mm.                  | 413 daN.           |

| WEIGHT OF THE GUN BODY WITHOUT ARMS |             |        |        |        |
|-------------------------------------|-------------|--------|--------|--------|
| DISTANCE BETWEEN ARMS               | TRAFO       | 45 Kva | 65 Kva | 100 MF |
|                                     | UNIT KGS    |        |        |        |
| 250mm.                              | P. CYLINDER | 88     | 92     | 84     |
|                                     |             |        |        |        |

| PNEUMATIC CILINDER |      |            |
|--------------------|------|------------|
| WELDING CILINDER   | mm.  | Ø 100 (x3) |
| STROKE             | mm.  | 25+30      |
| AIR PRESSURE       | bar  | MAXI.8     |
| MAX. FORCE         | daN. | 1800       |

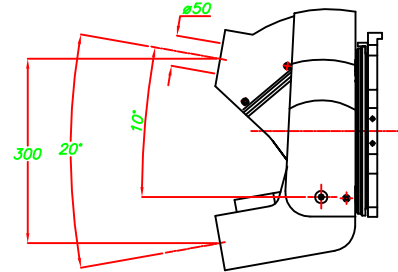
|                       |       |     |
|-----------------------|-------|-----|
| COOLING WATER FLOW    | l/mn. | 10  |
| DISTANCE BETWEEN ARMS | mm.   | 250 |



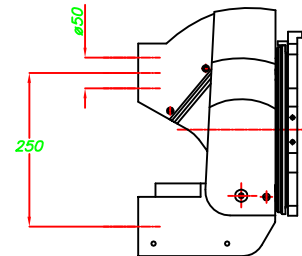
STROKE 25+30 mm.  
OPEN ARMS  
PNEUMATIC CYLINDER

| BODY<br>REFERENCE | F. max.<br>A = 500mm. | WELD<br>ANGLE | PRE-STROKE<br>ANGLE |
|-------------------|-----------------------|---------------|---------------------|
| PTB2X-ACEBBA      | 640 daN.              | 6.4°          | 9.6°                |
| PTB2X-ADFBBA      |                       |               |                     |
| PTB2X-ACFBBA      |                       |               |                     |
| PTB2X-ADEBBA      |                       |               |                     |

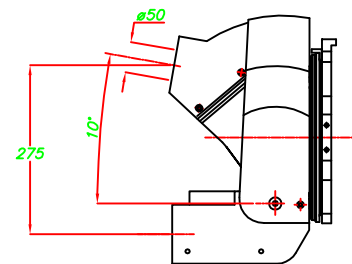
PTB2X-ACEBBA



PTB2X-ADFBBA

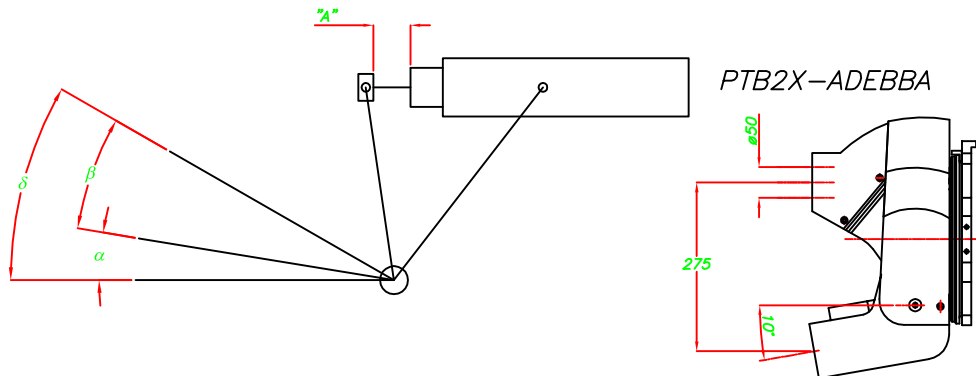


PTB2X-ACFBBA

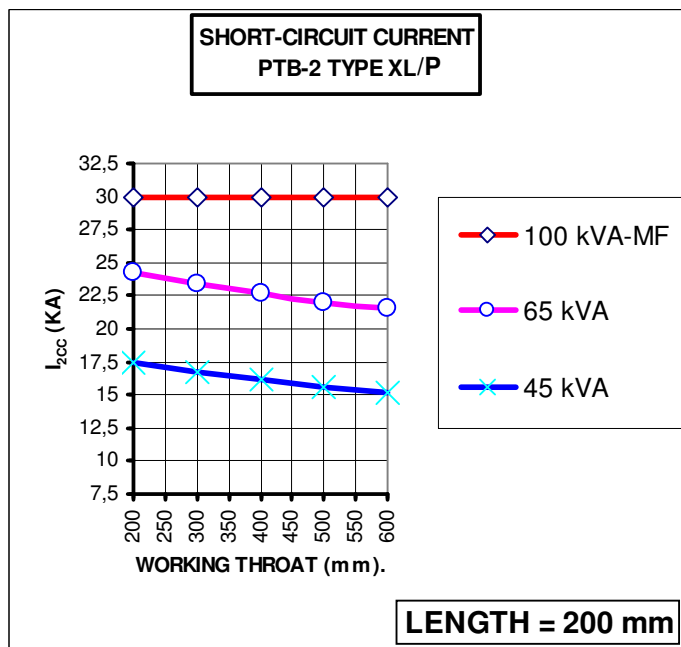


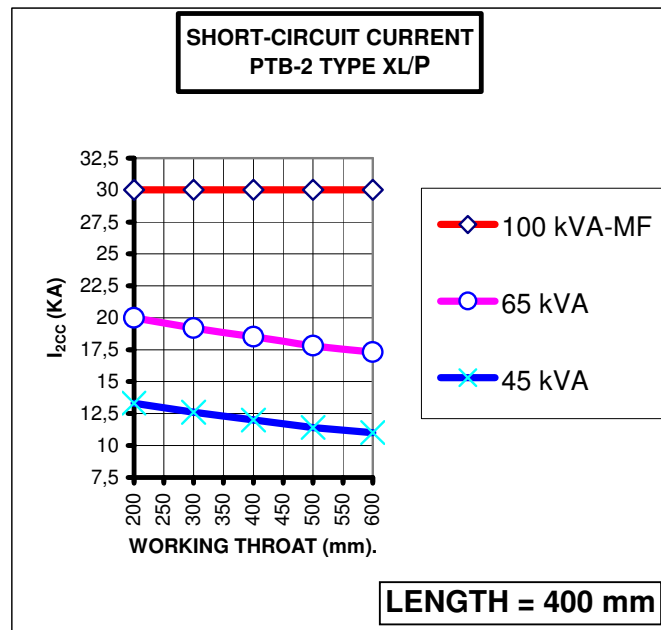
| DIM "A" | WELD<br>ANGLE<br>$\alpha$ | PRE-STROKE<br>ANGLE<br>$\beta$ | TOTAL<br>ANGLE<br>$\delta$ |
|---------|---------------------------|--------------------------------|----------------------------|
| 19.5    | 6.447°                    | 9.601°                         | 16.048°                    |
| 20.5    | 6.128°                    | 9.601°                         | 15.729°                    |
| 21.5    | 5.809°                    | 9.601°                         | 15.410°                    |
| 22.5    | 5.490°                    | 9.601°                         | 15.091°                    |
| 23.5    | 5.171°                    | 9.601°                         | 14.772°                    |
| 24.5    | 4.852°                    | 9.601°                         | 14.453°                    |
| 26.5    | 4.533°                    | 9.601°                         | 14.134°                    |
| 27.5    | 4.214°                    | 9.601°                         | 13.815°                    |
| 28.5    | 3.895°                    | 9.601°                         | 13.496°                    |
| 29.5    | 3.576°                    | 9.601°                         | 13.177°                    |
| 30.5    | 3.257°                    | 9.601°                         | 12.858°                    |
| 31.5    | 2.938°                    | 9.601°                         | 12.539°                    |
| 32.5    | 2.619°                    | 9.601°                         | 12.220°                    |
| 33.5    | 2.300°                    | 9.601°                         | 11.901°                    |
| 34.5    | 1.981°                    | 9.601°                         | 11.582°                    |
| 35.5    | 1.662°                    | 9.601°                         | 11.263°                    |
| 36.5    | 1.343°                    | 9.601°                         | 10.944°                    |
| 37.5    | 1.024°                    | 9.601°                         | 10.625°                    |
| 38.5    | 0.705°                    | 9.601°                         | 10.306°                    |
| 39.5    | 0.386°                    | 9.601°                         | 9.987°                     |

PTB2X-ADEBBA



|                   | MODEL                                 | Units  | PTB2-XP   |
|-------------------|---------------------------------------|--------|-----------|
| General data      | Arm diameter                          | mm     | 50        |
|                   | Gun body maximum resistance           | daN    | 900       |
|                   | Distance between arms mín. / máx. "Z" | mm     | 200 / 400 |
|                   | Maximum arm length                    | mm     | 740       |
|                   | Gun weight (min-max) without arms     | Kg.    | 84 – 92   |
| Pneumatic version | Cylinder diameter                     | mm     | 3x100     |
|                   | Cylinder pre-stroke                   | mm     | 30        |
|                   | Gun rotation angle in pre-stroke      | Grados | 9,6       |
|                   | Cylinder stroke                       | mm     | 25        |
|                   | Total gun stroke rotation angle       | Grados | 16        |
|                   | Maximum air pressure                  | bar    | 8         |
|                   | Cylinder force at 8                   | daN    | 1700      |
| Cooling           | Maximum water inlet temperature       | °C     | 30        |
|                   | Minimum water inlet temperature       | °C     | 10        |
|                   | Minimum water differential pressure   | bar    | 1.5       |
|                   | Cooling flow                          | L/min  | 9         |





## Manual weldgun Type XP Force at electrodes with cylinder Ø3x100

| Length<br>mm | Pressure (bar) |     |     |     |     |     |     |
|--------------|----------------|-----|-----|-----|-----|-----|-----|
|              | 2              | 3   | 4   | 5   | 6   | 7   | 8   |
| 200          | 225            | 338 | 450 | 563 | 675 | 788 | 900 |
| 300          | 174            | 261 | 348 | 435 | 522 | 609 | 696 |
| 400          | 142            | 213 | 283 | 354 | 425 | 496 | 567 |
| 500          | 120            | 179 | 239 | 299 | 359 | 418 | 478 |
| 600          | 103            | 155 | 207 | 259 | 310 | 362 | 414 |