

Linear Action Pneumatic Spot Welders • 35-50 kVA

4665 • 4666 • 4667 • 4668

The new stationary ergonomic frame designed by TECNA helps to facilitate the operator's work

The pneumatic commands and the compressed air pressure gauge have been placed at the top for easier reading and adjustment



Key Features

- Chrome-copper electrode holders for long life and heavy duty service, designed for straight and angled fitting
- Water cooled epoxy resin coated transformer
- Water cooled arms, electrodes and electrode holders
- Microprocessor control unit TECNA TE101
- USB port for data storage (only with TE550)
- The air operated lubrication free cylinder eliminates oil mist
- Protected filter assembly with gauge
- Two stage electric foot control for clamping the welding pieces in the correct position prior to welding
- Pre-connected for additional electric foot pedal for the direct recalling of welding program No.2. This function is helpful when different kinds of welding are to be performed on the same piece
- Arms: gap 280mm, adjustable depth 320mm (Option 4638)
- Adjustable electrodes stroke for max. working rate



Order Code		4665	4666	4667	4668
Nominal power @ 50%	kVA	35	50	35	50
Maximum welding power	kVA	67	84	64	84
Short circuit current	kA	15.5	17	14.5	17
Thermal current 100%	A	4500	5700	4500	5700
No load secondary voltage	V	5.4 (4)	6.1	5.4 (4)	6.1
Supply voltage 50Hz *	V	400	400	400	400
Cables section L=30m	mm ²	16	35	16	35
Delayed fuses	A	63	100	63	100
Insulation class		F	F	F	F
Min. throat depth	mm	400	400	500	500
Max. electrode force (@ 6 bar)	daN	470	470	300	300
Electrode stroke	mm	5 - 80	5 - 80	5 - 80	5 - 80
Gap min. (option 4638)	mm	-	-	170	170
Gap max. (option 4638)	daN	-	-	500	500
Max. short circuit current with max. gap (option 4638)	mm	-	-	10	12.1
Arms diameter	mm	50	50	50	50
Electrode holders diameter	mm	25	25	25	25
Standard electrodes cone diameter	mm	14.8	14.8	14.8	14.8
Compressed air supply	bar	6.5	6.5	6.5	6.5
Air for 1000 spots (6 bar)	Nm ³	5.4 - 1.7	5.4 - 1.7	5.4 - 1.7	5.4 - 1.7
Water cooling	l/min	4	4	4	4
Aerial noise produced	dB(A)	<70	<70	<70	<70
Measure conditions					
Working stroke	mm	20	20	20	20
Welding time	cycles	17	23	20	24
Welding current	kA	11.6	12.7	10.9	12.4
Working rating in welds/min		15	15	15	15
Net weight (approximately)	Kg	220	225	220	225

* Different voltages & frequencies on request