

PEDAL OPERATED – ROCKER ARM SPOT

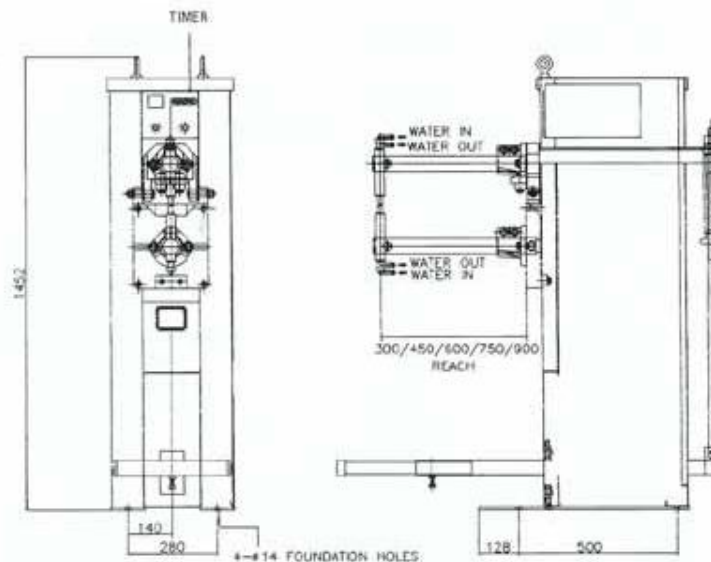


Two robust heavy-duty spot welders featuring:

- **A choice of transformer and arm reach.**
- **A 'T' slotted face plate giving both vertical and horizontal adjustment of the lower arm.**
- **Optional reversible upper and lower electrode arms, one drilled to accept vertical electrodes with the other end a 22½° inclined electrode.**
- **Optional water cooled lower arms and adapters for cross wire and 'T' wire welding.**
- **Adjustable weld time ranges 1 cycle to 100 cycles.**
- **Current range infinitely adjustable from 30% to 100% phase shift control.**
- **Weld/No Weld switch, Weld indicators as standard for safety.**

Total reliability is provided by British Federal Monopak type WP1 electronic welding control using 'state of the art' technology providing all electronic fully synchronous welding control and solid-state thyristor switching.

Pedal Operated Rocker Arm Spot Welder Type 117/125



All measurements shown in mm unless otherwise indicated

Technical Specifications		Type 117	Type 125	
Transformer - Air cooled	Continuous rating 100% duty cycle	kVA	12	18
	Maximum power	kVA	45	70
	Number of taps		1	1
	Secondary volts	V	4.0	5.0
	Short circuit current at 450mm reach	Amp	11,000	14,000
	Maximum primary current	A	110	170
	Rating at 50% duty cycle	kVA	17	25
Electronic controls	Timer	Monopak WP1 Synchronous timer 1 - 100 cycles in 2 ranges Thyristor contactor 30% to 100% phase shift control		
Arm details	Reach	mm	300, 450, 600, 750 or 900	300, 450, 600, 750 or 900
	Diameter top and bottom	ins(mm)	2" (51)	2" (51)
	Electrode holders	ins(mm)	1 1/4" (32)	1 1/4" (32)
	Electrodes (masonry 328)	ins(mm)	3/4" B.S. 807 taper (19)	3/4" B.S. 807 taper (19)
	Water cooled arms are available as an optional extra Pressure adjustable using a spring up to 1.3 kN (300lbs)			
Shipping specifications	Nett weight	kg	225	
	Gross weight	kg	325	
	Case size	mm	1190 x 480 x 1750	
Services required	Electrics (via customer's switch fuse)		2 phase 380/440 V 50Hz	2 phase 380/440 V 50Hz
	Water		5/10 litres per minute	5/10 litres per minute
	Suggested PVC multikore cable and fuse size (BS 88)		10mm ² /32A HRC	16mm ² /50A HRC

Welding Capacity Guide

Material Thickness		Mild Steel			Galvanised			Mild Steel Wire			
mm	swg	press lbs	current amps	time cycles	press lbs	current amps	time cycles	diameter mm	press lbs	current amps	time cycles
0.5	26	140	5,000	5	300	3,000	6	2.5	125	1,800	9
1.0	20	280	7,000	8	550	11,000	12	4.5	360	3,300	14
1.6	16	550	10,000	16				6.0	600	4,500	20