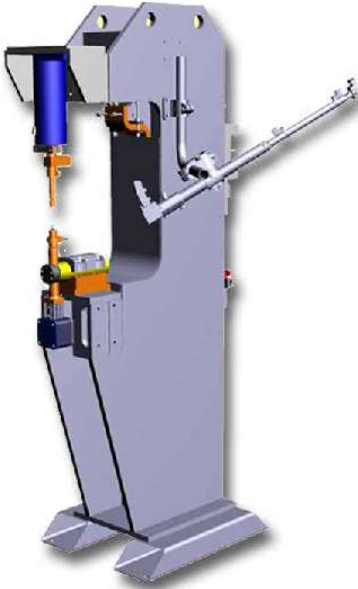


**SERRA**



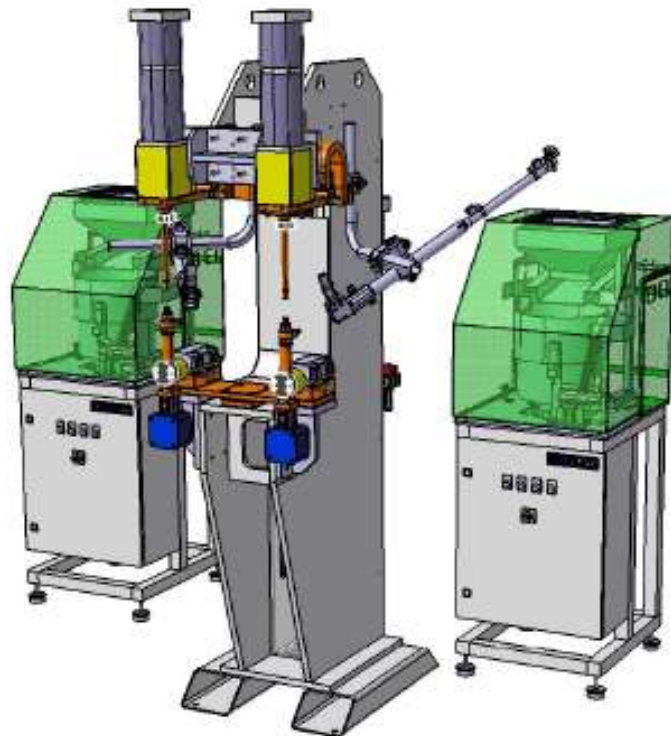
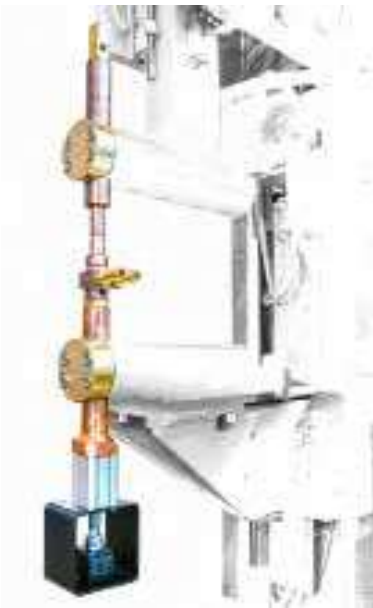
- Pneumatic circuit with single pressure system
- I/O water valves 1/2".
- Air Inlet valve 1/2".
- Field Buses : DeviceNet / ProfiNet.

#### FEATURES

- Current: AC/MF
- Power: from 100 to 200 kVA.
- Option: one or two anti-rotation cylinders for projection nut welding.
- Option: one or two guided welding heads with high performance effort tracking for anular projection welding.
- Optional: intelligent pin up system.

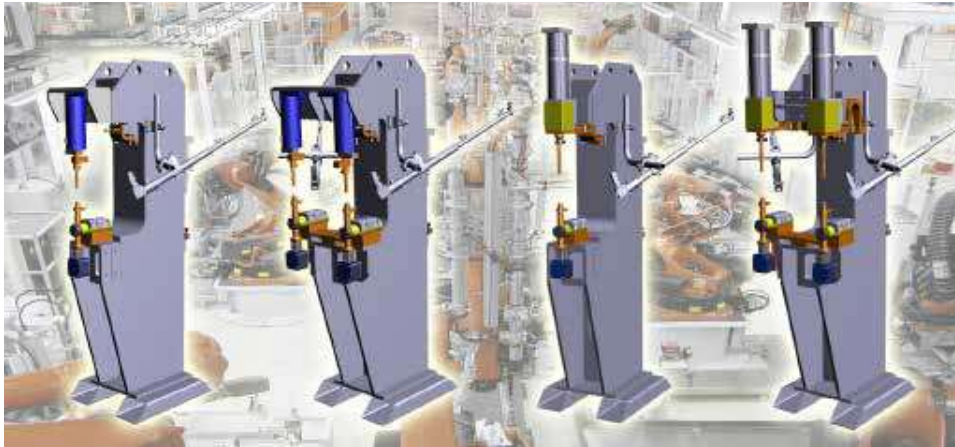
#### OPTIONALS

- Intelligent pin up system for nuts and/or bolts.
- Socket floor 200 and 300 mm
- Electric cabinet AS-6, AS-4, AS-2MFC
- Separated RIP Panel with proportional valve and flowmeter - UNR 220 for AC / UNR 230 for MF



# ALPHA IN LINE

## NUT AND BOLT WELDING FOR IN-LINE APPLICATIONS



TECHNICAL SPECIFICATIONS		L2123	L2133	L2143	L2153	L2127	L2137
Welding Frequency	Hz	50	50	50	50	1000	1000
Main Voltage	V	400	400	40	400	400 - 700	400 - 700
Power at 50% D.C	kVA	125	125	125	125	100	170
DIN throat depth	mm	400	400	400	400	400	400
Cylinder force at 6 bar	daN	-	-	900	2 x 900	-	-
Guiding welding head force at 6 bar	daN	900	2 x 900	-	-	900	2 x 900
Max. short circuit (5 periods)	kA	35	35	35	35	45	45
Max. welding current (5 periods)	kA	28	28	28	28	40	40
Air consumption 50mm / 6 bar	NI	5.35	10.70	5.35	10.70	5.35	10.70
Cooling water consumption	l/h	600	720	600	720	900	900
Admissible power	kVA	250	250	250	250	160	250
Delayed fuses	A	250	250	250	250	160	250
Main supply section by phase (for 15m)	mm <sup>2</sup>	120	120	120	120	70	120
Secondary voltage	V	11	11	11	11	10	10
Diameter electrode upper / lower (cone 10%)	mm	20 / 19	20 / 19	20 / 19	20 / 19	20 / 19	20 / 19
Diameter arms / electrode holders	mm	70 / 35	70 / 35	70 / 35	70 / 35	70 / 35	70 / 35
Stroke Cylinder / Welding head	mm	100	100	100	100	100	100
Manoeuvres / minute (in 10 mm)	mm	90	90	90	90	90	90
Width	mm	580	580	580	580	580	580
Length	mm	900	900	900	900	900	900
Height	mm	2200	2200	2000	2000	2200	2200
Weight	kg	780	810	775	800	725	765
Power Thyristors	BTS	900	900	900	900	-	-
Medium Frequency Inverter	MFC	-	-	-	-	3007	3015
Electric cabinet (optional)	-	AS - 4	AS - 4	AS - 4	AS - 4	AS - 6MFC	AS - 2MFC
URN panel (optional)	-	URN-220	URN-220	URN-220	URN-220	URN-230	URN-230