

MICROWELDING

MS-07 ◦ MS-16 ◦ MS-25 ◦ MS-50

Spot welding of small parts.



High accuracy and output in resistance welding.



MICROWELDING

SPOT WELDING OF SMALL PARTS.



MS-07

Provided with a small size welding head engineered for welding small and thin parts that require high mechanical accuracy. Powered by a 7 kVA transformer at 50% DC. The welding force is micrometrically adjustable.



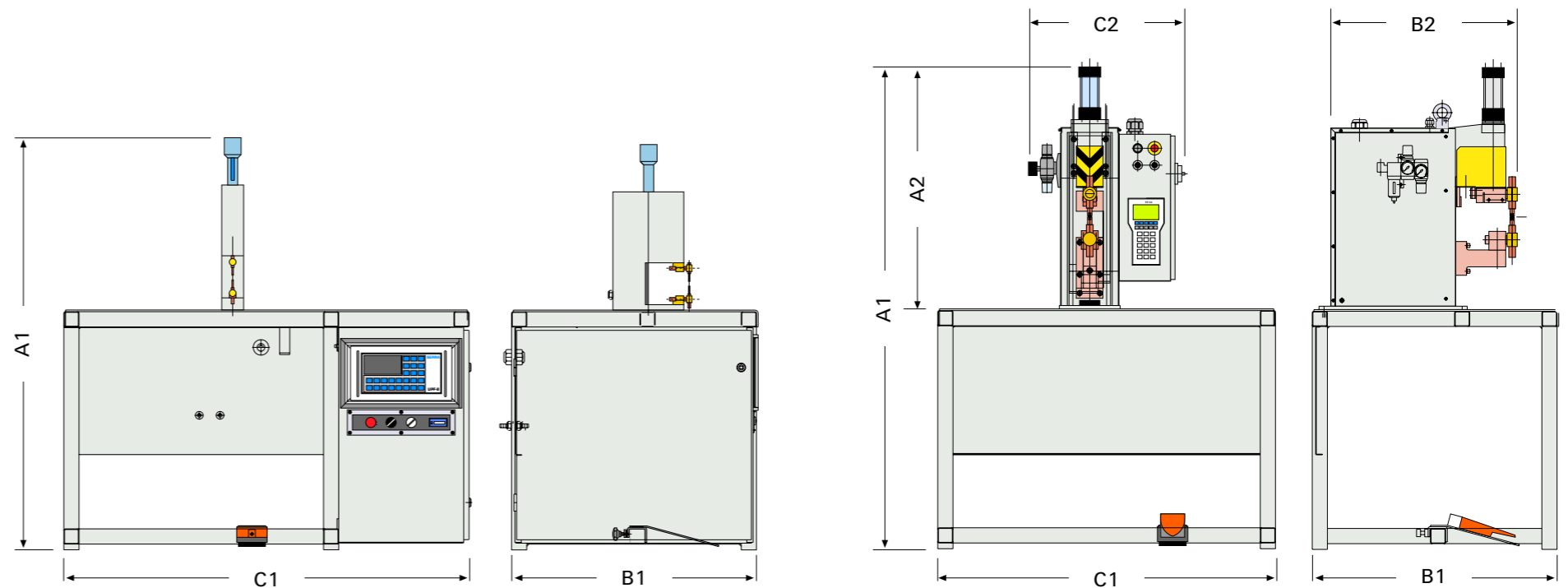
MS-16 and MS-25

Both models share the same structure design and dimensions, but the transformer power is 16 kVA for the MS-16 and 25 kVA for the MS-25. High accuracy in thin and medium thickness, the MS-16 and MS-25 can be applied both for mass-production and for precision procedures in small parts. Double pressure cycle: start (contact of electrodes) and weld. Both are adjustable independently.



MS-50

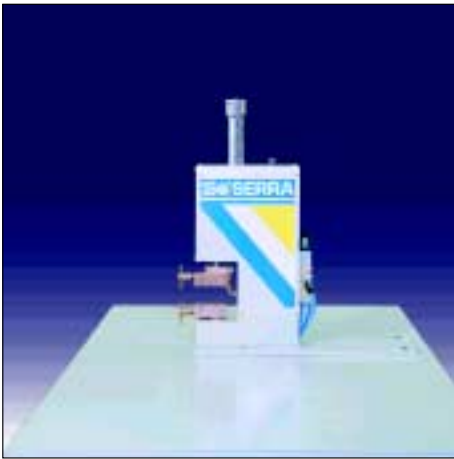
Powered by a 50 kVA transformer, this powerful model is designed to provide heavy duty cycles by means of powerful welding intensities and large forces. The MS-50 can be applied in welding processes of copper and high mechanical resistance alloys, with considerable thickness and sections. The pressure cycle is double.



TECHNICAL DATA

		MS-07	MS-16	MS-25	MS-50
Power at 50% DC	kVA	7	16	25	50
Cylinder force at 6 bar	daN	9 (*)	120	120	450
Maximum welding power in Short Circuit	kA	7,3	9,6	19	22,7
DIN Throat depth	mm	46	110	110	200
Cylinder working stroke	mm	-	50	50	100
Working stroke	mm	20	45	45	100
Distance between arms (max. min.)	mm	73 / 53	240 / 160	240 / 160	300 / 150
Lower arm diameter	mm	10	20	20	60
Electrode diameter	mm	5	12,5	12,5	19
Power supply at 50 Hz	V	400	400	400	400
Secondary voltage in vacuum	V	2,5	3,7	5	6,3
Air consumption per 50mm stroke / 6bar	NI	-	0,31	0,31	1,25
Cooling water consumption	l/h	240	280	280	400
Isolator	A	63	63	63	100
Double pressure squeeze / welding time	-	-	•	•	•
Power supply cable max. 15 m. (400V)	mm²	6	6	16	25
Timer	SERRATRON	1A	1A	1A	1A
Programming device	-	UPF-8a	TP-10	TP-10	TP-10
DIMENSIONS AND WEIGHT					
Height A (A1 with table / A2 without table)	mm	1220 / -	1427 / 717	1427 / 717	1750 / 1640
Length B (B1 with table / B2 without table)	mm	725 / -	725 / 585	725 / 585	785 / 775
Width C (C1 with table / C2 without table)	mm	1200 / -	1000 / 465	1000 / 465	1000 / 530
Weight (with / without table)	kg	117 / -	185 / 122	185 / 122	250 / 187
OPTIONALS					
Delivery without table	-	-	•	•	•
Other voltages different to 400 V / 50 Hz	-	•	•	•	•

(*) max. cylinder force through spring device



MS-07



MS-16 • MS-25



MS-50

Please use the following references when ordering.

Type	Product	Code
MS-07	MICROWELDING 7 kVA	71010
MS-16	MICROWELDING 16 kVA (WITH TABLE)	71020
MS-16	MICROWELDING 16 kVA (WITHOUT TABLE)	71021
MS-25	MICROWELDING 25 kVA (WITH TABLE)	71030
MS-25	MICROWELDING 25 kVA (WITHOUT TABLE)	71031
MS-50	MICROWELDING 50 kVA (WITH TABLE)	71040
MS-50	MICROWELDING 50 kVA (WITHOUT TABLE)	71041

Serratron 1A Electronic Weld Timer



State of the art weld control with unique user interface: a complete programming and monitoring facility created for quick, intuitive learning.

- Up to 16 weld programs.
- Constant current control.
- Weld current programmable in kA.
- 12 digital inputs and 7 digital outputs
- 1 current measuring input and 1 firing output..
- RS-485 interface CPC-BUS, for centralised programming.
- Control modes: constant current, current monitoring, firing angle.
- Electrode wear compensation through 10 interpolation curves.
- Serial interface V24 for lap top or programming unit. (RS-232)
- Log of the latest 16 welds.
- Log of the latest 64 error messages.
- Parameter storage without the need for battery back up.

Programming devices.

TP-10

The ergonomic design assures easy handling when handheld, or when mounted onto the machine. The device may be used for programming, as well as for displaying weld parameters, counters, measured weld currents, error messages, etc. The TP-10 is able to store a log of messages, which can be read by a PLC equipped with a serial port or by a PLC program of a Serratron 10p/c.



UPF-8a

The possibilities for programming, monitoring and storing data, are identical to those of the TP-10, but the UPF-8A is designed to be machine mounted. Easy mounting due to integrated bolts. The UPF-8A is directly connected to the weld timer through a serial port RS-232-C/V24.



Specifications and descriptions in this leaflet are subject to change without notice.



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