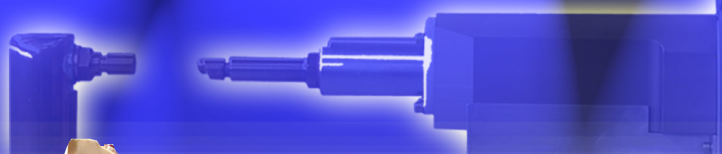
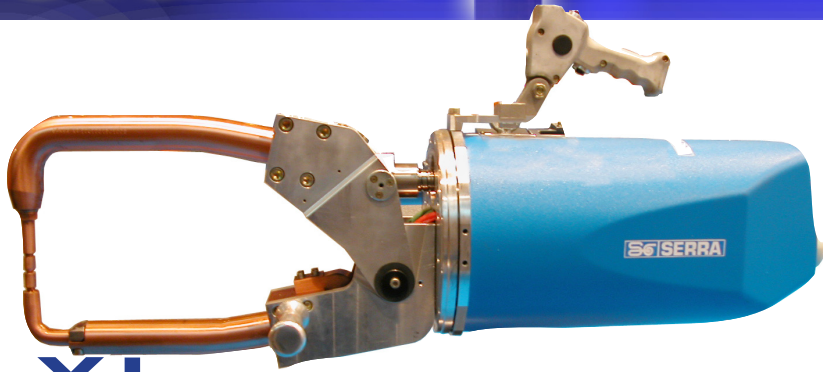


SIGMA

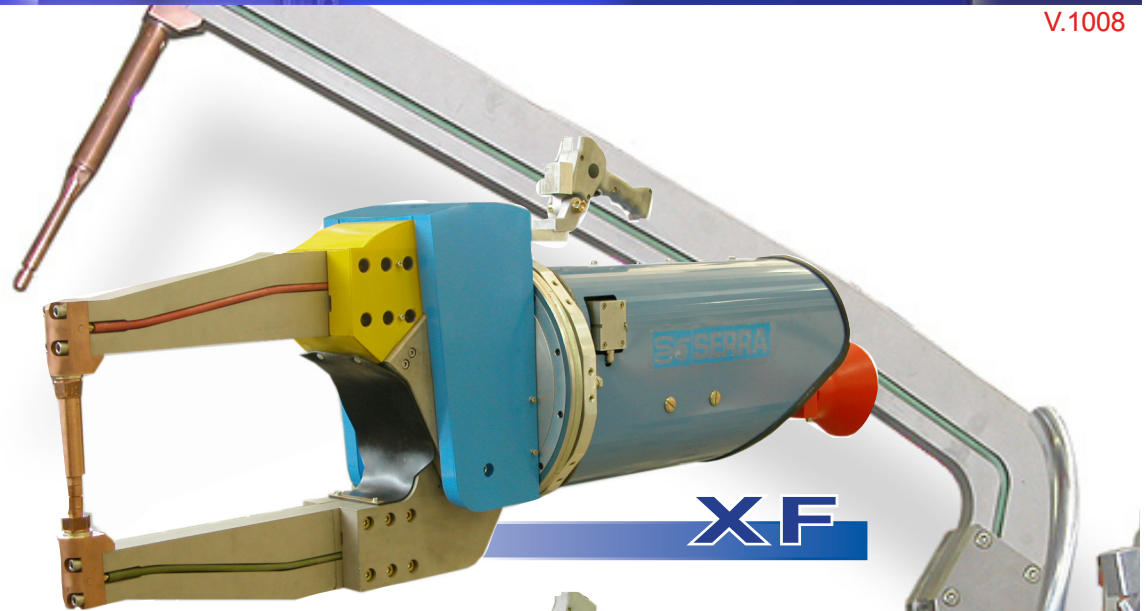


SERRA
Weld power at your fingertips

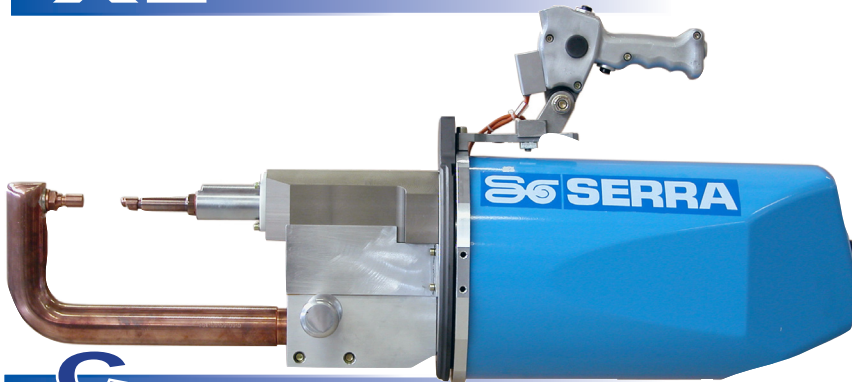
V.1008



XL



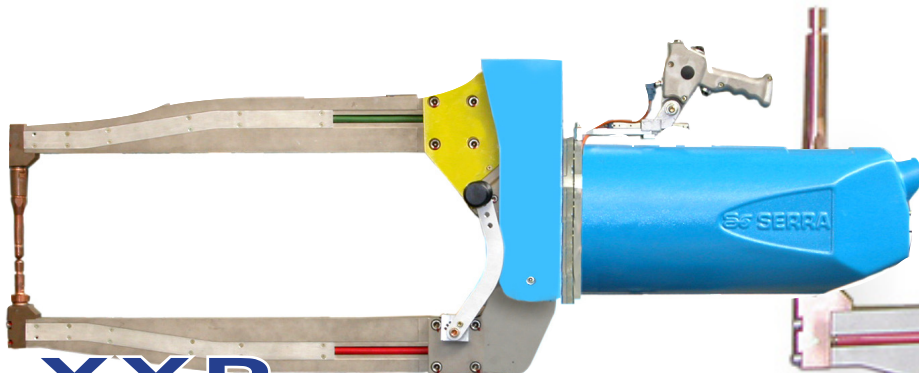
XF



C



CF



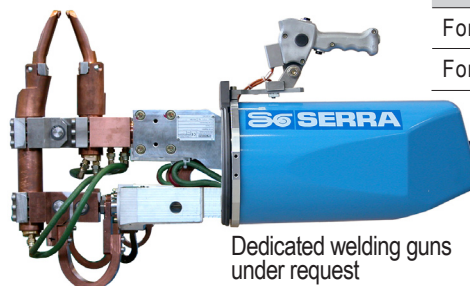
XXP

SERRA

Serie SIGMA - Welding guns with integrated transformer

Equipment included :

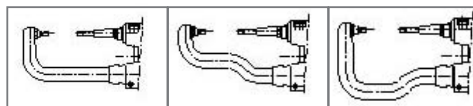
- Pneumatic cylinder
- Energy set of 7m
- Gun balancer
- Energy set balancer



Dedicated welding guns under request

Control cabinets	AC 50 Hz	MF 1000 Hz
For 1 welding gun	AS-51-1B	AS-51-MFC
For 2 welding gun	AS-52-1B	AS-52-MFC

Possible arm configurations :



Pneumatic and chilling sets	URN-250	URN-255
Application	AC	MF
Flowmeter	-	●
Water flow cutting valve	-	●
Water filter	●	●
Air filter	●	●
Controlled air output by manometer	-	●
Controlled air output by proportional valve	-	●

Ref.	XL			XP		XXP		XXPGA	XF		C				CF	
	XL-45	XL-65	XL-60MF	XP-65	XP-60MF	XXP-65	XXP-100MF	XXPGA-100MF	XF-100MF	XF-170MF	C-45	C-65	C-60MF	C-100MF	CF-100MF	CF-170MF
Welding frequency	50		1000	50	1000	50	1000	1000	1000		50		1000		1000	
Transformer power at 50% D.C.	45	65	60	65	60	65	100	100	100	170	45	65	60	100	100	170
Arms diameter	50			50		Rectangular. 40x100		Rec.40x100	Rectangular. 50x120		45				Rectangular. 50x120	
Distance between arms	200 to 300			250 to 300		300		400	250 to 300		-				-	
Maximum arm length admissible	600			600		1000		1240	1000		320				650	
Weight (arms 400 mm)	104	108	100	109	101	111	103	126	190	200	88	92	84	86	177	190
Current in Short Circuit (arms 400 mm)	17	20	21	20	21	20	22	22	22	30	17	20	21	21	22	30
Cylinder force	1800			1800		2250		2800	3500		628				1300	
Electrode force (arms 400 mm)	409			566		750		926	1166		628				1300	
Cylinder diameter	3x100			3x100		4x100		5x100	5x125		100				2x125	
Cylinder approach stroke	30			30		30		98	30		100				100	
Cylinder working stroke	25			25		25		30	25		46				40	
Gun rotation angle in approach stroke	15°			9,5°		9,5°		24°	8,6°		-				-	
Total gun rotation angle in working stroke	8°			8°		6,4°		7°	5,8°		-				-	
Maximum air pressure	8			8		8		8	6		8				6	
Minimum differential pressure in gun	1,5			1,5		1,5		1,5	1,5		1,5				1,5	
Chilling flow in parallel circuit	9			9		9		9	10		9				10	
Inlet water temperature (max./min)	10 / 30			10 / 30		10 / 30		10 / 30	10 / 30		10 / 30				10 / 30	



Polígono Industrial Zona Franca Sector C, Calle D, nº 29
E-08040 BARCELONA
Tel. +34 93.26.17.100 Fax +34 93.26.17.110

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