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CEA

RESTECH

made in Italy
SINCE 1950





PPN

SPOT AND PROJECTION WELDERS

VERTICAL STROKE

Being suitable for both spot and projection welding jobs, PPN models fully satisfy an extremely large variety of the heaviest mass production industrial applications.

Equipped with a microprocessor control and safety concomitant side buttons, upon request they can also be supplied fitted with special controls and in different configurations.

PPN 63

EQUIPPED WITH:

- Lower round arm with adjustable height and lateral adjustment
- Electrodeholders with electrodes for spotwelding and ability to easily fit barholders for projection welding
- Lower arm holder can be adjusted for use with larger arm gap
- Spotwelding (A)
- Projection welding with bars for mesh (B)



PPN 83, 103, 153 and 253

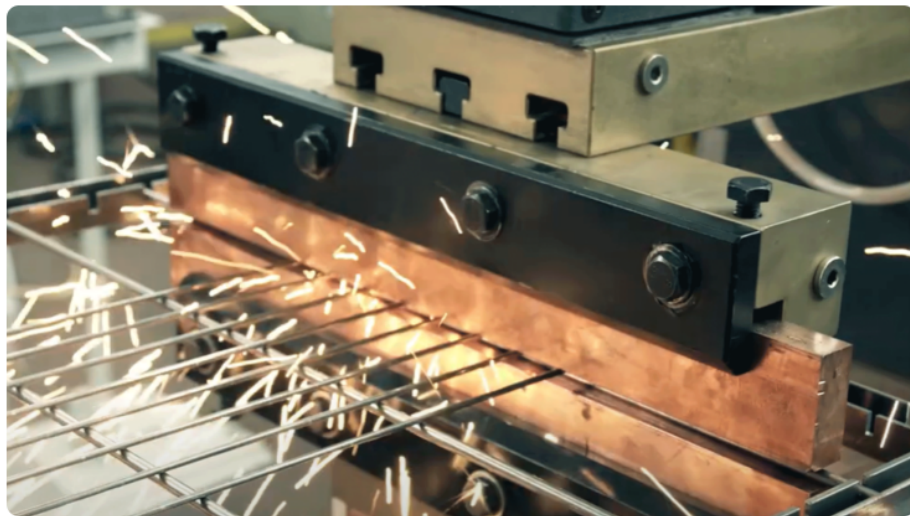
All supplied with lower platen adjustable in height and fitted with T-slots, enable the quick assembly of barholders, of electrodeholders or any dedicated tooling for a specific application. Platens gap is easily and quickly adjustable without any intervention on the secondary circuit (patent pending).

- Manual valve for upper head descent without pressure for cleaning, centering and ordinary maintenance of the electrodes.
- Upper head linear bearing driving system for precision welding (except PPN 83)

Welding advantages

- Excellent welding on all weldable metals
- Synchronous ignition SCR group with phase shift welding current adjustment to eliminate initial transient
- Thermostatic protection on the SCR group
- High welding currents with low consumption
- Set up time reduction thanks to quick and easy modification of electrodeholders platens opening without any intervention on the secondary circuit (patent pending)





Other characteristics

- Self-lubricated pneumatic components to eliminate oil deposits and to safeguard the environment from contaminants
- Water cooled secondary circuit, i.e. electrodes, electrodeholders, platens and transformer, to avoid overheating
- Water cooled copper electrodeholders with adjustable height
- Electrode force adjustable by pressure reducer group equipped with a manometer and filter for automatic air impurity expulsion

- Upper electrode movement by self lubricated double effect pneumatic cylinder fitted with speed regulator, end stroke shock-absorber and silencer for compressed air discharge
- Solenoid valve to control welding cylinder
- Safety cycle start by means of concomitant side buttons or, alternatively only if the operator can work in safe conditions, by electric pedal. Either option can be chosen by a selector with removable key
- Cycle stop emergency button



TECHNICAL FEATURES



FILIUS MULTI

- Pre-squeeze; Squeeze time
- Preheating time; Preheating current
- Cooling time; Slope up
- Welding time; Welding current; ½ period welding time
- Welding time 2 / Welding current 2 (2 pedal version)
- Pulse interval time; Pulse number
- Post heating time and current
- Holding time; Pause time
- Auto-repeat; 32 Programs
- Welding current display; Limit monitoring
- Mains voltage compensation
- Error message
- Spot counter; Pressure contact; Cycle end contact

WS 750 ADV

WS 750 ADV is a microprocessor welding control for resistance welding machines with 100 programs/JOBs developed for spot, projection and butt-welding applications. The combination of 3 displays, 6 keys and LEDs allow a user friendly parameterization and configuration.

The LEDs have the function of showing the status of the welding cycle and to set the correct parameters of the welding JOB.

An USB port enables the backup of the welding JOBS, firmware updates and the saving of the welding logbook in Excel format.

The WS 750 ADV allows to measure the welding current which enables the quality control of the cycle by selecting the min./max. current, and to adjust the welding force by using a proportional valve.



Available accessories

DISCOVER ALL AVAILABLE ACCESSORIES



**PPS 60/PPN 63: SET OF
PIPE TIPS 115MM**

271258



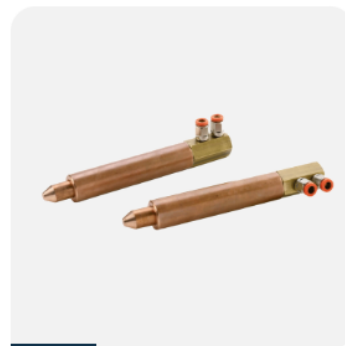
**PPN 83/MF 1040/1041:
SET BARHOLDERS 200MM**

264530



**PPN 83/MF 1040/1041:
SET BARHOLDERS 400MM**

264540



**PPS 60/BSW 100: SET
ELECTRODEHOLDERS**

268110



**PPS 35: SET
ELECTRODEHOLDERS**

268100



SET ELECTRODEHOLDERS

268120



**PPN 83/BSW 100: SET OF
ELECTRODEHOLDER
SUPPORTS**

280885



**PPN 103/153/253: SET OF
ELECTRODEHOLDER
SUPPORTS**

280874



**PPN 83/BSW 100: SET
BARHOLDERS 400MM**

264578



**PPN 83/BSW 100: SET
BARHOLDERS 600MM**

264588



**PPN 83/103: SET
BARHOLDERS 400MM**

264575

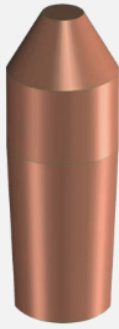


**PPN 83/103: SET
BARHOLDERS 600MM**

264585



**SET OF STANDARD
ELECTRODES-6PCS**
380007



**SET OF STANDARD
ELECTRODES-6PCS**
380008

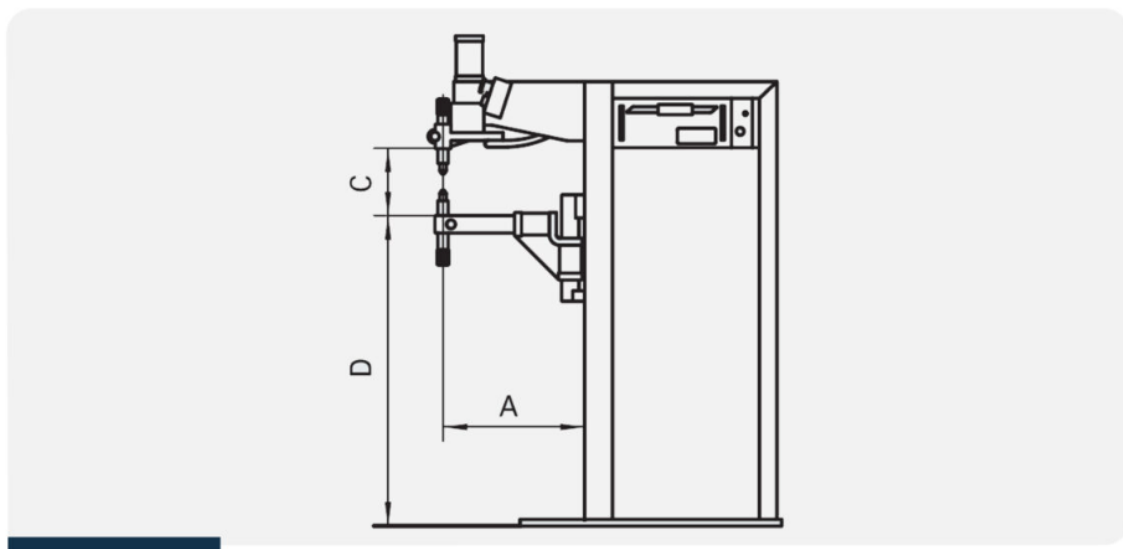


2 STEP PEDAL
SPV10

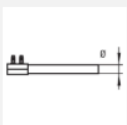
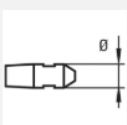
Datasheet

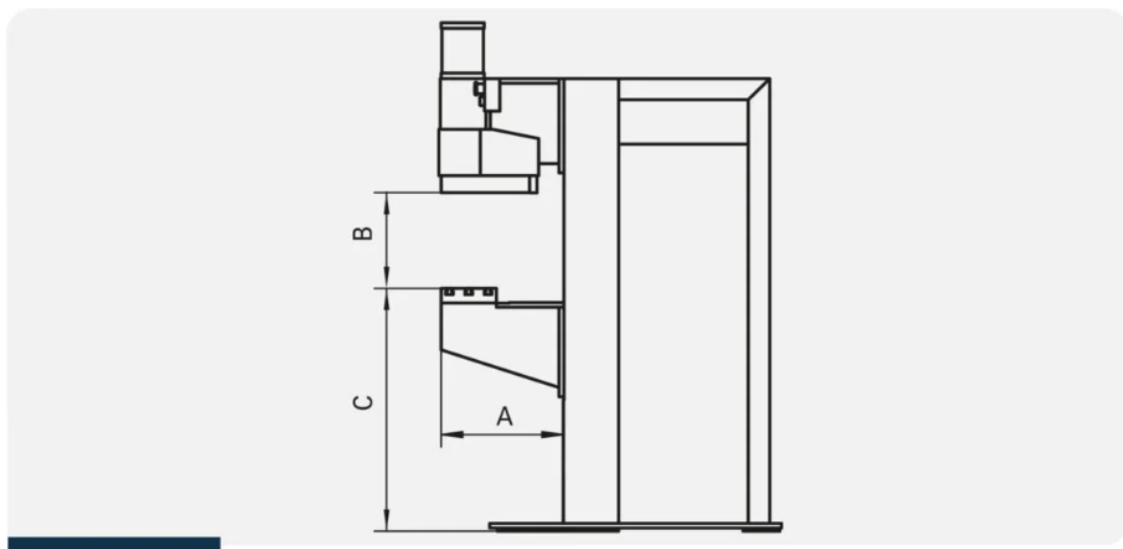
PPN: TECHNICAL FEATURES

TECHNICAL DATA		PPN 63	PPN 83	PPN 103	PPN 153	PPN 253
Single phase input 50/60 Hz	V	400	400	400	400	400
Rated power at 50%	kVA	50	80	100	150	250
Max. welding power	kVA	113	210	293	460	610
Installed power	kVA	38	65	78	120	195
Fuse(delayed action)	A	100	150	200	300	500
Secondary voltage	V	5,9	8,3	9,4	11,5	12,5
Secondary short circuit current	kA	24	32	39	50	61
Max welding current	kA	19	25	31,2	40	49
Work stroke	mm	65	100	100	100	100
Electrode force at 600kPa (6bar)	daN	470	736	900	1200	1884
Water consumption at 300 kPa (3bar)	l/min	7	8	8	8	8
Dimensions (LxWxH)	mm	1070 x 430 x 1520	1115 x 400 x 1650	1115 x 400 x 1650	1170 x 400 x 1800	1210 x 460 x 1800
Weight	kg	335	560	580	610	900



PPN63 STANDARD VERSION DIMENSIONS

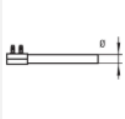
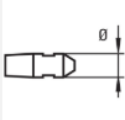
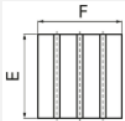
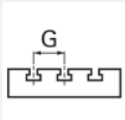
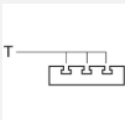
		PPN 63
A	mm	435
A (Optional) – MIN.	mm	650
A (Optional) – MAX.	mm	750
C – MIN.	mm	180
C – MAX.	mm	510
D – MIN.	mm	615
D – MAX.	mm	945
	Ø mm	60
	Ø mm	35
	Ø mm	19



PPN 83 -103 – 153 – 253 STANDARD VERSION DIMENSIONS

		PPN 83	PPN 103	PPN 153	PPN 253
A	mm	400	400	400	445
A (Optional) – MIN.	mm	650	650	650	650
B	mm	445	445	445	490
C – MIN.	mm	145	145	145	200
C – MAX.	mm	300	300	300	330
D – MIN.	mm	800	800	800	865
D – MAX.	mm	955	955	955	995

PPN 83 -103 – 153 – 253 STANDARD VERSION DIMENSIONS

		PPN 83	PPN 103	PPN 153	PPN 253
	Ø mm	30	30	30	35
	Ø mm	19	19	19	25
	E mm	150	180	180	200
	F mm	150	180	180	200
	G mm	63	63	63	63
	T	2	3	3	3



WELDING TOGETHER

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