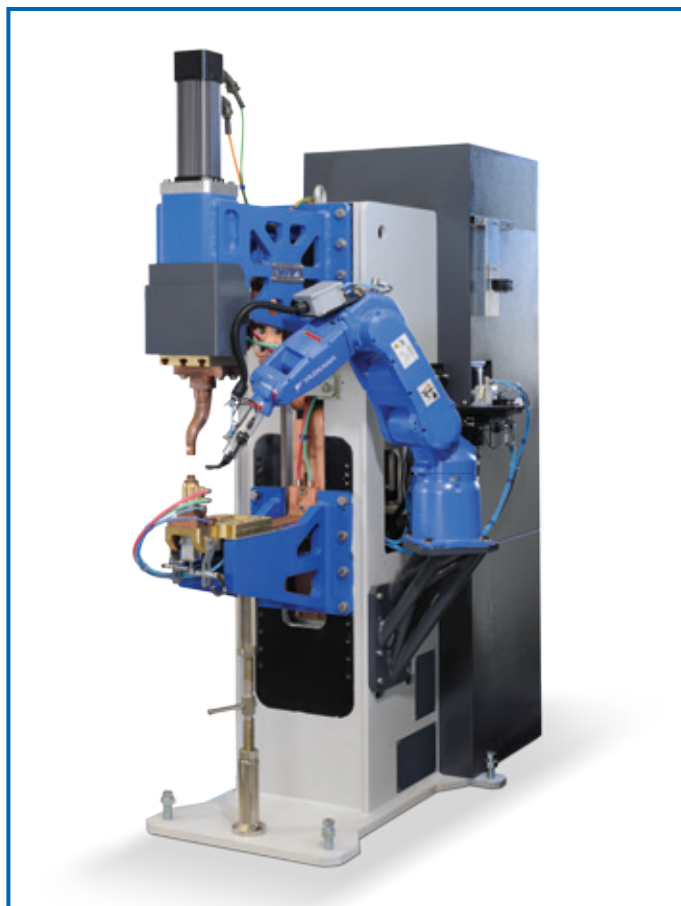


NUT WELDING MACHINE

The Nut Welding Machine is the new machine designed and manufactured by Yaskawa for completing the welding process.

It consists of a welded structure, adjustable in different positions and with higher head.

On the right or left side of the machine, depending on your needs, you can mount the handling robot MH5 with support attached to the structure and a unit for servicing the item to be welded (nut/bushing/pin).



SPECIFICATIONS

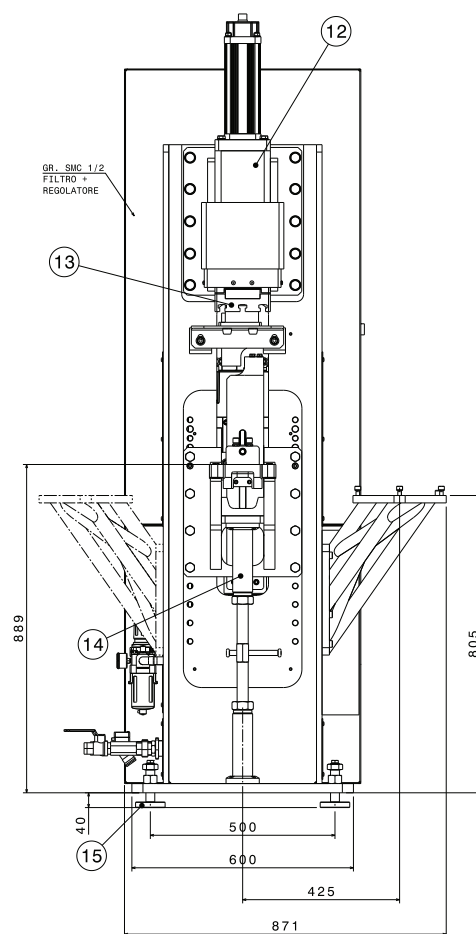
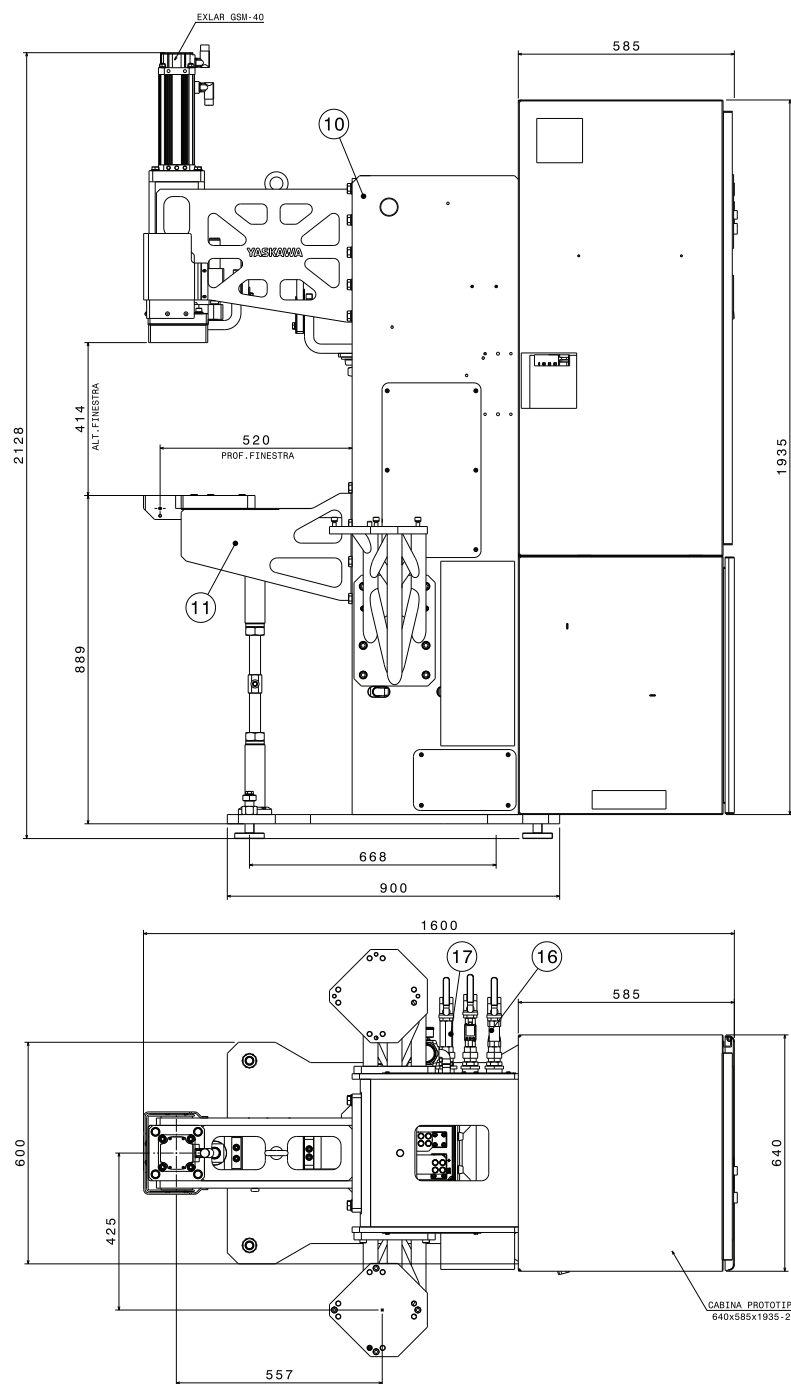
Between the workbench and the top head is mounted a tool dedicated to item welding. To the back of the structure is installed a cabinet containing a vibrator that allows you to select the item to be welded, to control the handling robots and the timer of the transformer. The items to be welded are loaded into the vibrator and conveyed, by vibration, near the service unit. When the item is brought in position, it can be picked up by the handling robot that places it on the tool on which the sheet metal item is already present. The servo-motor brings the moving part of the tool into contact with the item that is in contact with the sheet metal item. Through pressure and current flow, the indents of the item (nut/bushing/pin) are melted with the sheet metal item.

BENEFITS

The advantages of the Nut Welding Machine for the user are:

- Autonomy, thanks to the integration of its elements.
- Greater performance and reliability.
- Immediate maintenance.
- Quick set-up when changing the item.

NUT WELDING MACHINE



Machine type	SF YASKAWA	Min opening between the boards	400 mm
Supply voltage	400 V - 50 Hz	Top board size (3 grooves)	150 x 150 mm
Secondary voltage	9,3 V with no load	Bottom board size (customized)	150 x 150 mm
Short circuit current intensity	39 kA	Water pressure	0,3 - 0,6 Mpa
Auxiliary supply voltage	220V-AC / 24V-CC	Water consumption	13 l/min
Conventional power at 50%	85 kW	Air consumption (m³ for 100 points at 0,4Mpa)	1,4 m³
Force on electrodes min.	250 daN	Welding control	CS-I 700A
Force on electrodes max.	1000 daN	SCR Unit	SAFCO
SF axis usable depth	500 mm	Weight	950 kg
Mobile electrode stroke	130 mm	Height	2128 mm
Lower shelf adjustment stroke	200 mm	Minimum-maximum width	640-870 mm
Max opening between the boards	600 mm	Depth	1600 mm