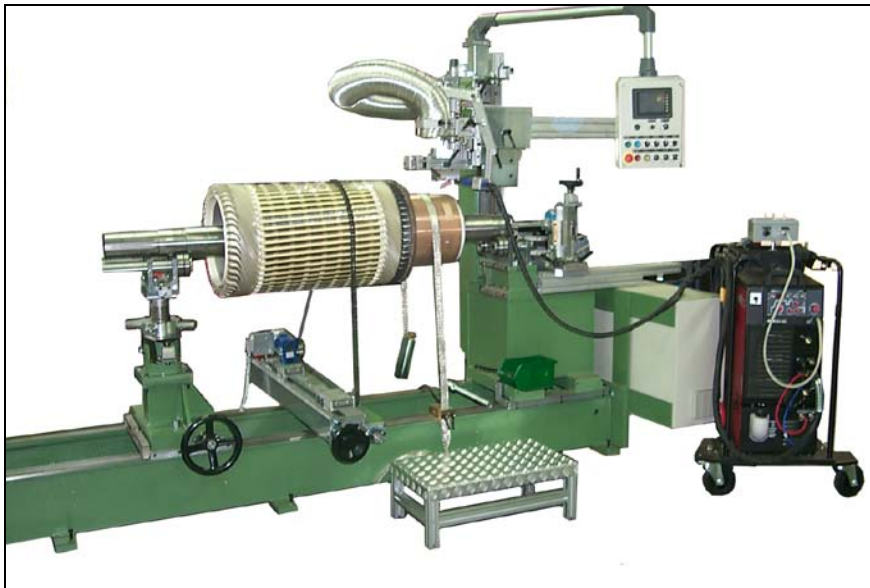
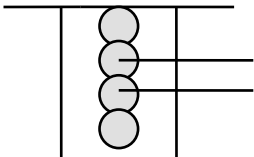


Automatic TIG welding machine for commutators



	W -TIG-50	W -TIG-100	W-TIG-130
Armature core diameter	80 - 600	100 - 1000	100 - 1300 mm
Riser commutator diameter	70 - 500	100 - 900	100 - 1300 mm
Height of commutator riser	0 - 150	0 - 200	0 - 200 mm
Max shaft length	1750	2200	2500 mm
Max armature weight	2500 Kg	4000 Kg	5000 Kg
Number of bars	0 - 999	0 - 999	0 - 999 bars

Torch welding movement:



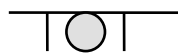
X

a- Manual: after each welding turn, the torch can be manually replaced in the new weld position.

b- Automatic: after each welding turn, the torch moves automatically on a new weld circumference until the riser is completely welded. Movement "x" is adjustable stepless from 0 up to 10mm.

Bar indexing: by step motor with adjustable speed; an electronic divider-unit takes care of commutator rotation with bar index in function of welding program and cycle.

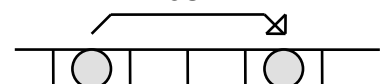
Welding cycles: SPOT



LONG -SPOT
0 - 100 %



BAR JUMP



Welding equipment: CEA- Matrix 400-HF of 400 Amps with water cooled torch

Two different level of current can be set:

- 1) High for copper melting
- 2) Low for arc ignition and during bar index

Gas: Helium , Argon, mix Helium-Argon
Aspirator for welding smokes