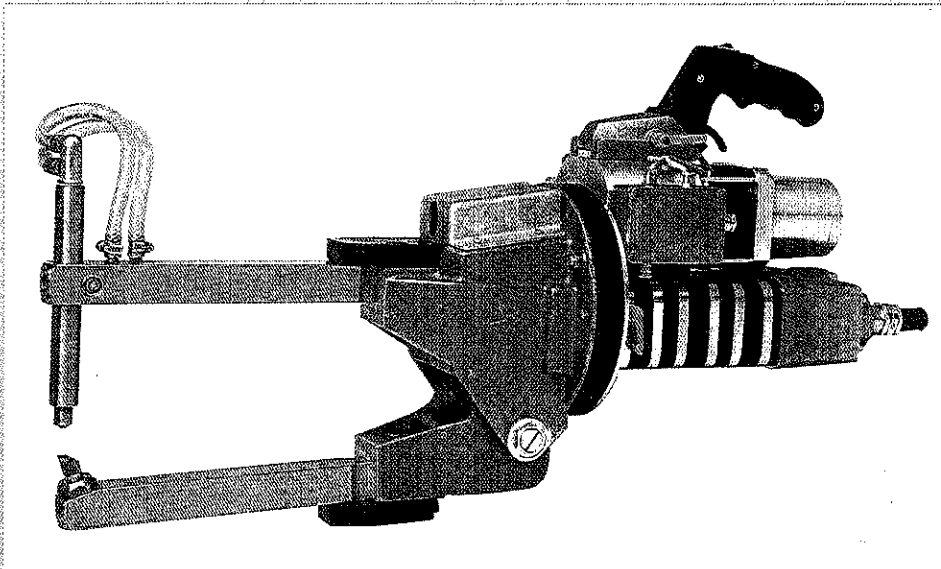


# Spot welding guns with integrated transformer

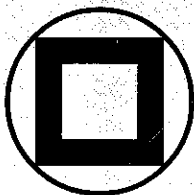
## Heavy duty spot welding guns for industrial use



- Complete water cooling
- Double acting pneumatic cylinder
- Vacuum - molded transformer in resin epoxy



TYPE		3327	3328	3329
Nominal input at 50% duty cycle	KVA	22	28	28
Electrode force (short arms, pressure: 6 bar)	daN	280	280	440
Secondary short circuit current (short arms)	KA	14	16,5	16,5



**ELECTRODES ARMS**  
Using rectangular profiles result in advantages as follows:

- Rigidity is substantially increased.
- Clamping safety without

Arm length (mm)	Upper straight	Lower straight	Upper inclined	Lower inclined
170	D 34/25/170 g	D 34/2/170 g	D 34/25/170 s	D 34/2/170 s
350	D 34/25/350 g	D 34/2/350 g	D 34/25/350 s	D 34/2/350 s
500	D 34/25/500 g	D 34/2/500 g	D 34/25/500 s	D 34/2/500 s
650	D 34/25/650 g	D 34/2/650 g	D 34/25/650 s	D 34/2/650 s

<b>WELDING CAPACITY</b>		<b>3327</b>		<b>3328</b>		<b>3329</b>	
<b>Capacity on mild steel 1)</b>	Throat depth	Sheets	Round bars	Sheets	Round bars	Sheets	Round bars
	170 mm	3 + 3	12 + 12	3,5 + 3,5	14 + 14	4 + 4	16 + 16
	500 mm	2 + 2	8 + 8	2,5 + 2,5	10 + 10	3 + 3	10 + 10
	800 mm	1,25 + 1,25	6 + 6	1,5 + 1,5	8 + 8	2 + 2	8 + 8
<b>Admissible production rate 1)</b>	Sheets	Spots per hour					
	Ø of spot: 4,5 mm	1 + 1 mm	6200	6200	6200	6200	6200
	6 mm	2 + 2 mm	1550	1840	1840	1840	1840
	8 mm	3 + 3 mm	550	650	650	650	650
<b>Electrode force (daN)</b>	Throat depth	170 mm	500 mm	170 mm	500 mm	170 mm	500 mm
	Air at 6 bar	280	125	280	125	440	180
<b>Electrodes arms</b>		24 x 34 mm					
Diameter mm		140 mm (version E: 230 mm)					
Arm gap		170 - 800 mm					
Throat depth (std./maxi)							
<b>Electrodes</b>	Throat depth	170 mm	350 mm	500 mm	650 mm	800 mm	
	Working stroke	0 - 20 mm	0 - 40 mm	0 - 55 mm	0 - 70 mm	0 - 85 mm	
	Retraction stroke	40 - 60 mm	70 - 110 mm	95 - 150 mm	120 - 190 mm	145 - 230 mm	
	Electrode taper Ø electrode holder	10% Ø 15,5 mm, ISO 16 25 mm					
<b>TECHNICAL DATA</b>		<b>3327</b>		<b>3328</b>		<b>3329</b>	
<b>Secondary open circuit voltage</b>		3,8 V		4,7 V		4,7 V	
<b>Secondary current</b>	Throat depth	170 mm	500 mm	170 mm	500 mm	170 mm	500 mm
	short circuit	14 KA	9,5 KA	16,5 KA	11,5 KA	16,5 KA	11,5 KA
Max. welding input		46,5 KVA		63 KVA			
Connection input		18 - 35 KVA		25 - 47 KVA			
Nom. input at 50% duty cycle		22 KVA		28 KVA			
<b>Electrical connection</b>		230 V	400 V	230 V	400 V	230 V	400 V
	Cross section for cable ≤ 15 m and 5% voltage drop	10 mm <sup>2</sup>	4 mm <sup>2</sup>	16 mm <sup>2</sup>	6 mm <sup>2</sup>	16 mm <sup>2</sup>	6 mm <sup>2</sup>
	Fuse (delayed action)	80 A	50 A	125 A	80 A	125 A	80 A
<b>Cooling water consumption</b>		360 l/hour					
<b>Operating pressure max.</b>		5 bar.					
<b>Air consumption at 6 bar</b> (for 1000 spots at 10 mm stroke)		0,7 m <sup>3</sup>				0,9 m <sup>3</sup>	
<b>Weight (with standard electrode arms)</b>		42 kg		46 kg		47 kg	

Subject to alterations without prior notice. Technical data given are based on short electrode arms.

Additional equipment: - Synchronous welding controls: please refer to individual leaflet  
- Spring balancers: please refer to individual leaflet  
- Filter - regulator - lubricator (fri) units

1) On mild steel with clean surface; carbon contents less than 0,2%



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