

TECNA



DIRECT

INDUSTRIAL RESISTANCE WELDERS AND TOOL BALANCERS

6073 - 6075 SERIES

56kVA MFDC Spot and Projection Welders

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Advanced Resistance Welding Systems and Balancers



Stocking Master Distributor
of TECNA Resistance Welders
and Tool Balancers

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WSI

WELD
SYSTEMS
INTEGRATORS, INC.

Spot and Projection Welders: 56 kVA

TECNA 6073 – 6075 Series MFDC Press-Type Spot Welders from TECNADirect.com are designed to meet every need of spot welding. The frame of this line of machines has been designed by TECNA so to facilitate the operator's work. The control unit, the pneumatic commands and the pressure gauge have been placed at the top so to enable the operator to use them smoothly.

The inverter technology, which these machines are provided with, allows a higher welding quality, an extreme precision in time and current and a reduction in costs, installation ones included. The welding time is adjusted in milliseconds thus allowing the best set-up. The welding current is supplied continuously and constantly and is not affected by the dimensions of the welding circuit.



WELDER FEATURES

- Medium frequency welders, designed to obtain high quality welding.
- Modular design of mechanical structure, arms, brackets, cylinders.
- Cylinder with chrome plated stem for heavy duty works and long life; adjustable anti-rotation device.
- Lubrication free pneumatic components to eliminate oil mist and to protect the environment.
- Adjustable double-stroke cylinder with key control.
- Built-in compressed air filter unit. Compressed air disconnection device.
- Water-cooled transformer, plates, electrode-holders and electrodes; transformer with epoxy resin coated windings.
- Two stage electric foot control for clamping and welding pieces only if correctly positioned.
- Pre-setting for additional double stage electric foot switch connection for the direct recalling of a different welding program.
- Arranged for all models: two-hand safety control with timer and removable key selector, assuring the best safety. The two-hand control device is standard on projection models only (it is available upon request on spot welder models).
- Emergency push-button to stop the machine immediately.

The most advanced resistance welding machines

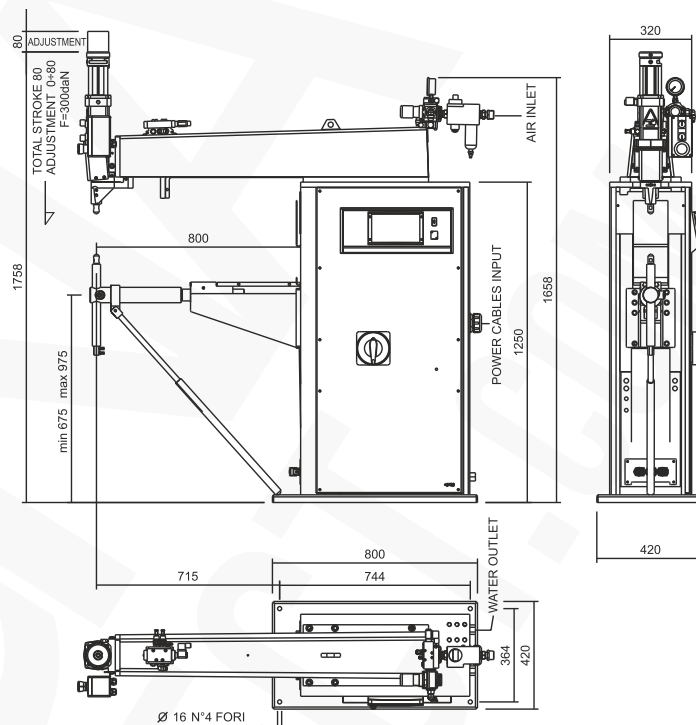
SPECIFICATION		UNITS	WTP-6073	WTP-6073A	WTP-6074
Spot Welder			Spot	Spot	Spot
Projection Welder			–	–	–
Standard Control			TE751	TE700	TE751
Power @ 50% Duty Cycle	kVA		56	56	56
Max Power	kVA		200	200	200
No-Load Secondary Voltage	V		8.4	8.4	8.4
Short Circuit Current	A		25,000	25,000	25,000
Thermal Current @ 100%	kA		4.9	4.9	4.9
Supply Voltage (3-Phase @60Hz)*	V		440	440	440
Delayed Fuses @ 440VAC	A		50	50	50
Primary Cables Ø (up to 30m)	mm ²		25	25	25
Compressed Air Supply	psi (bar)		94.3-145 (6.5-10)	94.3-145 (6.5-10)	94.3-145 (6.5-10)
Air Consumption per 1000 Spots @ 94.3 PSI (650kP / 6.5 bar)	SCF (N/m ³)		307-92 (8.7-2.6)	307-92 (8.7-2.6)	191-60 (5.4-1.7)
Throat Depth – To Electrode Holders	in (mm)		15.7 (400)	15.7 (400)	31.5 (800)
Throat Depth – To Tooling Platens	in (mm)		–	–	–
Max Electrode Force @ 94 psi (6.5 bar)	lbs. (daN)		1034 (470)	1034 (470)	660 (300)
Working Stroke	in (mm)		0.2-3.2 (5-80)	0.2-3.2 (5-80)	0.2-3.2 (5-80)
Adjustable Retraction Stroke (Standard)	in (mm)		0.0-3.2 (0-80)	0.0-3.2 (0-80)	0.0-3.2 (0-80)
Water Cooling @ 36 psi (250 kP / 2.5 bar)	gpm (lpm)		1.6 (6)	1.6 (6)	1.6 (6)
Min/Max Water Pressure	psi (bar)		36-58 (2.5-4)	36-58 (2.5-4)	36-58 (2.5-4)
Aerial Noise Produced	dB(A)		<71	<71	<71
Measured Conditions					
Working Stroke	in (mm)		0.8 (20)	0.8 (20)	0.8 (20)
Welding Time	ms		160	160	160
Welding Current	kA		18.8	18.8	18.8
Working Rating (Welds per Minute)	#/min		15	15	15
Ø Arms	in (mm)		2.4 (60)	2.4 (60)	2.4 (60)
Ø Electrode Holders	in (mm)		1.26 (32)	1.26 (32)	1.26 (32)
Electrode Taper Size			5RW/2MT	5RW/2MT	5RW/2MT
Tooling Platen T-Slot Spacing					
T-Slot Spacing	in (mm)		–	–	–
Bolt Size	in (mm)		–	–	–
Net Weight	lbs (kg)		616 (280)	616 (280)	715 (325)
Dimensions L x W x H	in		44.1 x 16.5 x 72.8	44.1 x 16.5 x 72.8	59.8 x 16.5 x 73.4
	mm		(1120 x 420 x 1848)	(1120 x 420 x 1848)	(1520 x 420 x 1838)

*May be supplied capable of operating on other voltages/frequencies. Please ask for details.

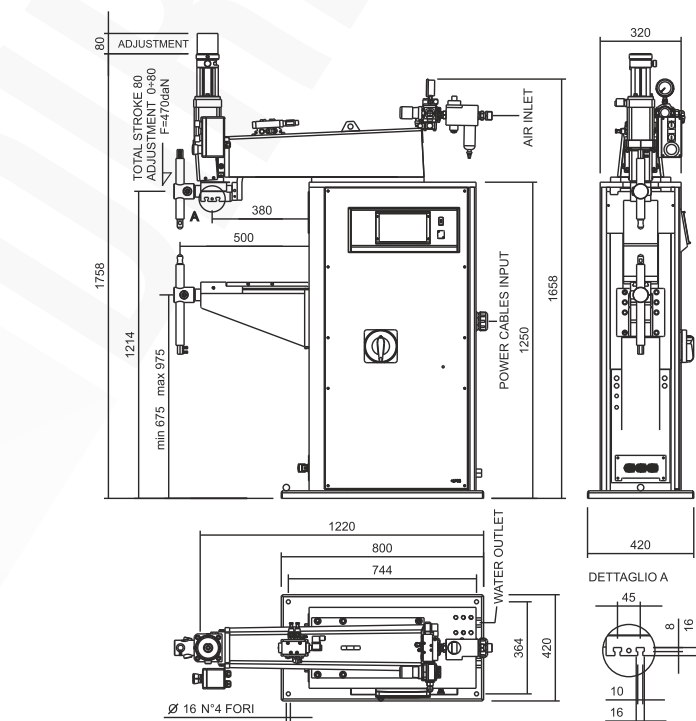
SPECIFICATION		UNITS	WTP-6074A	WTP-6075	WTP-6075A
Spot Welder			Spot	Spot	Spot
Projection Welder			–	Projection	Projection
Standard Control			TE700	TE751	TE700
Power @ 50% Duty Cycle	kVA		56	56	56
Max Power	kVA		200	200	200
No-Load Secondary Voltage	V		8.4	8.4	8.4
Short Circuit Current	A		25,000	25,000	25,000
Thermal Current @ 100%	kA		4.9	4.9	4.9
Supply Voltage (3-Phase @60Hz)*	V		440	440	440
Delayed Fuses @ 440VAC	A		50	50	50
Primary Cables Ø (up to 30m)	mm ²		25	25	25
Compressed Air Supply	psi (bar)		94.3-145 (6.5-10)	94.3-145 (6.5-10)	94.3-145 (6.5-10)
Air Consumption per 1000 Spots @ 94.3 PSI (650kP / 6.5 bar)	SCF (N/m ³)		191-60 (5.4-1.7)	307-92 (8.7-2.6)	307-92 (8.7-2.6)
Throat Depth – To Electrode Holders	in (mm)		31.5 (800)	15.7 (400)	15.7 (400)
Throat Depth – To Tooling Platens	in (mm)		–	11 (280)	11 (280)
Max Electrode Force @ 94 psi (6.5 bar)	lbs. (daN)		660 (300)	1034 (470)	1034 (470)
Working Stroke	in (mm)		0.2-3.2 (5-80)	0.2-3.2 (5-80)	0.2-3.2 (5-80)
Adjustable Retraction Stroke (Standard)	in (mm)		0.0-3.2 (0-80)	0.0-3.2 (0-80)	0.0-3.2 (0-80)
Water Cooling @ 36 psi (250 kP / 2.5 bar)	gpm (lpm)		1.6 (6)	1.6 (6)	1.6 (6)
Min/Max Water Pressure	psi (bar)		36-58 (2.5-4)	36-58 (2.5-4)	36-58 (2.5-4)
Aerial Noise Produced	dB(A)		<71	<70	<70
Measured Conditions					
Working Stroke	in (mm)		0.8 (20)	1.9 (50)	1.9 (50)
Welding Time	ms		160	380	380
Welding Current	kA		18.8	18.8	18.8
Working Rating (Welds per Minute)	#/min		15	6	6
Ø Arms	in (mm)		2.4 (60)	2.4 (60)	2.4 (60)
Ø Electrode Holders	in (mm)		1.26 (32)	1.26 (32)	1.26 (32)
Electrode Taper Size			5RW/2MT	5RW/2MT	5RW/2MT
Tooling Platen T-Slot Spacing					
T-Slot Spacing	in (mm)		–	1.77 (45)	1.77 (45)
Bolt Size	in (mm)		–	0.315 (8)	0.315 (8)
Net Weight	lbs (kg)		715 (325)	616 (280)	616 (280)
Dimensions L x W x H	in		59.8 x 16.5 x 73.4	44.1 x 16.5 x 73.4	44.1 x 16.5 x 73.4
	mm		(1520 x 420 x 1838)	(1120 x 420 x 1838)	(1120 x 420 x 1838)

*May be supplied capable of operating on other voltages/frequencies. Please ask for details.

SPECIFICATION		UNITS	WTP-6075 w/8031	WTP-6075A w/8031
Spot Welder			Spot	Spot
Projection Welder			Projection	Projection
Standard Control			TE751	TE700
Power @ 50% Duty Cycle	kVA		56	56
Max Power	kVA		200	200
No-Load Secondary Voltage	V		8.4	8.4
Short Circuit Current	A		25,000	25,000
Thermal Current @ 100%	kA		4.9	4.9
Supply Voltage (3-Phase @60Hz)*	V		440	440
Delayed Fuses @ 440VAC	A		50	50
Primary Cables Ø (up to 30m)	mm ²		25	25
Compressed Air Supply	psi (bar)		94.3-145 (6.5-10)	94.3-145 (6.5-10)
Air Consumption per 1000 Spots @ 94.3 PSI (650kP / 6.5 bar)	SCF (N/m ³)		307-92 (8.7-2.6)	307-92 (8.7-2.6)
Throat Depth – To Electrode Holders	in (mm)		19.7 (500)	19.7 (500)
Throat Depth – To Tooling Platens	in (mm)		15 (380)	15 (380)
Max Electrode Force @ 94 psi (6.5 bar)	lbs. (daN)		1034 (470)	1034 (470)
Working Stroke	in (mm)		0.2-3.2 (5-80)	0.2-3.2 (5-80)
Adjustable Retraction Stroke (Standard)	in (mm)		0.0-3.2 (0-80)	0.0-3.2 (0-80)
Water Cooling @ 36 psi (250 kP / 2.5 bar)	gpm (lpm)		1.6 (6)	1.6 (6)
Min/Max Water Pressure	psi (bar)		36-58 (2.5-4)	36-58 (2.5-4)
Aerial Noise Produced	dB(A)		<70	<70
Measured Conditions				
Working Stroke	in (mm)		1.9 (50)	1.9 (50)
Welding Time	ms		380	380
Welding Current	kA		18.8	18.8
Working Rating (Welds per Minute)	#/min		6	6
Ø Arms	in (mm)		2.4 (60)	2.4 (60)
Ø Electrode Holders	in (mm)		1.26 (32)	1.26 (32)
Electrode Taper Size			5RW/2MT	5RW/2MT
Tooling Platen T-Slot Spacing				
T-Slot Spacing	in (mm)		1.77 (45)	1.77 (45)
Bolt Size	in (mm)		0.315 (8)	0.315 (8)
Net Weight	lbs (kg)		649 (295)	649 (295)
Dimensions L x W x H	in		52.0 x 16.5 x 73.4	52.0 x 16.5 x 73.4
	mm		(1320 x 420 x 1838)	(1320 x 420 x 1838)
*May be supplied capable of operating on other voltages/frequencies. Please ask for details.				

Model: 6074 / 6074A

Model: 6075+8031 / 6075A+8031



**Item 8033**

Double stroke control device with pneumatic foot instead of key one. To be used only for spot welding when the work necessarily requires it.

**Item 73070 / 73038**

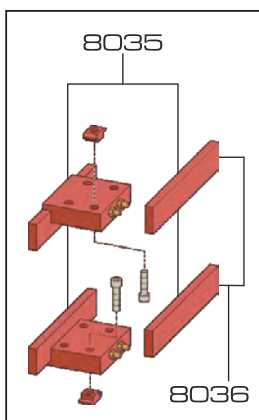
Additional double stage electric foot switch for the direct recalling of a different welding program.

**Item 72628**

Two-hand safety control on pedestal, adjustable height. Recommended for the operator safety according to the working requirements.

**Item 8043**

Electrodes descent without pressure for both maintenance and set-up.

**Item 8035 (45-45)**

Pair of electrode-holders to be used for multiple weldings on rod.

Item 8036

Pair of knife-type electrodes for multiple welding on rod.

**Item 8030**

Valve to stop the flow of the water cooling when the machine is off and flow switch which makes the welder stop if the cooling water does not circulate.

**Item 6033**

USB interface board.

**Item 8037**

Proportional valve. Allows to adjust the working pressure directly from the control unit and to combine a proper pressure value to each program. Assures constant and accurate working pressure. It can be used only on welders equipped with TE700 control unit.

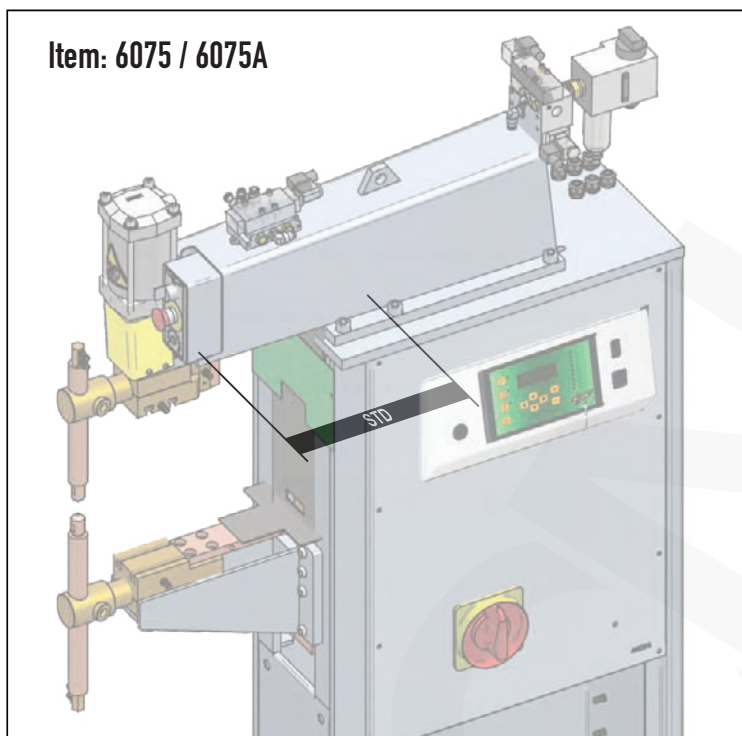
**Item 8038**

Position sensor. It can be used only on welders equipped with TE700 control unit.

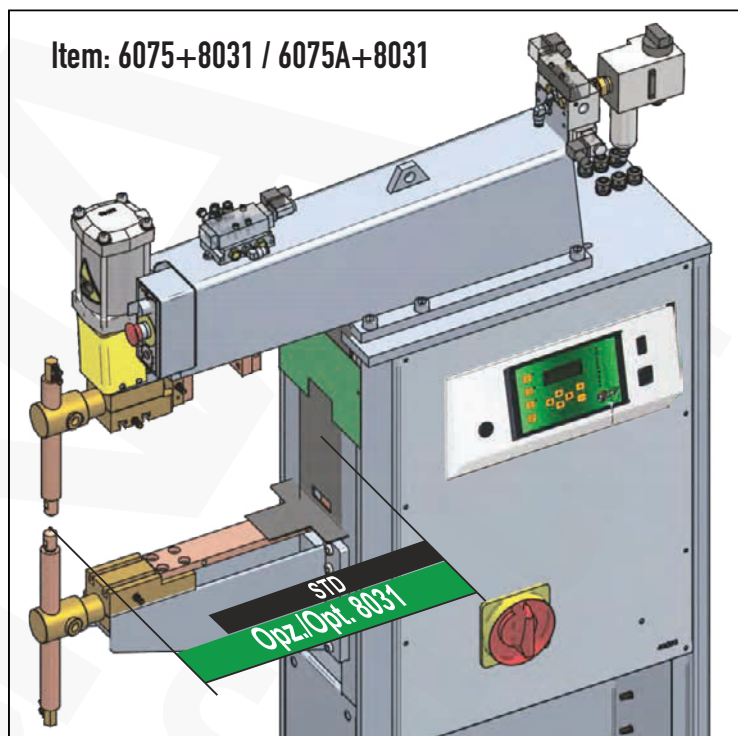
**Item 8042**

Rotary selector for recalling the welding programs. It can be used only on welders equipped with TE700 control unit.

Item: 6075 / 6075A



Item: 6075+8031 / 6075A+8031

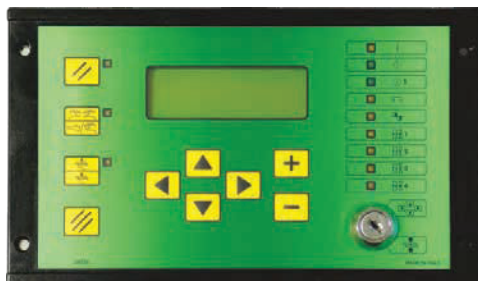


Item: 6074



Item: 6075+8031 / 6075A+8031





MODEL	TE751	TE750
Ammeter	●	●
Parameters No.	16	26
Programs No.	150	250
Welding programs recallable from foot pedal	2	2
RS232 Interface	○	○
USB Interface	○	○
Constant current	●	●
Stepper function	●	●
Constant energy	–	●
Two-hands input	●	●
Higher and lower current limits	●	●

● = Standard ○ = Optional – = Not Available

The TE751 is a medium frequency welding controller, it may work with constant current and fix operating modes.

It is possible to store up to 150 different welding programs. Each program comprises several programmable parameters that describe the work cycle. In addition to the plain 4-stage welding cycle, the control unit allows the running of welding processes with pre-welding current, post-welding current, slope and pulses.

MAIN TECHNICAL FEATURES

- Easy programming through 9 keys and backlit graphic LCD display.
- Inverter command with medium frequency IGBT, with possibility of choosing the operating frequency of the inverter between 1000 Hz and 4000 Hz.
- Storage of 150 welding programs, up to 15 which may be called from the outside.
- Up to 16 programmable parameters for each program.
- Current slope up, current slope down, impulses, pre-weld, post-weld functions and adjustment of the welding times with 1 ms resolution.
- Display of welding current RMS and percentage use of the machine.
- 2 operating modes: constant current and FIX.
- Current limits and percentage use of the inverter.
- Double stroke function.
- Stepper function to compensate the wear of the electrodes with programmable curves.
- Single and automatic cycle.
- WELD / NO WELD function.
- Two-hand control function.
- Management of three 24 Vdc max 5W solenoid valve with self-protected output.
- Self-adjustment to the mains frequency 50/60 Hz.
- Communication (optional) through RS232 or USB port.
- Selectable languages: Italian, English, French, German, Spanish, Hungarian, Swedish, Dutch, Czech or Portuguese.
- Possibility of updating control unit firmware.
- Programme sequence.
- Possibility of graphically displaying welding time and current.
- Possibility of consulting weld tables.



Industrial Resistance Welders and Tool Balancers



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