

LORS-TECNA

Rocker Arm-Type Spot Welders

WATER-COOLED, AIR and FOOT OPERATED



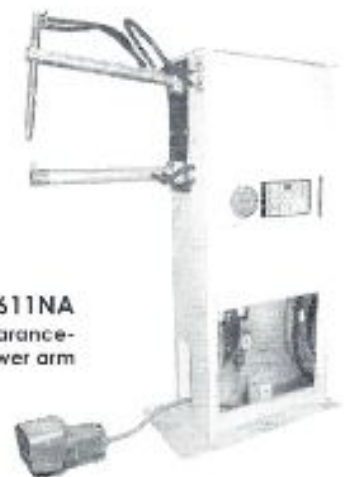
MODEL 4609NA-4611NA
Water-cooled Air Rocker
with optional 2nd Footswitch
for weld schedule "B"



MODEL 4604NA-4606NA
Water-cooled Foot Rocker

FEATURES

- Rugged Welded Steel Frame.
- Built-in Microprocessor Control TE90 with Dual Current, Dual Weld Time, Upslope and Pulsation.
- Digital Phase Shift Weld Current adjustment from 01% to 99% for precision welding.
- Maintenance Free Solid State SCR Contactor.
- KVA rating: 20 and 25.
- Dual Voltage 220V-440V / Single Phase / 60 Hertz output Welding Transformer.
- Soft Touch Control Pad with LED function and value indicators.
- Adjustable Throat Depth:
Models 4604NA/4606NA/4609NA/4611NA - 15" to 27-1/2"
- Universal Arms for 90° or inclined tip holder position.
- Speed Control adjustments on the Air Rocker.
- Two Stage Electric Footswitch with the option to add a second footswitch for Dual Current and Dual Weld Time - Air Rocker only.



MODEL 4609NA-4611NA
with optional low clearance-
type lower arm

OPTIONS

- | |
|--|
| IE4566: Lower Arm with 90° Threaded Adapter
2MT/5RW, 27-1/2" Max Throat (4604NA/4609NA) |
| IE4567: Lower Arm with 90° Threaded Adapter
2MT/5RW, 27-1/2" Max Throat (4606NA/4611NA) |

SPECIFICATIONS

LTR MODEL:	4604NA	4606NA	4609NA	4611NA
TYPE:	FOOT OPERATED ROCKER ARM		AIR OPERATED ROCKER ARM	
TRANSFORMER:	Water-Cooled, Dual Voltage Compact High Output Type			
KVA RATING @ 50% Duty Cycle: Maximum Short Circuit:	20 40	25 45	20 40	25 45
SECONDARY CURRENT (A): Short Circuit	13,500	15,000	13,500	15,000
SECONDARY VOLTAGE (V):	2.75 - 3.8			
WATER COOLING: (gallons per hour)	47 gph	58 gph	47 gph	58 gph
ELECTRICAL CONNECTIONS:	220V-440V/1 PHASE/60 Hz.			
RECOMMENDED CABLE: For not more than 5% Voltage drop in 100 feet	220V 1AWG	220V 1AWG	440V 6AWG	440V 6AWG
FUSE RATING:	70A	60A	40A	40A
INITIATION:	Standard Manual Footswitch (adjustable in length)		Standard Dual Stage Electric Footswitch (2nd footswitch receptacle for dual current operation)	

WELDER CONTROL: TE 90

- Built-in Digital Solid State Microprocessor Control with LED display and indicators.
- Synchronous Control with thyristor, insulated water-cooling and over-temperature protection.

Phase Shift control adjustable from 20% to 100%, weld time adjustable from 1 to 99 cycles to allow precision welding.

Simplified programming by means of four push-buttons.

Dual pre-setting for time and current selectable by optional second footswitch.

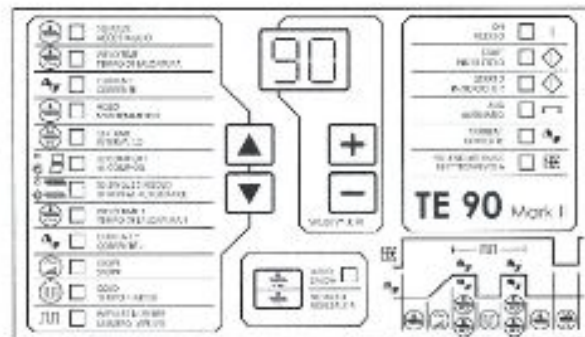
Parameters include: Squeeze, Weld, Hold, Off times, Dual Currents, Pulsation, Upslope and Single Spot or Auto Repeat functions.

Secondary current compensation function for welding of oxidized sheets and rods.

Auto-Retain disabling for manually operated welders.

First Phase Shift Delay adjustment.

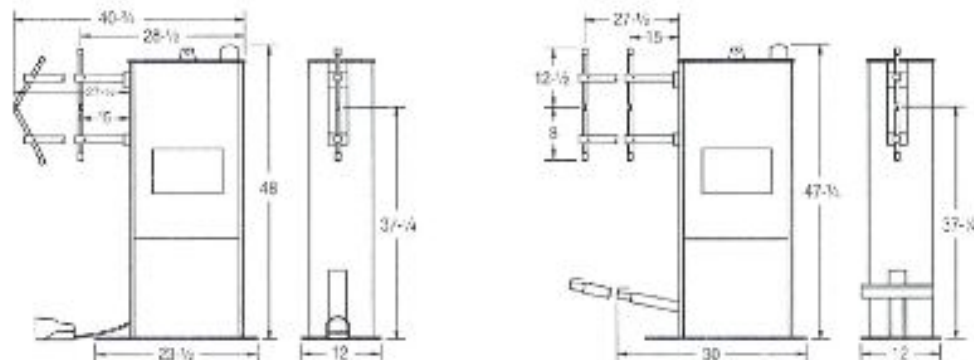
Maintenance free SCR Contactor.



ARM DIAMETER: 1-1/2" Diameter ELECTRODE HOLDERS: 1" Diameter ELECTRODE TIPS: 1MT/4RW

DISTANCE BETWEEN ARMS:		NET WEIGHT:	
4604NA: 8-1/8"	4606NA: 8-1/8"	4804NA: 290 Lbs.	4806NA: 295 Lbs.
4609NA: 8-1/8"	4611NA: 8-1/8"	4809NA: 288 Lbs.	4811NA: 290 Lbs.

DIMENSIONS:



Specifications are subject to change without notice.

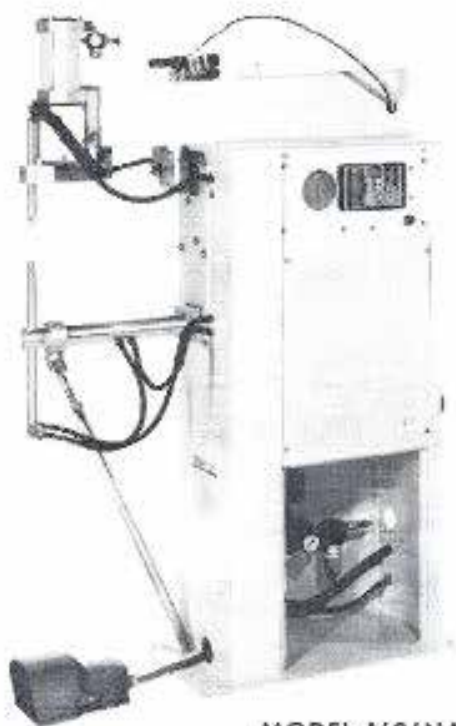
LORS-TECNA

50 KVA SPOT WELDERS

WATER-COOLED and AIR OPERATED

FEATURES

- Rugged Welded Steel Frame.
- Built-in Microprocessor Control TE90 with Dual Current, Dual Weld Time, Upslope and Pulsation.
- Digital Phase Shift Weld Current adjustment from 01% to 98% for Precision Welding.
- Maintenance Free Solid State SCR Contactor.
- Dual Voltage 220V-440V / Single Phase / 60 Hertz output Welding Transformer.
- Soft Touch Control Pad with LED function and value indicators.
- Adjustable Throat Depth on the Rocker Arm.
- Speed Control adjustments.
- Two Stage Electric Footswitch with the option to add a second Footswitch for Dual Current.
- Combination Air Filter and Pressure Regulator with Gauge.

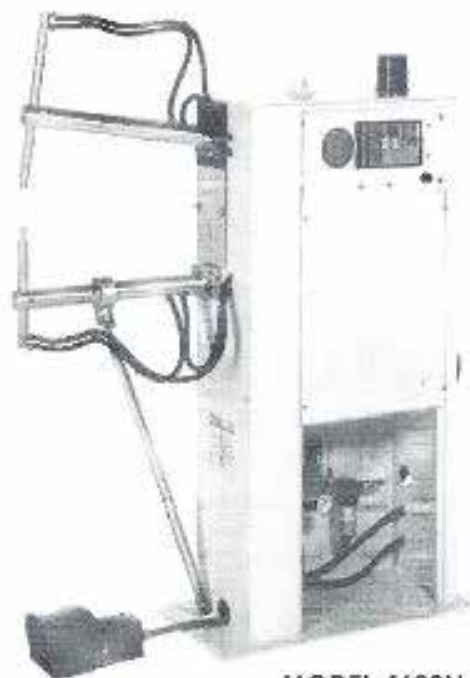


MODEL 4626NA
Vertical Press-Type
with standard high lift retraction
stroke air cylinder

OPTIONS FOR 50 KVA ROCKER

TE4574: Standard Upper Arm to accept 1" Dia. Straight Holder-
2MT;5RW. 31-1/2" (800 mm.) Max. Throat

TE4575: Standard Lower Arm to accept 1" Dia. Straight Holder-
2MT;5RW. 31-1/2" (800 mm.) Max. Throat



MODEL 4622NA
Rocker Arm-Type

SPECIFICATIONS

KVA RATING @ 50% Duty Cycle: MAXIMUM SHORT CIRCUIT (A):	LTR 4622NA 50 KVA 21,400 A	LTP 4626NA 50 KVA 17,900 A
TRANSFORMER:	Water-cooled, Dual voltage	
SECONDARY VOLTAGE (V) NO LOAD:	6.3V	6.3V
FORCE RATINGS Maximum Throat: Minimum Throat:	472 Lbs. 955 Lbs.	674 Lbs. -----
ELECTRICAL CONNECTIONS - DUAL VOLTAGE:	220V-440V/1/60	220V-440V/1/60
RECOMMENDED CABLE For not more than 5% voltage drop in 100 ft.	220V/1 PH 4/0 AWG	440V/1 PH 1 AWG
FUSE RATING (Long Delay Type)	150A	80A

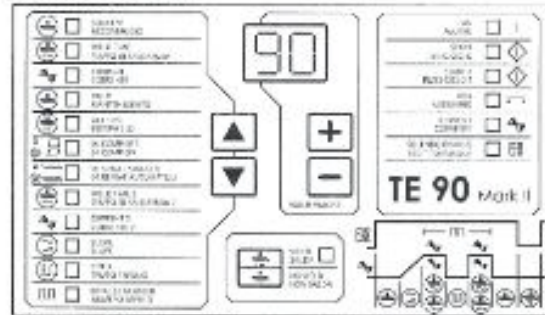
ELECTRIC FOOT SWITCH INITIATION: Machines come standard with one dual stage electric footswitch with a second foot-switch receptacle for dual current operation. A second footswitch can be added to enhance this operation.

WELDER CONTROL: TE 90

Built-in Digital Solid State Microprocessor Control with LED display and indicators.

Synchronous Control with thyristor, insulated water-cooling and over-temperature protection.

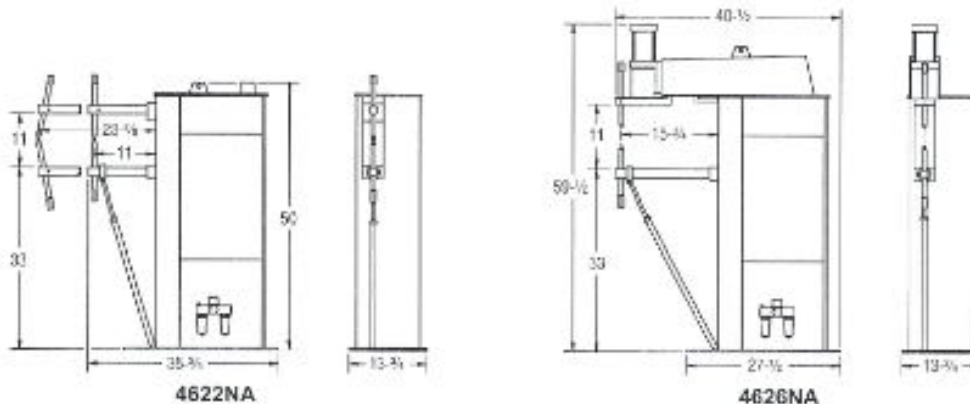
- Phase Shift control adjustable from 20% to 100%, weld time adjustable from 1 to 99 cycles to allow precision welding.
- Simplified programming by means of four push-buttons.
- Dual pre-setting for time and current selectable by optional second footswitch.
- Parameters include: Squeeze, Weld, Hold, Off times, Dual Currents, Pulsation, Upelope and Single Spot or Auto Repeat functions.
- Secondary current compensation function for welding of oxidized sheets and rods.
- Auto-Retain disabling for manually operated welders.
- First Phase Shift Delay adjustment.
- Maintenance free SCR Contactor.



- FEATURES:**
- Combination air filter and pressure regulator with gauge.
 - Lubrication-Free design air cylinder and shaft of hard chrome plated steel for high production and long life.
 - Standard high-lift retraction stroke air cylinder on vertical press type provides extra tip clearance. 3" maximum opening.
 - Standard adjustable throat depth on rocker arm type permits adjustment from 11" to 23-1/2". Adjustable stroke.

ARM DIAMETER: 2" Diameter	ELECTRODE HOLDERS: 1" Diameter (Ejector-type)
ELECTRODE TIPS: 2 MT / 5 RMWA	DISTANCE BETWEEN ARMS: 11" (280 mm)
NET WEIGHT: Rocker Arm- 424 Lbs. Vertical Press- 440 Lbs.	

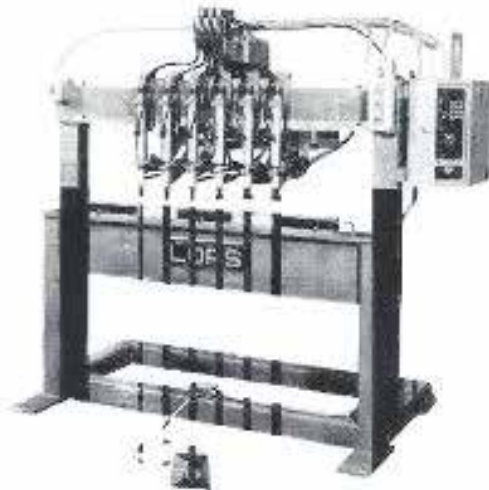
DIMENSIONS:



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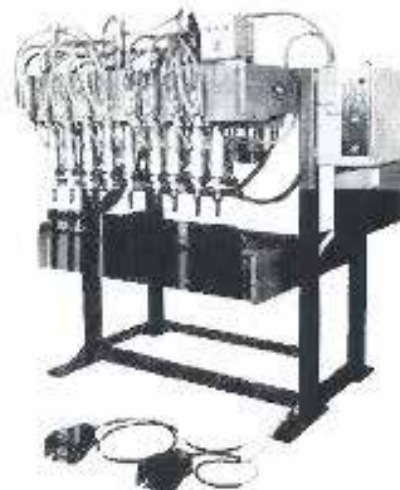
LORS General Purpose In-Line Multi-Head Spot Welders

The following Multi-Spot Welders are representative of the many cost effective welders designed and built by LORS to increase productivity, improve product quality and cut welding costs. Consult LORS for all your Resistance Welding requirements.



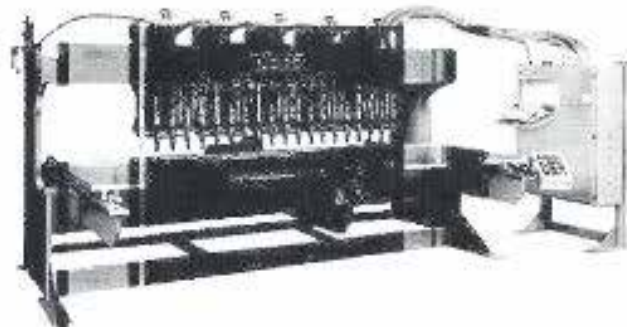
MODEL 641

Six Gun Series-Type Resistance Welder, economical and versatile, with weld gun sequence operation. Selection of weld gun pair sequence and weld pattern.



MODEL 592

Nine Gun In-Line Multi-Spot, set-up for 8 Gun series welding and one direct weld gun. Used to weld stiffeners and brackets onto panels.



MODEL 772

Special 20-Head Series-Type Resistance Welder, with computerized weld control for gun selection and servo drive for auto-indexing of fixture tools.

Consult **LORS** for all your Resistance Welding Equipment and supplies.