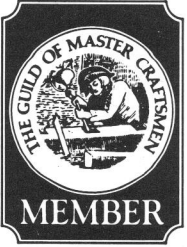


Meritus
Standard
Machines



manufactured in
the United Kingdom



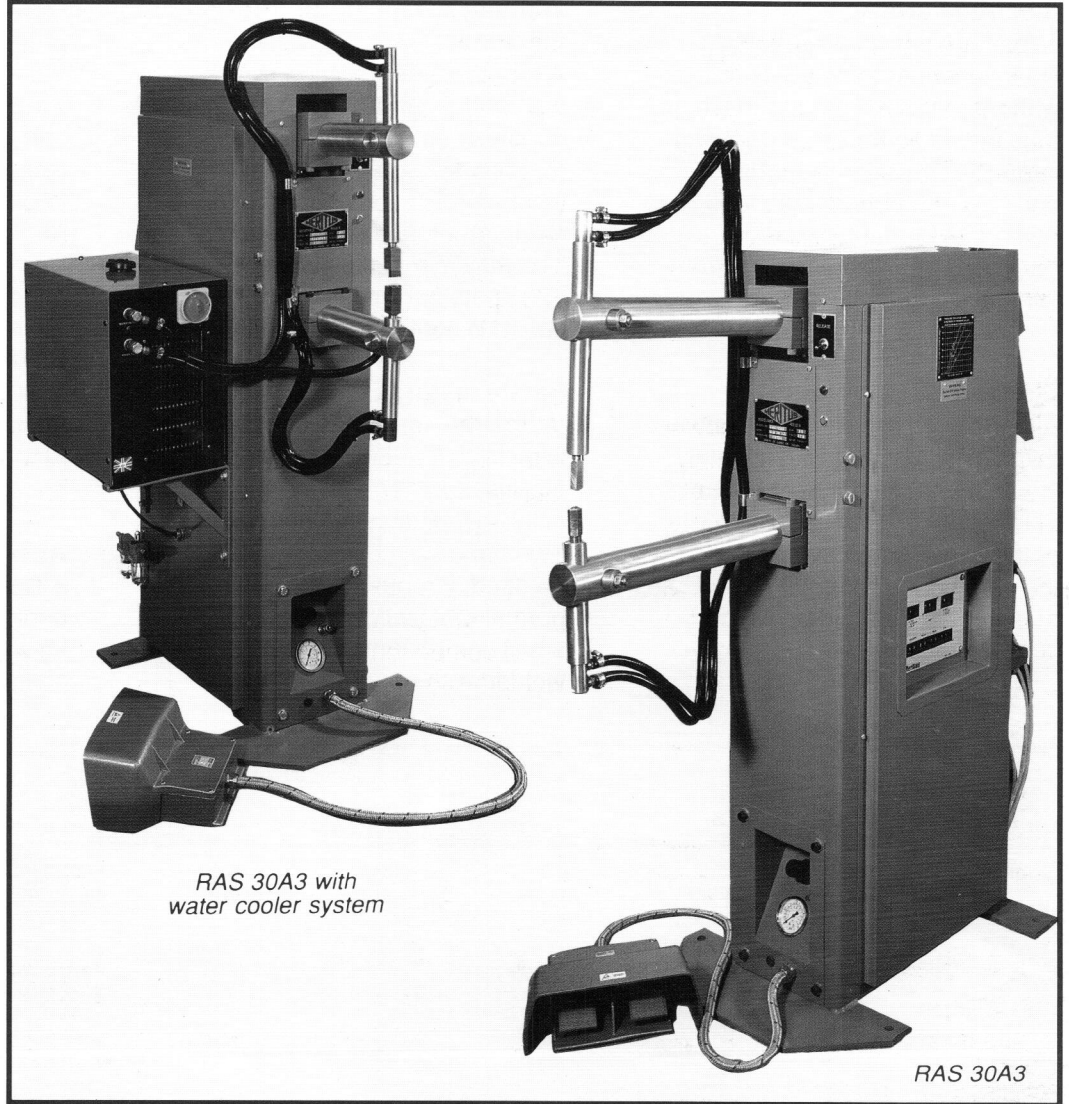
WORLDWIDE RANGE

Air operated spot
welding machines
from 10kva to 150kva

Meritus (St Albans) Ltd

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Hertfordshire AL1 1PN, England.

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*RAS 30A3 with
water cooler system*

RAS 30A3

'Autoforge' spot welders

Range

There are eight standard sizes covering 10, 15, 20, 30, 50, 75, 100 and 150 kva. These machines are particularly suitable for high speed continuous duty.

Operation

This is by solenoid controlled two-way compressed air cylinder applying pressure through a rocker beam.

Electrode cushion control

This adjusts the descent of the upper electrode to any desired speed and completely eliminates 'hammer blow'.

Initiation of welding cycle

This is automatically controlled by means of the 'squeeze' time setting selected on the 4 stage solid state synchronous electronic controller and used in conjunction with 'weld', 'hold' and 'off' times to control weld quality.

Electrode pressure

This is accurately controlled by means of an air pressure regulator and pressure gauge. Minimum air line pressure requirement 5.6 kgms/cm² (80 lbs/in²).

Water cooling

The electrodes, electrode holders and secondary connection points are all water cooled - minimum volume 7 litres per min. (1.1/2 gallons per min.)

Electrode arms

These are telescopic, enabling working length to be adjusted without removal from the machine, thus providing maximum welding capacity. Provision is made for both top and bottom electrode holders to be set forward or backward at an angle of 20° from vertical when required.

Electronic contactors

All machines are fitted with power thyristor contactors with infinitely variable phase shift heat control. This facility adds to the versatility of these machines by increasing the variety and range of thicknesses of materials that can be welded successfully.

Welding Facilities on 'Autoforge' machines

A thumbwheel selection switch on the control panel adjusts the machine for single spot or stitch welding also for roller spot and seam welding when used in conjunction with the Meritus motorised seam welding head. The maximum stitch welding rate is 120 spots per minute; seam welding speed is continuously variable.

Safety features

'Autoforge' machines are supplied with 'High lift - Low force approach' facilities or alternatively, with infinitely adjustable electrode gaps. Two hand switch initiation can also be fitted, if required, in addition to normal foot switch operation so that small components can be projection welded with operator safety.

Optional Extras Available

High lift - Low force approach.
Variable speed motorised seam welding attachment (circumferential and longitudinal).
Copper arms.
Wide range electrodes and holders.
Self contained water cooler system.
Upslope, downslope, pre-heat and pulsation timers.

Spares

The Meritus Autoforge range is manufactured in the United Kingdom and a full stock of parts are always readily available.

After Sales Service

A team of experienced service engineers are always prepared for a speedy response to customer needs.

Specification 'Autoforge' spot welders							
model	kva	arm length variable between	no of welding heats	electrode pressure	welding time	maximum continuous capacity	weld timer
RAS 10A3	10	150 mm & 450 mm	infinitely variable	215 kg with 300 mm arms	1 to 99 HZ	2 x 8 mm dia steel wire 2 x 2 mm steel sheet	all machines fitted with Meritus solid state synchronous controller type SST3 (811 - 1410)
RAS 15A3	15	150 mm & 450	infinitely variable	300 kg with 300 mm arms	1 to 99 HZ	2 x 9.5 mm dia steel wire 2 x 2.65 mm steel sheet	
RAS 20A3	20	150 mm & 600 mm	infinitely variable	260 kg with 450 mm arms	1 to 99 HZ	2 x 9.5 mm dia steel wire 2 x 3.25 mm steel sheet	
RAS 30A3	30	150 mm & 600 mm	infinitely variable	280 kg with 450 mm arms	1 to 99 HZ	2 x 12.5 mm dia steel rod 2 x 4 mm steel sheet	
RAS 50A3	50	300 mm & 600 mm	infinitely variable	300 kg with 450 mm arms	1 to 99 HZ	2 x 16 mm dia steel rod 2 x 5.00 mm steel sheet 2 x 1.25 mm brass or aluminium sheet	
AS 75A2	75	350 mm & 600 mm	infinitely variable	300 kg with 450 mm arms	1 to 99 HZ	2 x 6.25 mm steel sheet 2 x 2 mm brass or aluminium sheet	
AS 100A2	100	350 mm & 600 mm	infinitely variable	570 kg with 450 mm arms	1 to 99 HZ	2 x 6.25 mm steel sheet 2 x 3.25 mm stainless steel 2 x 2.5 mm brass or aluminium sheet	
AS 150A2	150	350 mm & 600 mm	infinitely variable	570 kg with 450 mm arms	1 to 99 HZ	2 x 6.25 mm steel sheet 2 x 3.25 mm stainless steel 2 x 3.25 mm brass or aluminium sheet	