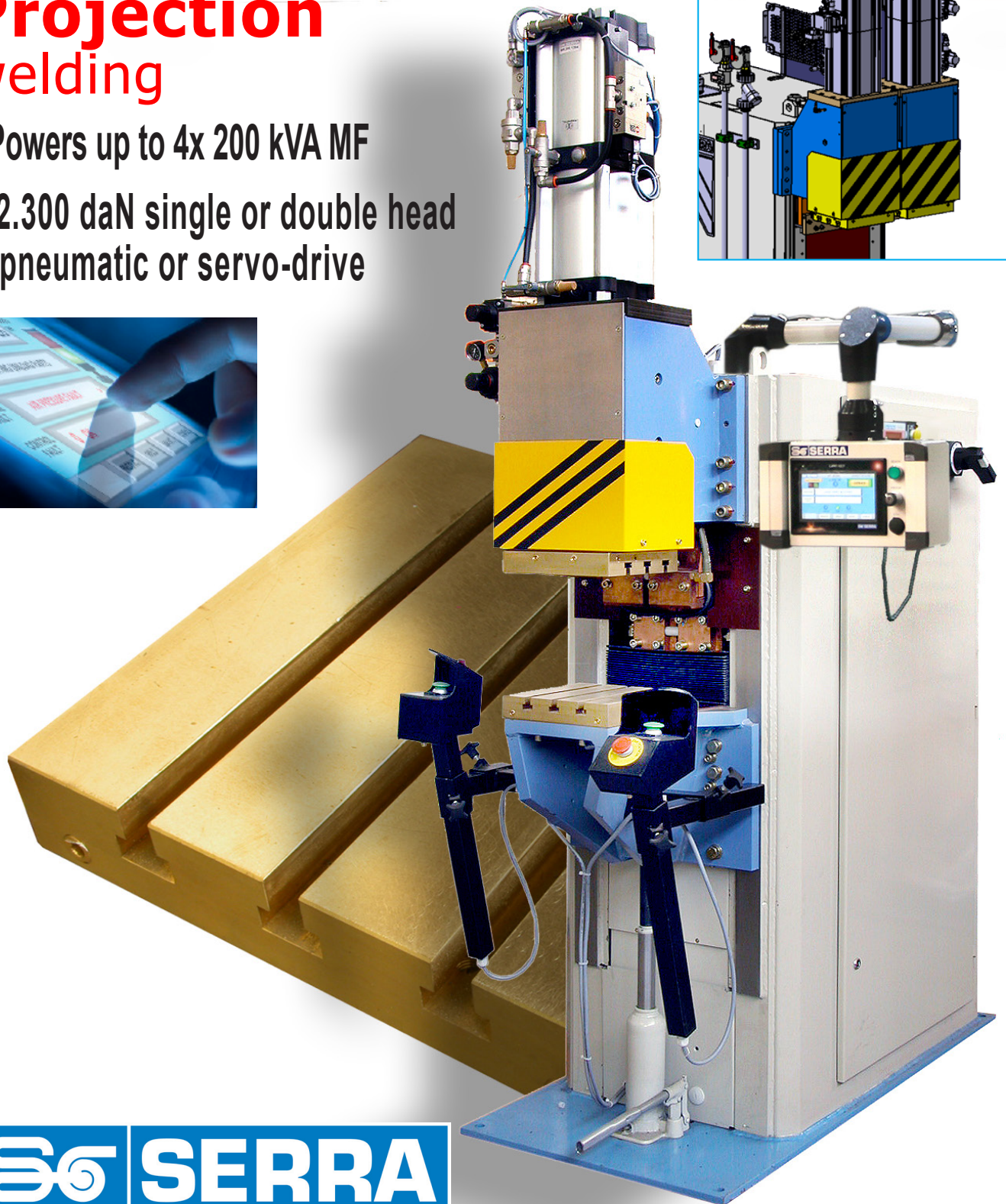
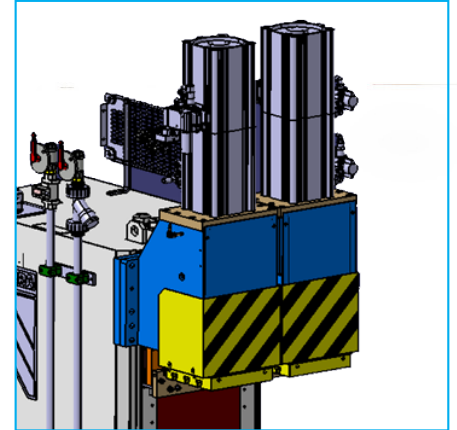
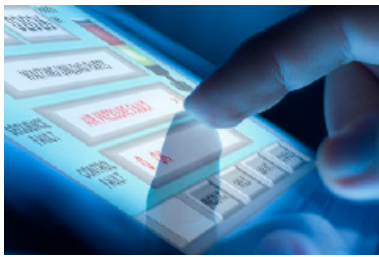




beta 323

Projection welding

- ▶ Powers up to 4x 200 kVA MF
- ▶ 2.300 daN single or double head pneumatic or servo-drive



SERRA

323

Standard equipment

- Pneumatic circuit with counterpressure system
- Elastomer for head tracking
- I-O water valves 3/4"
- Two hands start
- Brass platforms 3 slots

In AC welders:

- Main switch

In MF welders:

- Programming touchscreen UPF-107
- Circuit breaker
- Electronic flowmeter for water flow and temperature measurement

Optionals

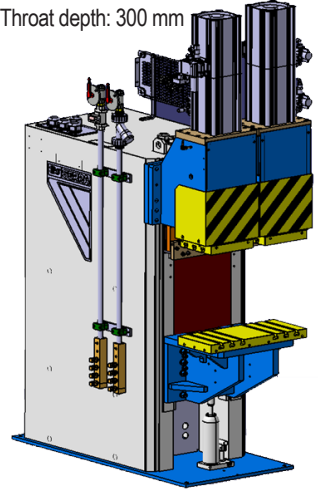
- Max. separation between platforms 550 mm
- DIN throat depth 300 mm
- Brass platforms 4 slots
- Force control by means of load cell
- Proportional valve
- Electronic flowmeter (in AC welders)
- Linear transducer
- Separate water chiller
- Safety pneumatic door 800 mm stroke
- Safety light curtain 30 mm resolution
- Safety light curtain 14 mm resolution

For nut or bolt welding:

- Automatic feeders
- Smart electrode
- Brass arm set of electrodes for nut or bolt welding.

Double head

- Working sequence:
 - Electric cascade for 1200 or 1400 daN
 - Pneumatic cascade for 2300 daN
- Throat depth: 300 mm



Technical features

Main Voltage	V	400 (50 Hz)
Platform dimensions	mm	250x250
Platform slots	nº	3
Distance between slots	mm	63
Distance between platforms (min.-max.)	mm	140-400

Order Code

B 3 1 2 1 Transformer

Structure dimensions

- 1- Up to 300 daN
- 2- Up to 1400 daN
- 3- Up to 2300 daN
- 4- Up to 5000 daN

Force unit

- 1- 1x2300 daN-Single pressure
- 2- 1x2300 daN-Counterpressure
- 3- 2x1400 daN-Single pressure
- 4- 2x1400 daN-Counterpressure
- 5- 2x2300 daN-Single pressure
- 6- 2x2300 daN-Counterpressure
- 7- 1x1400 daN-Single pressure
- 8- 1x1400 daN-Counterpressure
- 0- Servo electric head

Throat depth

- 1- 250 mm
- 2- 300 mm

Transformer

- 1- 200 kVA - AC
- 2- 250 kVA - AC
- 3- 300 kVA - AC
- 4- 1 x 170 kVA-MF
- 5- 1 x 200 kVA-MF
- 6- 2 x 170 kVA-MF
- 7- 2 x 200 kVA-MF
- 8- 4 x 170 kVA-MF
- 9- 4 x 200 kVA-MF

Beta 323 - MACHINE CODES		B3121	B3122	B3243	B3124	B3126	B3128	B3266	B3286	B3104	B3106
Welding frequency	Hz	50	50	50	1000	1000	1000	1000	1000	1000	1000
Power at 50 % D.C.	kVA	200	250	300	170	2x170	4x170	2x170	4x170	170	2x170
DIN throat depth	mm	250	250	300	250	250	250	300	300	250	250
Cylinder force at 6 bar	daN	2300	2300	2x2300	2300	2300	2300	2x2300	2x2300	electric	electric
Max. Short C.current 5 periods (*)	kA	44	51	56	36	74	110	74	110	36	74
Max. weld current in 5 periods (*)	kA	29	33	37	36	74	110	74	110	36	74
Air consumption 50mm / 6 bar	NI	27,4	27,4	54,8	13,7	13,7	13,7	54,8	54,8	-	-
Cooling water consumption	l/h	360	360	360	720	1200	1200	1200	1200	720	1200
Admissible power (**)	kVA	65	85	100	60	110	180	110	180	60	110
Delayed fuses (**)	A	160	210	250	150	300	450	300	450	150	300
Main supply section by phase (**)	mm ²	95	120	2 x 70	70	2 x 70	2 x 120	2 x 70	2 x 120	70	2 x 70
Secondary voltage	V	7,5 / 10,5	8,3 / 12,2	10 / 13,2	10	10	10	10	10	10	10
Working stroke	mm	120	120	120	120	120	120	120	120	120	120
Electronic weld controller	-	CSP-1B	CSP-1B	CSP-1B	MFC-3015	2xMFC-3015	2xMFC-3015	2xMFC-3015	2xMFC-3015	MFC-3015	2xMFC-3015
Width	mm	650	650	650	650	720	650	720	720	650	650
Length	mm	1650	1650	1650	1650	1650	1650	1650	1650	1650	1650
Heigh	mm	2310	2310	2310	2310	2310	2310	2310	2310	2310	1650
Weight	kg	870	870	1020	780	850	890	1040	1100	780	850

(*) Values for secondary circuit with 200mm separation between platforms and 100mm stroke. (**) Values for max. welding current up to 4% Duty Cycle and line voltage drop < 3% with cable up to 30m.

