

KEJETHERM

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Upset Butt welding

Introduction

Weld quality obtained is mechanically and metallurgically similar to the parent metal. Because of shorter weld times the process is suited for higher production than other conventional methods. No additional material such as rods or gas etc. are required, thus it is highly economical. The machine cycle involves heating, upset butt welding followed by flash removal by special molybdenum alloyed inserts.

Applications

Upset butt welding of copper rod, brass rod, high speed tools to carbon steel & others.

Features

- Fully hydraulically operated & upset by high speed pneumatic thrust.
- Air cooled transformer having core of high grade silicon steel conforms to IS 4804, Part II.
- Precision control on initial die opening Upset length, time, length and final die opening.
- Precision time delay circuit for upset current.
- Safety and sequential interlinks provided for prolonged trouble free tooling operation.
- Highly rigid structure to counter the upset forces.
- Basic machine can be fitted with wide range of specifically designed to suit individual components.
- All the functions are through PLC operation for precision settings and ease of control.

TECHNICAL DATA

Model	Units	TUB-30	TUB-50	TUB-75	TUB-100	TUB-150
Supply voltage at 1 phase 50hz	V	415	415	415	415	415
Nominal Rating at 50% duty cycle	KVA	30	50	75	100	150
Switch Fuse	A	75	125	180	250	360
Current Taps	Nos.	6	6	6	6	6
Insulation class	Class F					
Cooling	PRIMARY AIR COOLED AND SECONDARY WATER COOLED					
Clamping force (hydraulic)	Kgs.	400	800	1000	1200	1500
Upset Force (pneumatic)	Kgs.	2500	3500	4500	5500	6500
Welding Capacity	mm	6+6	8+8	10+10	12+12	16+16
Water Required	Ltrs./min	17	20	25	30	40

Note : The information and illustration in this catalogue are subject to alterations due to constant endeavour to update design