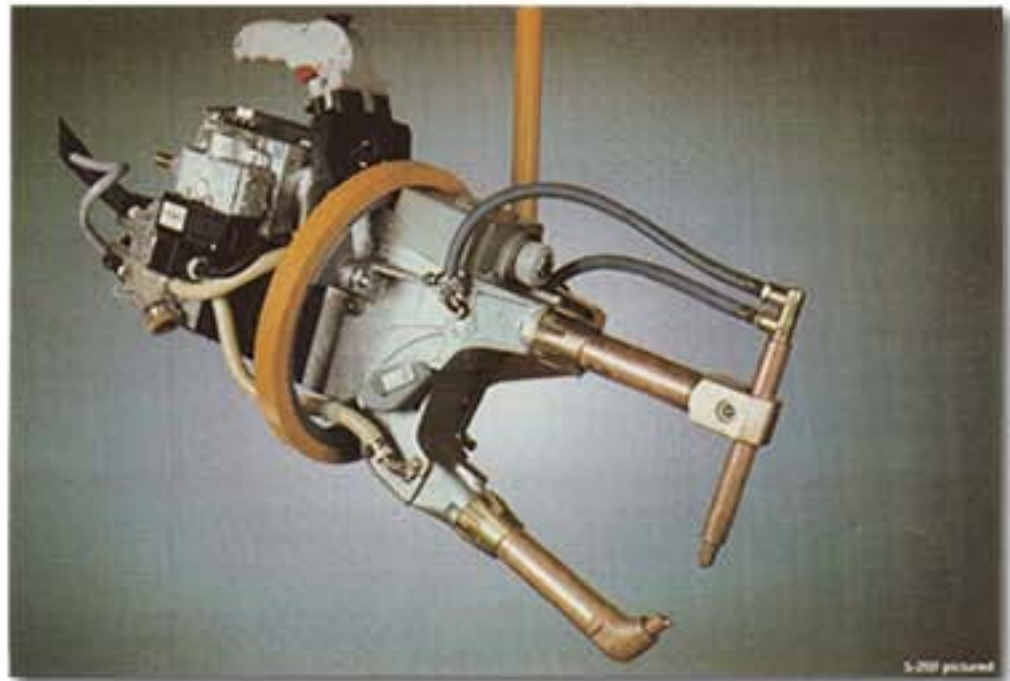


Air Operated / Water Cooled

The S-2151 series guns are specifically designed as an economical means of joining light gauge sheet steel. They are extremely compact and also highly maneuverable on all three planes of operation. Ideally suited for production line use, they have built-in versatility for many custom applications.



S-2151 pictured

Features

- Rated at 15 kVA with 15,000 amps secondary short circuit current.
- Maximum electrode force of 560 lbs at 85 psi and shortest throat depth.
- Ball-race type gyroscopic suspension allows easy rotation.
- Interchangeable standard arms provide throat depths of 6.29 in through 19.68 in.
- Gyro lock provides consistency in all planes of operation.
- Trigger controlled retraction for extra electrode clearance to work stroke.
- Designed for single spot or automatic repeat with appropriate controls.
- Fully water cooled.
- Epoxy-resin encapsulated transformer.
- Standard cable length of 50 ft.
- Weighs 72 lbs with short arms.

SPECIFICATIONS

WELDING CAPACITY Gun Arms 6.29" (160mm) Gun Arms 19.68" (500mm)	MILD SHEET STEEL 12 + 12GA. (2.5 + 2.5mm) 20 + 20GA. (1 + 1mm)		ELECTRODES Diameter Electrode Stroke Adj. (Short Arms) Clearance Stroke Adj. (Short Arms)	.482" IMT (4RW) 0 to 0.67" (0. to 17mm) 0 to 1.97" (0 to 50mm)
SEC. CURRENT (AMP) Short circuit 20 + 20GA. 14 + 14GA.	6.29" Arm 15,000 13,500 12,500	19.68" Arm 12,000 11,000 —	GUN ARMS Connection Shaft Dia. External Dia. Throat Height (S-2151) Throat Depth Standard Throat Depth Maximum	1" (2.54mm) 1.26" (32mm) 4.25" (108mm) 6.29" (160mm) 19.68" (500mm)
SECONDARY OPEN CIRCUIT VOLTAGE (V)	3.6		WATER CONSUMPTION Circulation at 30 PS.I.	1.05G.P.M. (290L.P.M.)
RATING KVA At 50% Duty Cycle At 100% Duty Cycle Maximum Welding Power (KVA)	15 10.5 46 at 5.5%		WATER COOLANT Temperature Not to Exceed Recommended Temp.	78° F 25.7° C. 60° F 15.6° C.
ELECTRICAL CONNECTIONS Cable Sec. area for Voltage Drop not more than 5% for length of 65 feet. Long Delay Fuse	220V #6 50 amp	440V #10 25 amp	AIR CONSUMPTION	1,000 Spots
THERMIC DUTY CALCULATOR (A)	3,000		Short Stroke Maximum Stroke	26 cu. ft. (0.75 cu.m.) 76 cu. ft. (2.15 cu.m.)
ELECTRODE FORCE LBS (For Air at 85 PS.I.) Gun Arms 6.29" Gun Arms 19.69"	560 lbs. 200 lbs.		WEIGHT	(6.29" Arms Suspension and Cables) 72 lbs. (32.5Kg)

STANDARD GUN ARMS

WORKING THROAT DEPTH	UPPER VERTICAL S-2151	UPPER INCLINED S-2151	LOWER VERTICAL S-2151	LOWER INCLINED S-2151
6.29" (160mm)	WG2003 10	N/A	WG200 104	WG200204
9.44" (240mm)	WG2 103 12	WG2 10409	WG2 10 108	WG2 102 12
12.40" (310mm)	WG220308	WG220409	WG220 107	WG2202 15
15.35" (390mm)	WG2203 10	WG2204 12	WG220 111	WG2202 16
19.68" (500mm)	WG240305	WG240404	WG240 103	WG240207

NOTE: Special arms available upon request. Specifications and design details subject to change without notice.