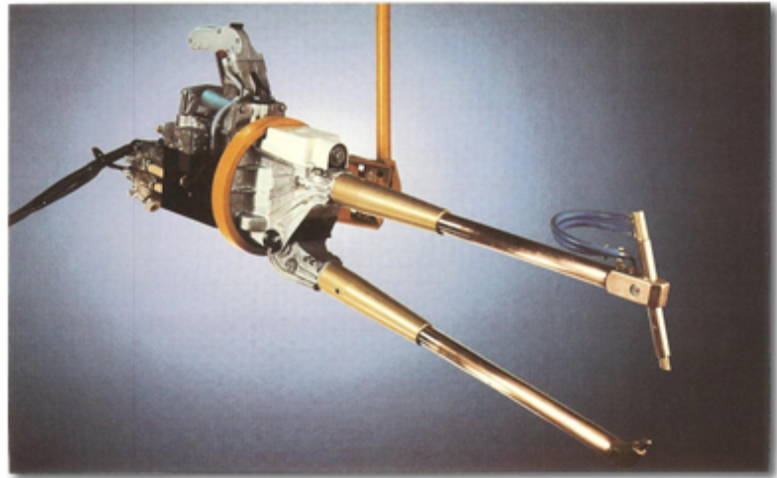


Air Operated - Water Cooled

The S-3231 guns are designed for high production with either single spot or repeating spot operation. They are extremely compact and also highly maneuverable on all three planes of operation. Ideally suited for production line use, they have sufficient capacity for most short throat applications on sheet steel.



Features

- Rated at 23 kVA with 18,000 amps secondary short circuit current.
- Maximum electrode force of 840 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 25.59 in.
- Special arms designed for applications.
- Trigger controlled retraction for extra electrode clearance to work stroke.
- Suitable for use with full range of standard and special controls.
- Fully water cooled.
- Epoxy-resin encapsulated transformer.
- Standard cable length of 50 ft.
- Weighs 98 lbs with short arms.

SPECIFICATIONS

WELDING CAPACITY		MILD SHEET STEEL		ELECTRODES	
Gun Arms 6.29" (160MM)	10+10GA. (3.5+3.5MM)	Diameter	IMT (4RW)		
Gun Arms 19.68" (500MM)	14 +14GA. (2 + 2MM)	Electrode Stroke Adj. (Short Arms)	0-0.87" (0-22MM)		
		Clearance Stroke Adj. (Short Arms)	0-2.05" (0-52MM)		
SEC. CURRENT (AMP)		6.29" Arm	19.68" Arm	GUN ARMS	
SHORT CIRCUIT		18,000	14,000	Connection Shaft Dia.	1.18" (30MM)
20 + 20GA.		17,000	13,000	External Dia.	1.26" (32MM)
14 + 14GA.		16,000	11,000	Throat Height (S-3231)	4.25" (108MM)
				Throat Depth Standard	6.29" (160MM)
				Throat Depth Maximum	31.50" (800 MM)
SEC. OPEN CIRCUIT VOLTAGE (V)		4.3		WATER CONSUMPTION	
RATING KVA				Circulation at 30 P.S.I.	1.2GPM (320 LPH)
At 50% Duty Cycle		23		WATER COOLANT	
At 100% Duty Cycle		16.1		TEMPERATURE NOT TO EXCEED	78° F. 25.7° C.
Maximum Welding		62 at 6.7%		RECOMMENDED TEMP.	60° F. 15.6° C.
ELECTRICAL CONNECTIONS		220V	440V	AIR Consumption for 1,000 Spots	
Cable Sec. Area for Volt				Short Stroke	88.3 cu. ft. (2.5M)
Drop not more than 5% for				WEIGHT	
Length of 100 feet	4	8		(6.29" Arms Suspension & Standard Cables)	
Long Delay Fuse	60	30		98 LBS (44.5 KG)	
THERMIC DUTY CALCULATOR (A)		4,600			
ELECTRODE FORCE Lbs - For Air at 85 P.S.I.					
Gun Arms 6.29" (160MM)		840			
Gun Arms 19.68" (500MM)		310			

STANDARD GUN ARMS

WORKING THROAT DEPTH	UPPER VERTICAL S-3231	UPPER INCLINED S-3231	LOWER VERTICAL S-3231	LOWER INCLINED S-3231
6.29-(160MM)	WG300303	---	WG300 103	WG300206
9.44-(240MM)	WG3 10302	WG3 10402	WG3 10 102	WG3 10202
12.20-(310MM)	WG320305	WG320408	WG320 104	WG320207
15.35-(390MM)	WG320304	WG320409	WG320 105	WG320206
19.68-(500MM)	WG330302	WG330403	WG330 102	WG330202
25.59-(650MM)	WG350302	WG350402	WG350 102	WG350202
31.50-(800MM)	WG360302	WG360402	WG360 102	WG360202

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