

Technical data
NC automatic positioning and welding machines

	CSR 050	CSR 102	CSR 302
Product dimensions			
Length	1200 mm / 47.2"	2,000 mm / 78.75"	2,000 mm / 78.75"
Width	1200 mm / 47.2"	1200 mm / 47.2"	1200 mm / 47.2"
Height	40 mm / 1.57"	150 mm / 5.9"	400 mm / 15.75"
Alternative work area		According to customer specifications	According to customer specifications
Length	2,000 mm / 78.75"		
Width	1200 mm / 47.2"		
Welding capacity	125 kVA, AC 15 kA, 10% duty cycle DC or MF optional	100 kVA, AC 25 kA, 10% duty cycle MF optional	2 x 250 kVA, DC 45 kA, 10% duty cycle MF optional
Welding cylinder	2 pieces at 5.0 kN each	2 pieces at 5.0 kN each optional 3 pieces	3 pieces at 5.0 kN each optional 4 pieces
Welding force	10 kN	10 kN	15 kN
Proportional valves for setting of welding force	Optional	Standard	Standard
Rotatable electrodes	-	Optional: 0-360°	Rotating NC axes upper /lower 0-360°
Optional welding gun	-	X-version, C-version, choice between DC or MF 200 mm / 7.88" positioning stroke NC controlled Rotation range 0-360°	X-version, C-version, choice between DC or MF 200 mm / 7.88" positioning stroke NC controlled Rotation range 0-360°
Welding control	99 welding programs	128 welding programs	128 welding programs
Machine control	Sinumerik 810D/HT6 with integrated S7 teach-in-programming off-line acc. to DIN 66025 2 servo axes	Sinumerik 840D/HT6 with integrated S7 teach-in-programming off-line acc. to DIN 66025 8 servo axes	Sinumerik 840D/HT6 with integrated S7 teach-in-programming off-line acc. to DIN 66025 up to 8 servo axes
PC based control, incl. touch-screen and logging of operational data	Optional	Optional	Optional
Safety monitoring of air, water, voltage	Standard	Standard	Standard
Turntable: additional functions support for turning and pivoting	Optional	Standard	Standard