

DRAFT!!!

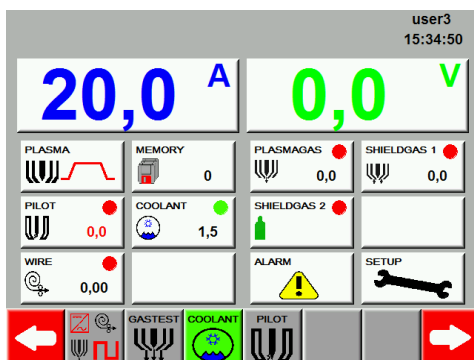


WELDING

SET PMI - 50 TL Automotive

User friendly micro and soft plasma equipment
for repair and maintenance (Item. no.: 1025923)

Intuitive Touch Screen



Plasma brazing

In the Plasma Brazing Prozess the restricted, transfered plasma arc is used to preheat the edges of thin sheets of materials up to brazing temperatures. Consumables with lower melting temperatures than the base materials allow the joining without melting the basematerial.

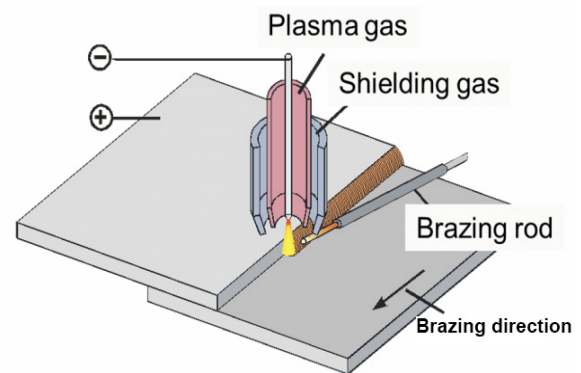
Due to the focused arc the brazing temperatures can be reached very fast and lead to high brazing speeds. This creates low heatinput into the workpiece and therefore very low distortion.

The main application for this prozess is the joining and repairing of zink galvanised sheets of material in Automotive.

Most common brazing consumables are CuSi alloys as well as other brass materials like CuAl, CuSiMn, CuSn,... .

Advantages compared to Mig or Tig - Brazing are:

- small seams
- low distortion
- separate input of thermal energy and brazing alloy
- no spatters
- less vaporizing of the zinc plating
- less consumables
- very economic joining with high speed



Micro Plasma

The electric arc in Micro Plasma welding is constricted by a copper nozzle with small bores, which causes a high power density. Due to the exact regulation of the welding current and the control of the plasma gas flow, the micro-plasma process, is the preferred choice for welding of films, sieves and thin-walled components as well as sharp adges.

The welding current starts from 0,5A only. Micro Plasma welding can be used for manual as well as automated applications.



Technical Specifications

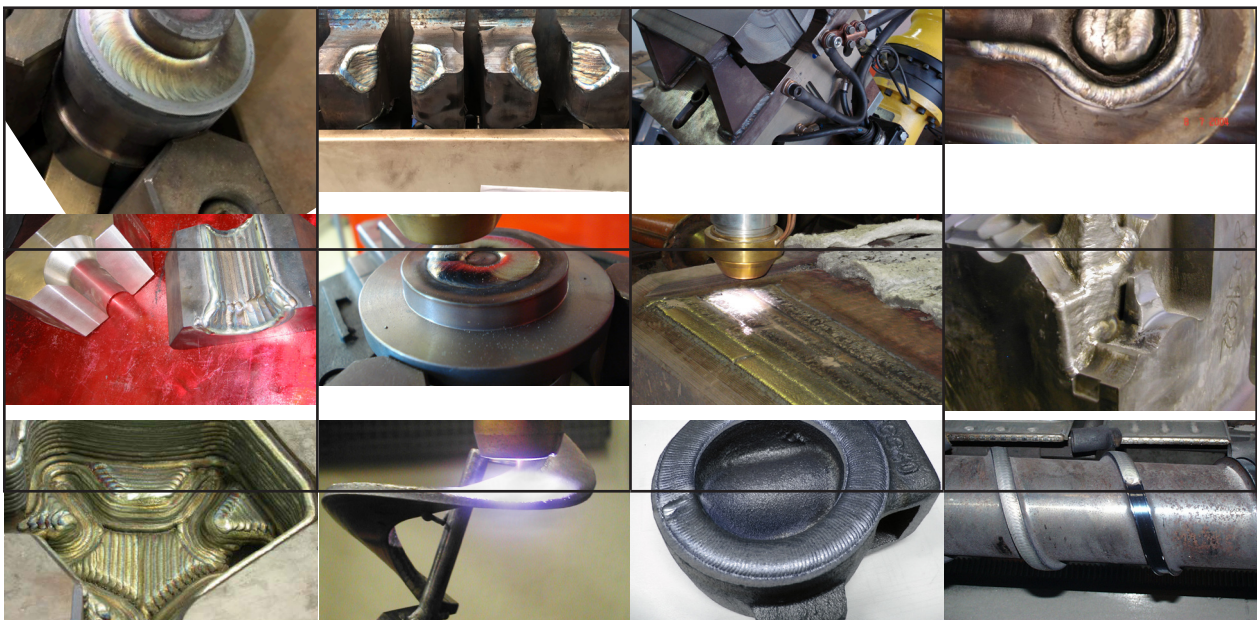
Specifications Set PMI - 50 TL Automotive

Mains voltage - Version ~3 Phase	3 x 400 V AC \pm 10% 50/60 Hz \pm 1% 4 x 32 A CEE plug
Mains voltage - Version single phase	230 V AC \pm 15% 50/60 Hz two-pin earthed plug
Torch connection	Quick connector
Welding current (35% duty-cycle)	50 A
Welding current (60% duty-cycle)	40 A
Welding current (100% duty-cycle)	30 A
Control range	0,5 ÷ 50 A
Control range pilot current	0,5 ÷ 50 A
Type of protection	IP 21 S
Electronic plasma gas control	0,2 ÷ 5,0 l/min
Manual shielding gas control	2,0 ÷ 25,0 l/min
Dimensions (LxWxH)	634x309x305 mm
Weight	approx. 47 kg



Technical changes and mistakes reserved

Applications



Equipment and Accessories

Trolley with torch holder

Item no.: 1025660 *1

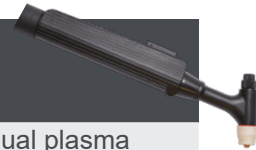
Trolley for PMI-50 TL with storage shelf and gas bottle fixing.
Torch holder for automatic pilot start.



TP50-M-70°, QC

Item no.: 1025657 (3m) *1

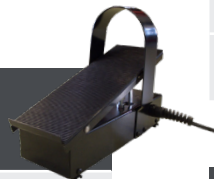
Type of torch	Manual plasma torch
Construction	Hand-held 70° torch
Max. current at 60% duty-cycle	50 A*
Cooling	Liquid
Hose pack length	3m/4m**
* with standard wear parts	
** optional hose pack length	



Foot control FP1

Item no.: 1017033

The remote control FP1 allows the operator easy adjustment of the current by foot pedal. The hands remain free.
Thereby a steady torch guidance without interruptions is provided.



Set wear parts TP50

Item no.: 1016898 *1

Set includes:
1x Box
2x Shield gas nozzle Ø11,0mm
3x Plasma nozzle Ø1,0mm
3x Plasma nozzle Ø1,2mm

*1 Included in the „Set PMI - 50 TL Automotive“

Tungsten Grinder

Item no.: 1006908

Sharpens electrodes precise and simple in longitudinal shape.
For Ø 1,0 ÷ 4,0 mm



Accessories

Böhler Guardian 62 Air complete

Item no.: 56997



Böhler Guardian 62

Item no.: 32373



Böhler Welding Gloves MIG/MAG Premium

Item no.: (M/9) 61137 / (L/10) 53095 / (XL/11) 60310



Consumables

For suitable powder products please refer to the high quality product range UTP PLASweld™ of voestalpine Böhler Welding UTP Maintenance GmbH
www.voestalpine.com/welding/de/Marken/UTP-Maintenance

