

AutoSPATZCX/CXi switch cabinet

The *AutoSPATZCX and CXi* welding system with one connection for medium-frequency transformer guns - or kick less cable guns connected to a medium-frequency transformer – represent, in conjunction with an *AutoSPATZM600L* inverter, a high-performance, flexible and cost-optimized tool which is especially suitable for manual applications. The primary areas of application are prototyping, pilot and niche production as well as repair stations in production lines.

A distance of about 15 - 20 meters (590.6 - 787.4 in) is permissible between the control cabinet and each welding gun. Depending on the used transformer a maximum welding current of approx. to 30 kA is, in conjunction with an *AutoSPATZM600L*, attained. This covers a very broad range of welding tasks at a sufficient duty factor.

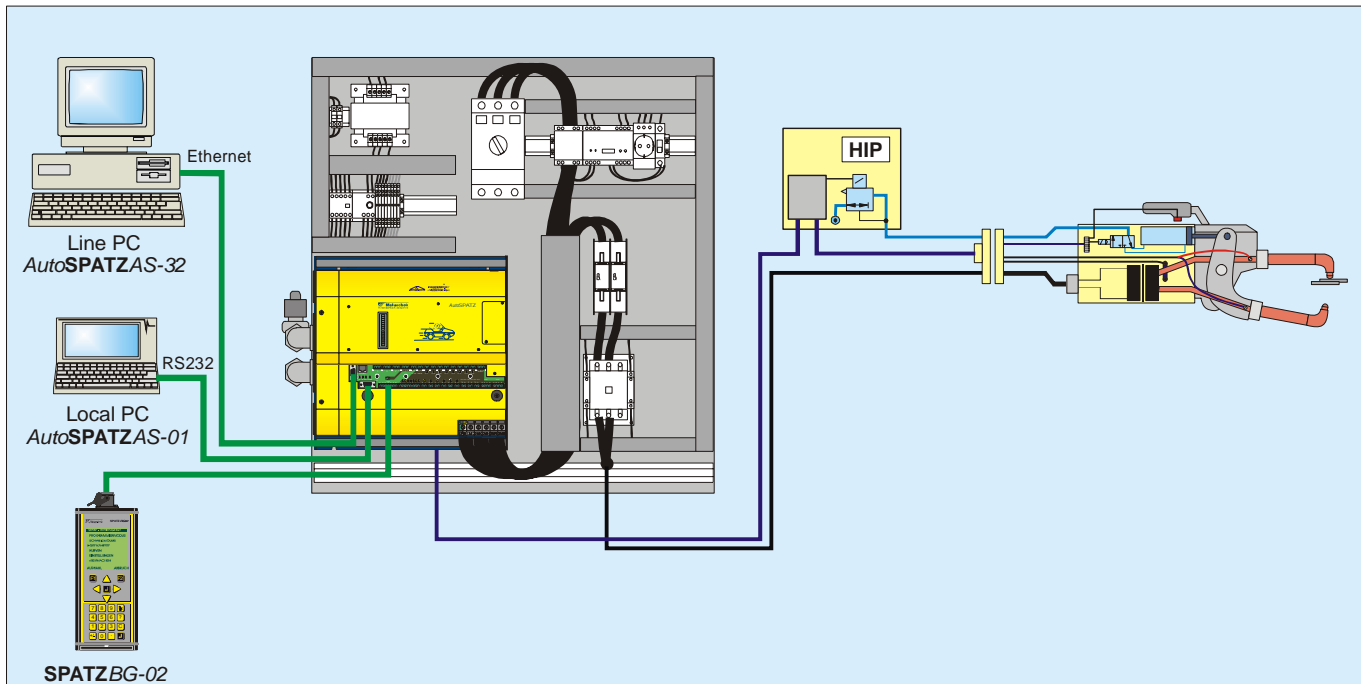
Programming and analysis of the welding process can be carried out via a **SPATZBG-02** operating device, via RS232 and *AutoSPATZAS-01* software on a laptop or via Ethernet and *AutoSPATZAS-32* software on a line PC. When welding programs are to be altered or new reference welds carried out for **MASTER** control, one of this units has to be connected to the control cabinet. The appropriate weld gun is selected and the desired changes are carried out. In conjunction with the **MASDAT** weld gun identification system and quick-changing devices, guns can be exchanged as often as necessary between the most diverse welding operations in the production process, without any need to network the welding controllers. This outstanding flexibility enables weld guns to be exchanged between different locations or factories without requiring any programming work on the respective welding timers.



The enclosure is equipped to house an *AutoSPATZM600L* mid-frequency power unit with integrated weld timer, isolation contactors for the gun and a residual current monitor with 30 mA trip current and a circuit breaker with shunt trip for the mains.

The cabinet door is equipped with the handle for the circuit breaker, the **SPATZBG-02** and RS232 connectors, a push button for Weld Stop and Error Reset, one button for Counter Reset, an indicator light for Power On and Error and one light for Electrode Life.





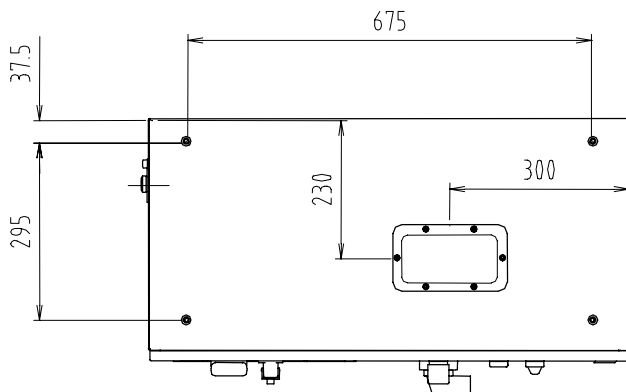
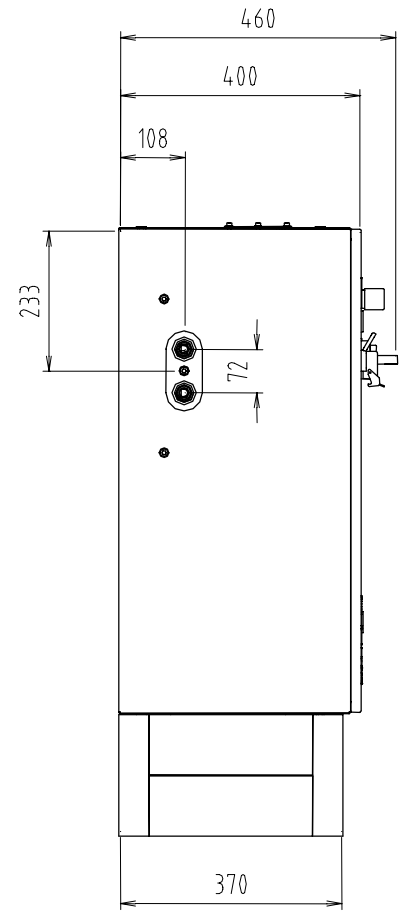
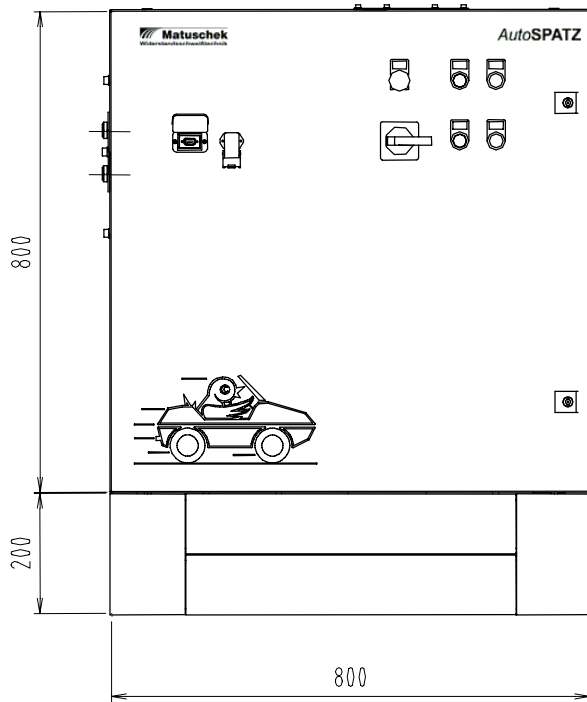
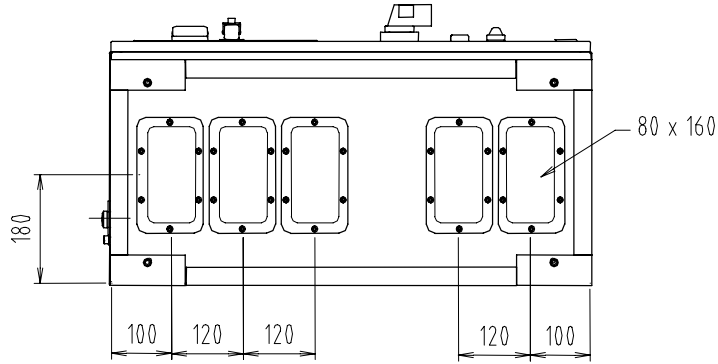
The cable with the electrical mains into the cabinet will be connected directly to the mains circuit breaker and the cable to the transformers directly to the isolation contactors. The control cables to the gun are connected to terminals. All cables go via cable glands in mounting plates into the cabinet. One mounting plate for cable glands is at the top, 5 mounting plates are at the bottom of the cabinet. The connectors for cooling water are on the left side wall of the cabinet.

The dimensions of the enclosure are (W x H x D) 800 x 800 x 400 mm (31.5 x 31.5 x 15.7 in). The additional enclosure socket is 200 mm (7.9 in) high. The enclosures are prepared to built one on top of another to save space on the floor. The result is a double cabinet with a total height of 2 m (78.7 in) with a socket in the middle and on the bottom for the cabling to the individual cabinet.

Technical Data in conjunction with the AutoSPATZM600L

Dimensions cabinet (W x H x D)	800 x 800 x 400 mm 31.5 x 31.5 x 15.7 in
Dimensions socket (W x H x D)	800 x 200 x 370 mm 31.5 x 7.9 x 14.6 in
Circuit breaker	80 A
Isolation contactor	75 A
Residual-current monitor	CXi 30 mA CX no
Water connectors	½" x 15 BSPT
Water consumption	2 l/min, temp. 20 °C - 25 °C 0.5 gal(US)/min, temp. 68 °F - 77 °F
Pressure drop	< 0,10 bar at 10 l/min < 1.45 PSI at 2.6 gal(US)/min
Mains voltage U ₁	3~400 V - 500 V, 50/60 Hz
Nominal power S _N	90 kVA, 50 % duty cycle, 400 V
Weld programs for each gun	63
Control modes	MASTER, CCC, CPC, CVC
Weld parameter monitoring	yes
Sensor supervision	yes
Force schedules	yes
Interfaces	SPATZBG-02, MASDAT, RS232, Profibus-DP, Ethernet
Signal inputs	voltage, current, force, penetration
Output for proportional valve	0 - 10 V DC





AutoSPATZCX and CXi

