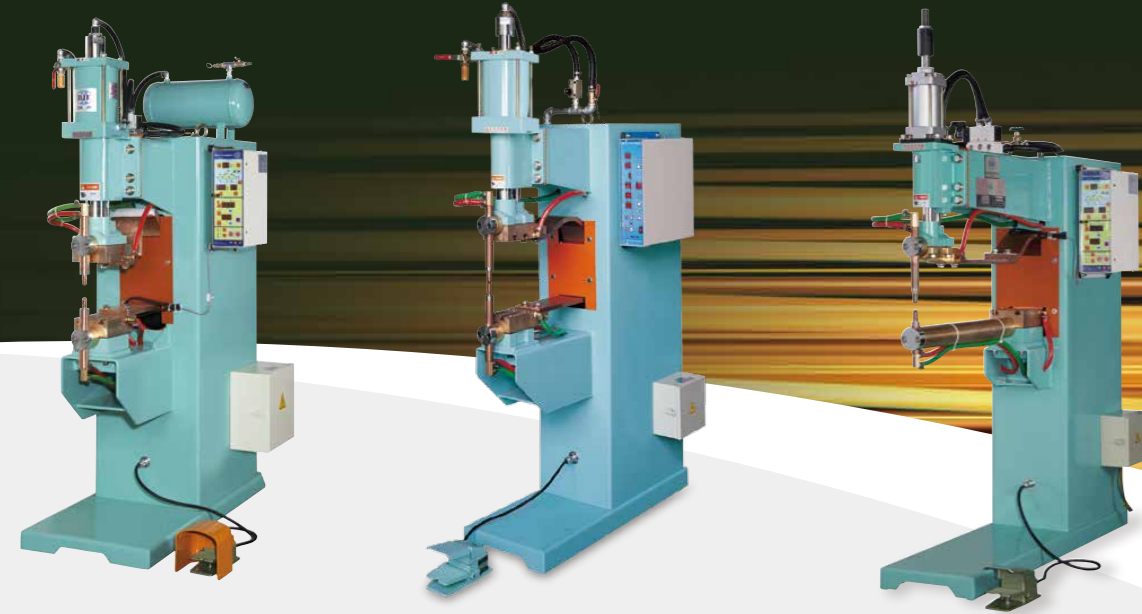
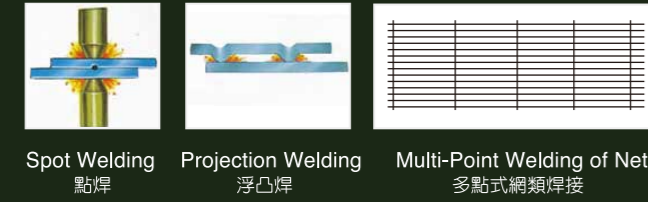


# Micro-computer Precision Control Resistance Welding Machine

## 微電腦精密控制式電阻熔接機

Full series of precise microcomputer control circuit, Control device using microcomputer control precision, No changes of welding terms, if any changes in power supply  
 全系列微電腦精密控制回路，控制裝置採用微電腦控制精確，無懼於電源條件變動



### SPECIFICATION 規格表

Models types 型式機種	Rated capacity 定格容量	Rated primary voltage 定格一次電壓	Rated frequency 定格頻率	Maximum force 最大入力	Maximum short-circuit current 最大短路電流	Maximum pressure force 最大加壓力	Permit usage 容許使用率	Deep throat 喉深
	KVA	V	HZ	KVA	A	Kg/cm <sup>2</sup>	%	mm
DJ-A350	35	220 / 440	50 / 60	98	16,000	560	6.37	400
DJ-A500	50	220 / 440	50 / 60	135	18,500	560	6.85	400
DJ-A600	60	220 / 440	50 / 60	146	20,000	580	8.44	400
DJ-A800	80	220 / 440	50 / 60	225	25,000	770	6.32	450
DJ-A1000	100	220 / 440	50 / 60	285	30,000	770	6.16	450
DJ-A1200	120	220 / 440	50 / 60	318	35,000	770	7.11	450
DJ-A1500	150	220 / 440	50 / 60	462	42,000	1,000	6.37	450
DJ-A2000	200	220 / 440	50 / 60	576	48,000	1,000	7.87	450
DJ-A2500	250	220 / 440	50 / 60	583	53,000	1,500	9.19	400
DJ-A3000	300	220 / 440	50 / 60	816	60,000	1,900	6.75	400

■ Can design & make according to local voltage requirement (200V-600V) 可依使用者當地電壓需要設計製造  
 ■ Big Capacity Model Could be Equipped With 3 Phase Inverter Control System. 大容量機型可接受三相變頻控制系統設計製造

### PRODUCT SERIES 系列產品

Air Pressure Automatic Spot Welding Machine  
 自動空壓點焊機

Air Hydraulic Flash Butt Welding Machine  
 自動空油壓閃焊機

Air Hydraulic Pressure Automatic Seam Welder  
 自動空油壓輪焊機

Condenser Welding Machine  
 電容儲能電阻點焊機

Electrical Heating Upsetter  
 電氣加熱擠壓鍛縮機

Inverter Control System  
 變頻控制系統

Fully-Automatic Coil Winding Machine  
 數控式自動捲圓機

Multi-Point Wire Mesh Welding Machine  
 多點式網類焊接機

Manufacturing & Designing for Various CO<sup>2</sup> & TIG Welding Machine Automation  
 各式自動化CO<sup>2</sup>、氬焊、燒焊機自動化設計製造

To Manufacture and Design of Full Set of Plant Equipments for Various Relative Products.  
 各種相關產品生產設備整廠設計製造

We accept special-specified order, and OEM/ODM supply.  
 本公司接受各種特殊規格設計製作及OEM/ODM生產



## DA JIE ELECTRICITY MACHINERY INDUSTRIAL CO., LTD. 大佳機電股份有限公司

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# Micro-computer Precision Control Resistance Welding Machine



## 微電腦精密控制式 電阻熔接機



Application Of High Tensile Steel  
 高張力鋼板適用

# Multi-function Spot Welder Controller

## 多功能點焊機控制器



DJ-A-30

### DJ-A-30

**Micro-computer high function welding controller:**  
 ● 30 conditions program memories, three sections of power.  
 ● Enhanced counting function.  
 ● Directly increase or decrease the value keys, welding current is automatically compensated.  
 ● Transformer output current is available in strong / weak settings.

### 微電腦精密高功能控制器

● 30條件記憶，三段通電。  
 ● 增加計數功能。  
 ● 直接增減數值按鍵，溶接電流可自動補償。  
 ● 變壓器輸出的電流大小可正確任意設定。



KD-1060  
 Japan NWT

### Employing pushbutton digital switch and all series with micro circuit control.

1. Quick answering operation, correct activation, shock resistant, low trouble rate.
2. Prevention against interferences such as foreign signal, electric shock, voltage and high frequency. Errorless & Reliable.

### 採用按鍵式數字開關及全系列採用微處理器控制

- 應答速度快、動作正確、耐震、故障率低。
- 對雜訊、電擊、電壓及高週波之干擾均裝有預防設施，無誤動作，安心使用。

### With autotmatic current circuit maintenance.

During the current connection, even the pedal switch is "OFF", it will maintain the power connection and voltage increase, according to preset time lengths until the final process, to prevent inferior welding.

### 具有自動保持通電回電路

焊接通電中途時，即使足踏開關OFF時，仍能保持通電及加壓，依設定時間動作至最後，以預防焊接不良。

### With power and voltage fluctuation compen-sation circuits.

During welding, for voltage and power within ±20%, the voltage and current fluctuate compensation circuit will activate prompt answering in one cycle and restore to the preset welding requirement, therefore obtaining welding effects with consistent quality. (For current adjustment scale higher than 80, the compensation range is narrowed.)

### 具有電源電壓變動補償回路

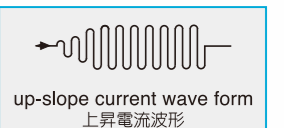
焊接時，如電源電壓±20%以內時，依靠電源電壓變動補償回路在1週波內快速應答，回復所設定之焊接條件，因此能獲得均一品質的焊接效果。電流調整刻度80以上時其補償範圍便狹小。

### Equiped with up-slope control for adjustment of preliminary welding current wave forms.

Adjust the up-slope control (0-9Hz) to gradually increase the welding current, avoid protruding current, avoid coarse welding surface, improve welding quality, especially to the welding of various galvanized sheet steel.

### 具備可調整初期焊接電流波形的控制功能

調整波頭控制(0-9HZ)可使焊接電流漸次增強，防止突入電流，避免焊接表面粗糙，提高焊接品質尤其對各種電鍍鋼板之焊接，更能發揮威力。



up-slope current wave form  
 上昇電流波形



DJ-MU1



DJ-MU2



DJ-MU3

### DJ-MU1~3功能

- DJ-MU1 Standard control box  
標準控制箱
- DJ-MU2 9 circuits electric connection control box  
九回通電控制箱
- DJ-MU3 15 conditions settable control box  
可設定15條件控制箱

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# Component Instruction

Micro-computer Precision Control Resistance Welding Machine

## 機體結構說明

### Two stage stroke switch

Design for two stages cylinder stroke, Upper electrode can be adjusted for higher and lower distance.  
And, it is Suitable for large work-piece production.

### 二段行程切換

二段行程氣缸設計，上座電極可調整高低，適用大型工件生產。

### High-Performance air compression components(Air F.R.L units)

Explosion-resistant casing is fitted on the outside of the filter and oil feeder to prevent broken, and to protect it from out-side impact.  
The filter and oil feeder cup can be dismounted to facilitate cleaning and maintenance.

### 使用簡單安全性高之高性能空壓壓縮組件

在過濾及給油器之外部加裝防爆殼，可預防油杯破裂時破片飛散，亦可保護從外部所受碰撞的衝擊，油水杯子能一起拆下，易於清洗保養，降壓後，自動排水。

### The accuracy for vertical and horizontal fixed position of upper and lower electrodes

The machine head portion's vertical and horizontal fixed position of upper and lower electrodes' accuracy is one piece formed by CNC milling machine.

### 上下電極垂直水平定點準確性

機台頭部上座與下部電極座的平面垂直與水平，由CNC龍門銑床一體成形，能保持上下座垂直定點準確性。

### The cooling tubing employs 3/8" bronze tube compulsory cooling cycle circuits

All cooling water pipes of the transformer, SCR and electrodes will have excellent cooling efficiency, with additional temperature rise automatic cut-off switch to completely avoid burning the transformer, SCR in case the water supply is interrupted.

### 冷卻管路採用3/8"的銅管強制冷卻循環回路

使變壓器，主回路開關，電極之各冷卻管路，能獲得高冷卻效果，並附有溫升自動切斷開關，以完全避免停水時變壓器，SCR燒毀之虞。

### High conductivity secondary re-circuits

Secondary side-welding recircuits made by bronze, low resistance and well-conductivity.

### 高導電性二次回路

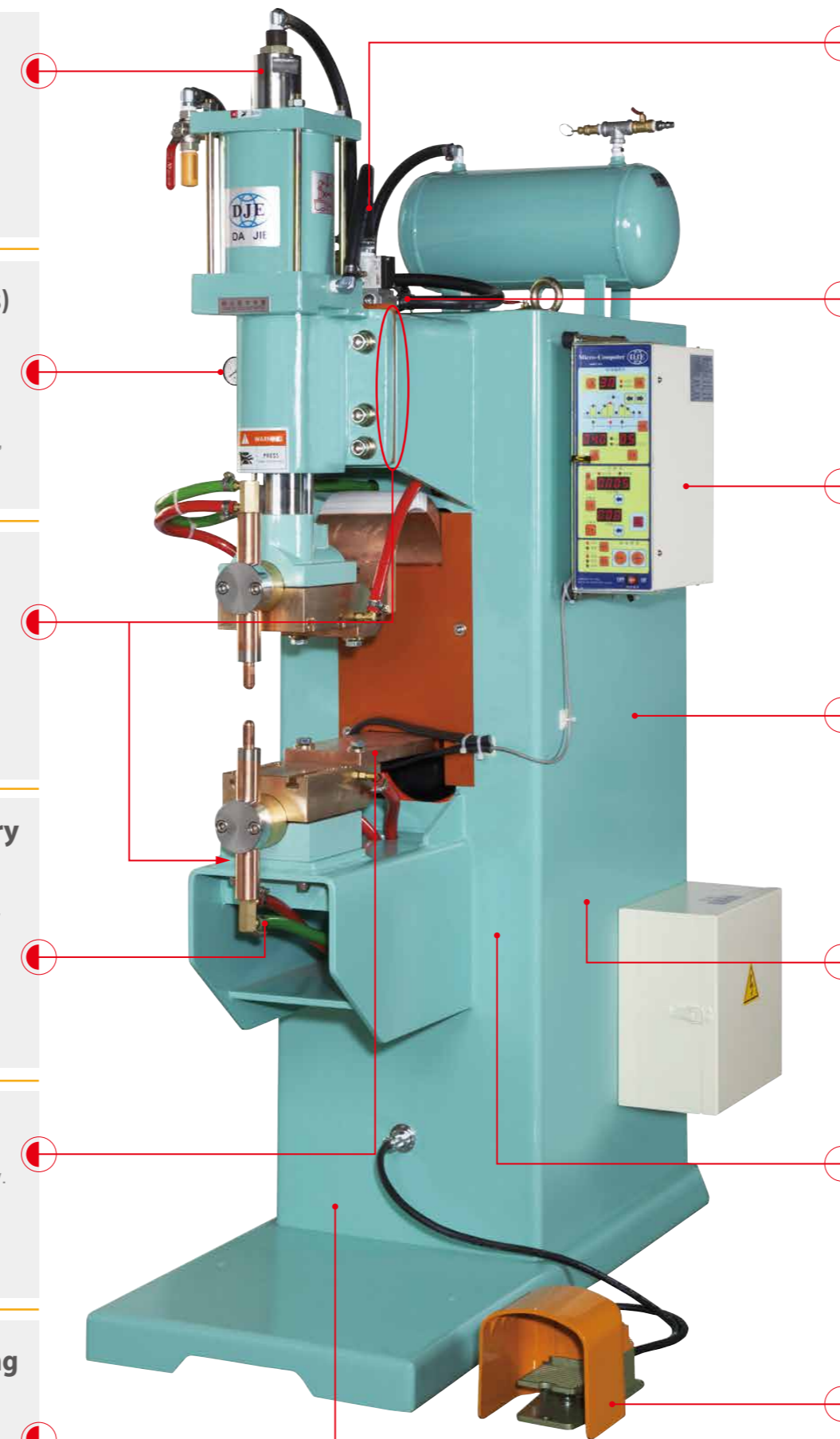
二次側溶接電流回路，採用延壓銅製成，密度高、電阻低、導電性良好。

### Both interior and exterior of machine are treated with coating

Coated with powder baked paint after acid pickling to extend the lifespan.

### 機體內外皆經皮膜處理

酸洗後經粉體塗裝烤漆處理，使用壽命長。



### An optional press adjuster is provided for upward and downward adjustment

To respectively adjust the rising or lowering speed and impact during the pressurizing progress, to obtain excellent welding quality and speed.

### 具備任意調整加壓速度之上下個別調整器

可分別調整加壓進行時，單獨上升或下降的速度及衝擊力，藉以達到最良好的焊接品質和速度。

### Central air exhaust method to improve working environment

Concentrated exhausting system will not only reduce the exhaust noise, but also reduce oil mist spraying, to maintain clean working environment.(Fitted with exhaust outlet to exhaust air to outdoors.)

### 改善作業環境的集中排氣方式

集中排氣的設計方式，不僅降低排氣音量，更可減少油霧飛散，保持潔淨的作業環境。(另裝有將排氣口裝置屋外的排氣口)

### All series with micro-computer precision control circuit

Micro-computer control device: precision control, no effected by unstable power supply condition.

### 全系列微電腦精密控制回路

控制裝置採用微電腦控制，控制精確，無懼於電源條件變動。



### Transformer of excellent current conductivity and of minimum electric loss

Secondary circuit with high conductivity, a low input will produce output with powerful current with minimum power loss and low facility cost.

### 導磁、導電性良好，電力損失少的變壓器

使用E鐵蕊，導磁效果佳，磁通路線力低、密合度高體積縮小得以縮減一、二次側回路長度，低入力即可輸出強大電流。

### Welding current circuits with adoption of SCR no-contact-point switch

Main circuit switch employs no-contact-point SCR to increase high welding reliability and avoid accident caused by poor connection and save maintenance and repair expense. Even under rigorous conditions, it will still assure stable welding current to obtain consistent and steady welding strength.

### 一次側主電流回路，採用S.C.R無接觸點開關

主電流回路採用S.C.R無接觸點開關，以增強焊接之堅固性，避免接觸不良，而發生之意外並節省維修費用，即使最不良環境的情況下，仍能使焊接電流穩定通路，而獲致良好的焊接功能。

### Sold frame structure

Sturdy body construction, excellent adaptability, reducing the electrode deviation during process, increase the welding quality, and reduce the shock and impact noise of the machine body.

### 堅韌穩固的機體結構

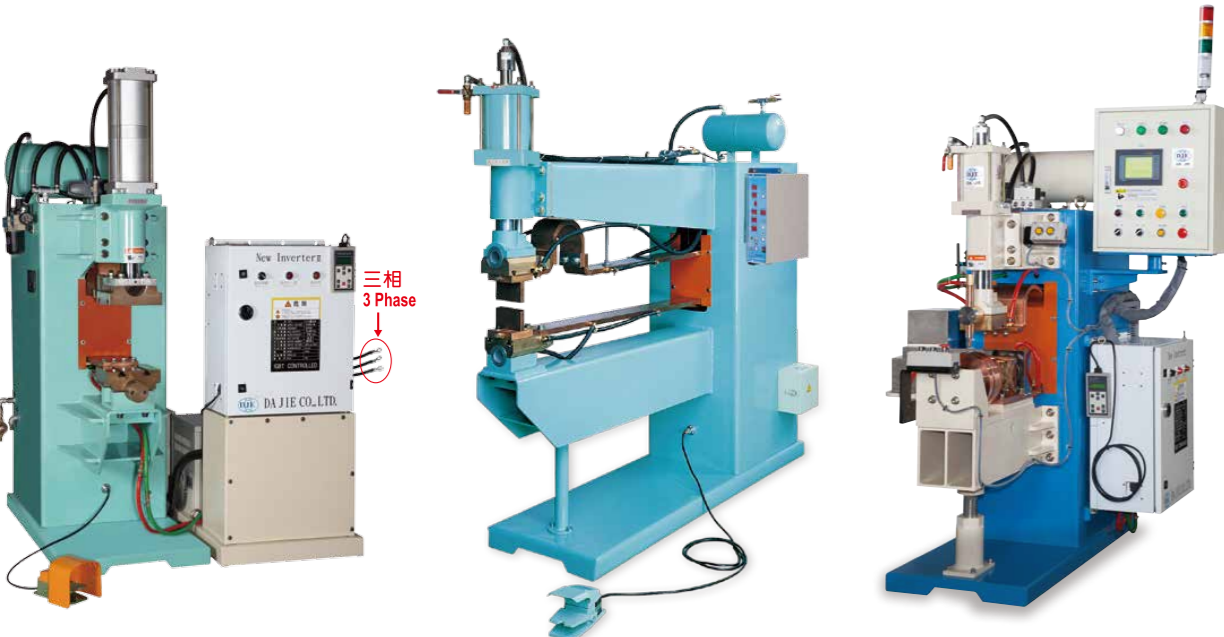
強固的機體結構，良好的適應性，減低加壓進行時電極頭的偏差，提高焊接品質，使機體的震動及衝擊聲音降至最低。

### Safe and reliable pedal switch

Sturdy and safe pedal switch with quick starting and easy installation starting voltage DC 12V which can be used safely.

### 安全穩固的足踏開關

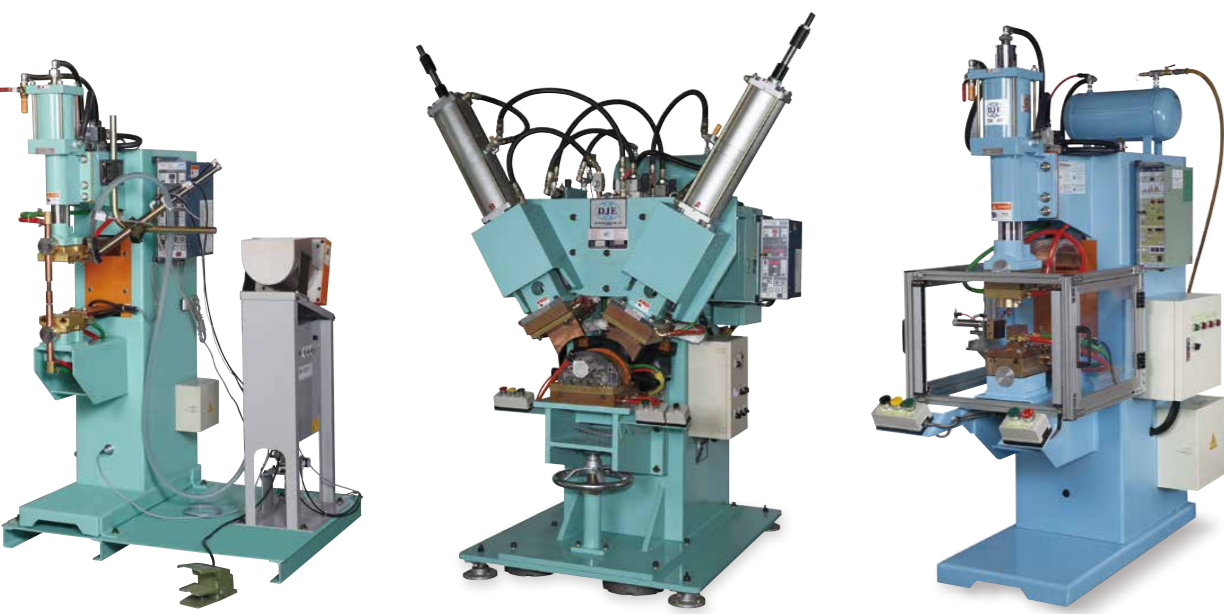
堅固安全的足踏開關，啟動輕巧，安裝容易，啟動電壓DC12V可安心使用。



**Inverter projection welding machine**  
(European, American and Japanese manufacturers are using)  
變頻溶焊機 (歐、美、日大廠皆使用)

**Automobile parts and special shape workpiece clamping welding machine**  
汽車部品及異型夾持工件焊機

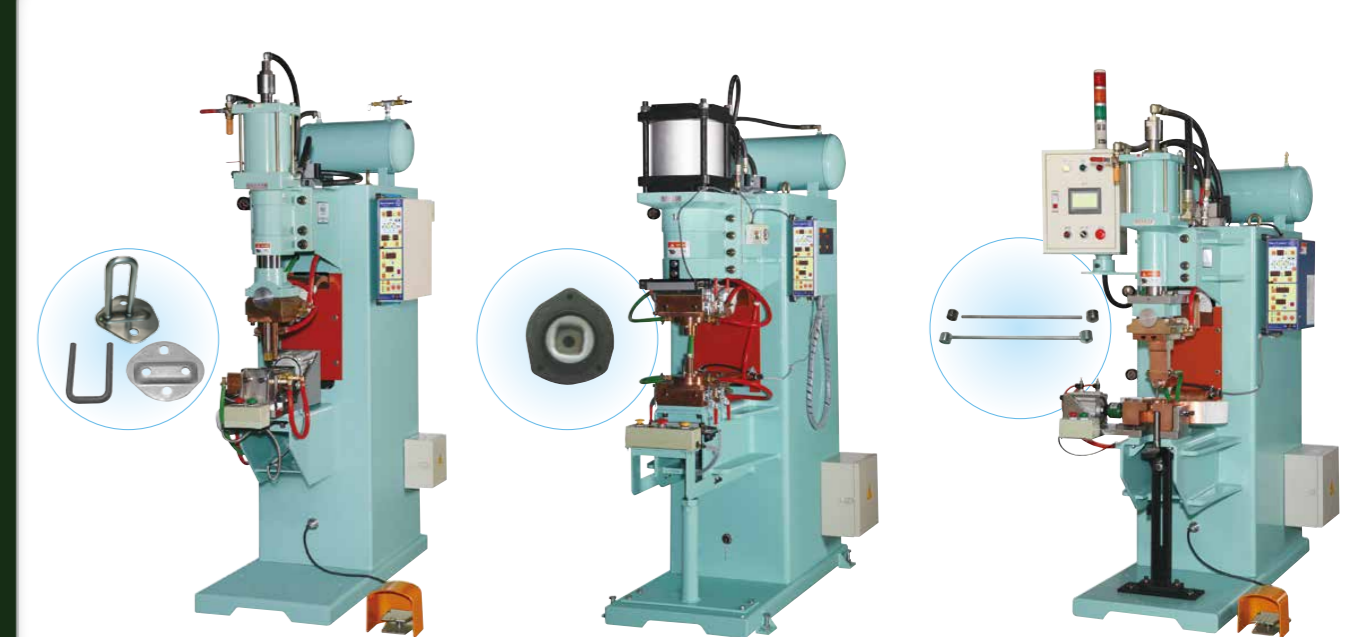
**Semi-automatic projection welding machine (Three-phase inverter type)**  
半自動式浮凸焊機 (三相變頻式)



**Automatic Feeding Nut Welder**  
(Used by Japanese vehicle manufacturing line)  
螺母自動送料焊機 (日本汽車廠全自動生產線上連線專用)

**Semi-automatic brake pads projection welding machine**  
半自動式煞車來令片浮凸焊機

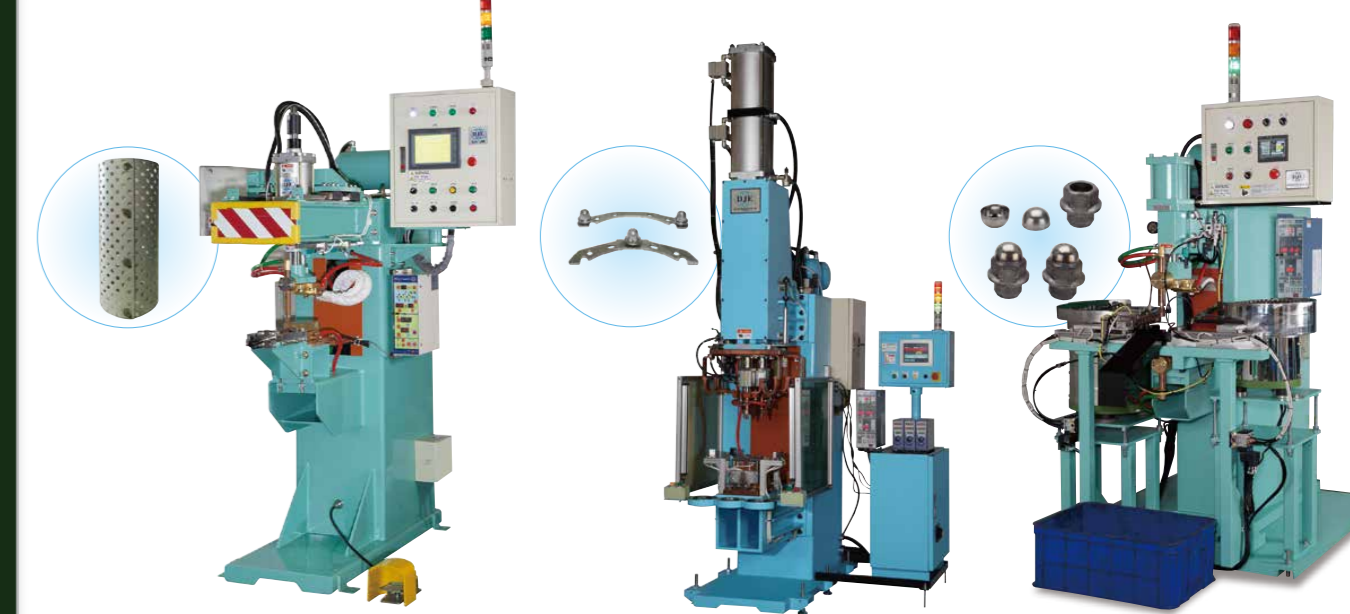
**Spot-Projection welding machine**  
自動空壓浮凸焊專用機



**Automobile door catches forming machine**  
汽車門扣加熱成型機

**Automobile shock absorber projection welding machine**  
汽車防震器浮凸焊機

**Automobile balance bar projection welding machine**  
汽車平衡桿浮凸焊機



**Pneumatic spot welder (table Use servo Motor movement)**  
空壓伺服式點焊機

**Refrigeration compressor components projection welding machine**  
冷凍壓縮機元件浮凸焊機

**Cap Nut Automatic Feeding Welding Machine**  
戴帽螺母自動送料焊機