

'PRESSTOTEST' Analogue Force Gauge



The production of a satisfactory resistance weld is dependent upon four variables – I) the surface condition of the metal being welded, II) the current setting of the welding machine, III) the duration of the welding cycle and IV) the pressure developed between the welding electrodes.

The surface condition of the metal can be controlled by suitable preparation prior to welding. Most resistance welding machines are fitted with current or heat controls and suitable time controls. Apart from pneumatically operated welders, no machines are fitted with any recording unit to measure the pressure between the electrodes. The 'PRESSTOTEST' Recorder has been designed and developed to measure this pressure.

This small tool is held in one hand between the tips of the welder, resting on the bottom tip. The center of the plunger should be underneath the top tip. When the tips are brought together by means of the foot pedal on the machine the pressure developed will be shown on the Recorder dial-in kilos.

The latest model 'PRESSTOTEST' now has insulation over the whole of the back of the load cell. This should prevent damage to the instrument in the event of it being used with the welding current

	Sheet Thickness	Tip Diameter	Electrode Pressure
Recommended Welding Pressure:	Up to 0.6 mm	3.2 mm	55 to 60 Kgs
	0.6 mm to 1.5 mm	4.8 mm	120 to 130 Kgs
	1.5 mm to 2.0 mm	6.4 mm	220 to 230 Kgs
	2.0 mm to 3.0 mm	8.0 mm	350 to 360 Kgs
	3.0 mm to 4.0 mm	9.5 mm	500 to 520 Kgs

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